C62557B

MODEL 700™ M24

Model SWS™

Action

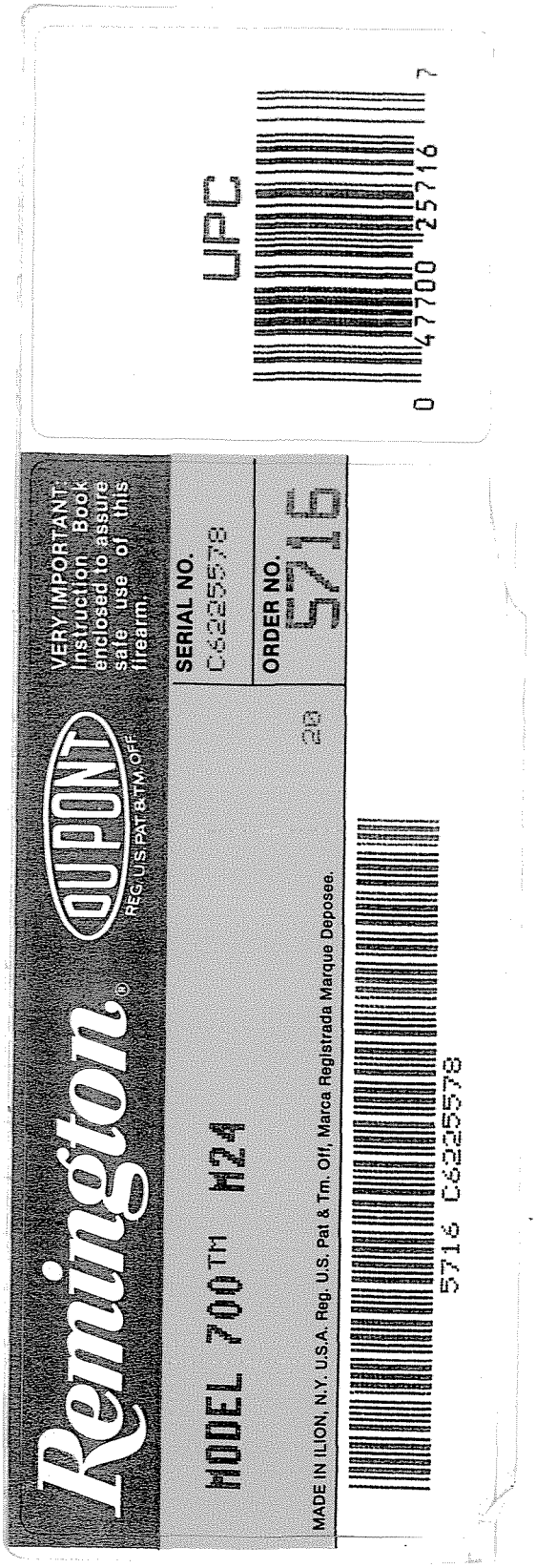
Barrel Length

Capacity

Order No. 57116

*Includes 1 in chamber.

Remington®


UPC
0 47700 25716 7
VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.
Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
MODEL 700TM M24
SERIAL NO.
C6225578
ORDER NO.
5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.
5716 C6225578

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225578

| OP. # | OP. NAME | READINGS | DATE | INIT |
|---|---|---|---|---|
| 575 & 580 | Assemble Action and Stock | 12 9 88 | | RW |
| 600 | Proof | 12 9 88 | | RW |
| 607 | Check Headspace | 12 9 88 | | RW |
| 610 | Dis-assemble Gun | 12 9 88 | | RW |
| 612 | Magnaflux Barrel Action | | 12 22 88 | pfc. |
| | Magnaflux Bolt | | 1-3-89 | pfc. |
| 615 | Rollmark Caliber | | 12/22/88 | WBC |
| 617 | Drill and Tap Sight Holes | 113389 | | FB |
| 618 | Polish Barrel | 12 2 88 | | WJT |
| 620 | Apply Coatings (Barrel Action) | | 1/6/89 | TSH |
| | Apply Coating (Bolt) | | | |
| 625 | Final Assembly A) Clean inside of Bolt Assembly | | 2/2/89 | RW |
| | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head | | 2/2/89 | RW |
| | C) Inspect Ejector Hole for Chamfer | | 2/2/89 | RW |
| | D) Oil Firing Pin Ass'y | | 2/2/89 | RW |
| | E) Adjust Trigger Pull to Min Setting and Stake | | 2/2/89 | RW |

| op. # | OP. NAME | READINGS | | | | | DATE | INIT |
|---|---|---|---|---|---|---|---|---|
| 625 cont. | F) Safety On Force | 5 | 5 | 5 | | | 3 Feb 89 | [illegible] |
| | G) Safety Off Force | 3 | 3 | 3 | | | 3 Feb 89 | [illegible] |
| | H) Trigger Pull Test & Retainability | | | | | | 2 Feb 89 | [illegible] |
| | I) Firing Pin Indent | .021 | .021 | .021 | | | 3 Feb 89 | [illegible] |
| | J) Assemble Stock | | | | | | 2/9/89 | RW |
| | K) Assemble Swivel Studs | | | | | | 6 Mar 89 | [illegible] |
| | L) Attach Front and Rear Sight Assemblies | | | | | | 2/9/89 | RW |
| | M) Iron Sight Alignment | | | | | | 2/9/89 | RW |
| | N) Detach Front & Rear Sights & place in numbered container | | | | | | 2/9/89 | RW |
| | O) Attach Scope to Rifle | | | | | | 10 Feb 89 | [illegible] |
| | P) Detach & Attach Scope 20 Times | | | | | | 10 Feb 89 | [illegible] |
| 640 | Gallery Target & Test | GCR | 85L | | | | 2/14/89 | [illegible] |
| | A) Time | | | | | | " | [illegible] |
| | B) Malfunctions | | | | | | " | |
| | C) Pierced Primers | | | NONE | | | " | [illegible] |
| | D) Optical Clearity of Scope | | | OK | | | 2/14/89 | [illegible] |
| 645 | Inspect for Live Ammo | | | NONE | | | 2/14/89 | [illegible] |
| 655 | Final Inspection A) Headspace | | | | | | 6 Mar 89 | [illegible] |
| | B) Trigger Pull | 2.58 | 2.59 | 2.52 | 2.53 | 2.51 | 6 Mar 89 | [illegible] |
| | C) Function | | | | | | 6 Mar 89 | [illegible] |
| 660 | Pack | | | | | | 3/22 | [illegible] |

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

SERIAL NO. 4622537
DATE 4-6-90
TESTER DH

| | 2.50# INITIAL | 2.50# AFTER 50 CYCLES | FINAL TEST & TO RESET 2.50# | | COMMENTS |
|---|---|---|---|---|---|
| PULL #1 | 2.34 | 2.44 | 2.52 | | MIN. SETTING, |
| PULL #2 | 2.29 | 2.31 | 2.50 | | NO AVG. OF 5 |
| PULL #3 | 2.33 | 2.39 | 2.51 | | READINGS ACCEPT- |
| PULL #4 | 2.25 | 2.27 | 2.50 | | ABLE LESS THAN 2# |
| PULL #5 | 2.23 | 2.31 | 2.50 | | |
| TOTAL | 11.44 | 11.72 | 12.53 | | |
| AVG. | 2.28 | 2.34 | 2.51 | | |

| | 3.00# INITIAL | 3.00# AFTER 20 CYCLES | | COMMENTS |
|---|---|---|---|---|
| PULL #1 | 3.38 | 3.39 | | |
| PULL #2 | 3.28 | 3.19 | | |
| PULL #3 | 3.19 | 3.12 | | |
| PULL #4 | 3.15 | 3.18 | | |
| PULL #5 | 3.19 | 3.09 | | |
| TOTAL | 16.09 | 15.87 | | |
| AVG. | 3.21 | 3.17 | | |

| | 4.00# INITIAL | 4.00# AFTER 20 CYCLES | MAX SETTING GREATER THAN 4# | RESET TO 4# FOR TARGET & ACCURACY |
|---|---|---|---|---|
| PULL #1 | 4.18 | 4.28 | | |
| PULL #2 | 4.28 | 4.28 | | |
| PULL #3 | 4.30 | 4.34 | | |
| PULL #4 | 4.33 | 4.09 | | |
| PULL #5 | 4.30 | 4.00 | | |
| TOTAL | 21.39 | 20.99 | | |
| AVG. | 4.27 | 4.19 | | |

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225578
17 Feb 1989

CENTROIDAL DISTANCES

| | | | |
|---|---|---|---|
| 0 | TO | 1 | .59895 |
| 1 | TO | 2 | .0570789 |
| 1 | TO | 3 | .40321 |
| 1 | TO | 4 | .280845 |
| 1 | TO | 5 | .688796 |

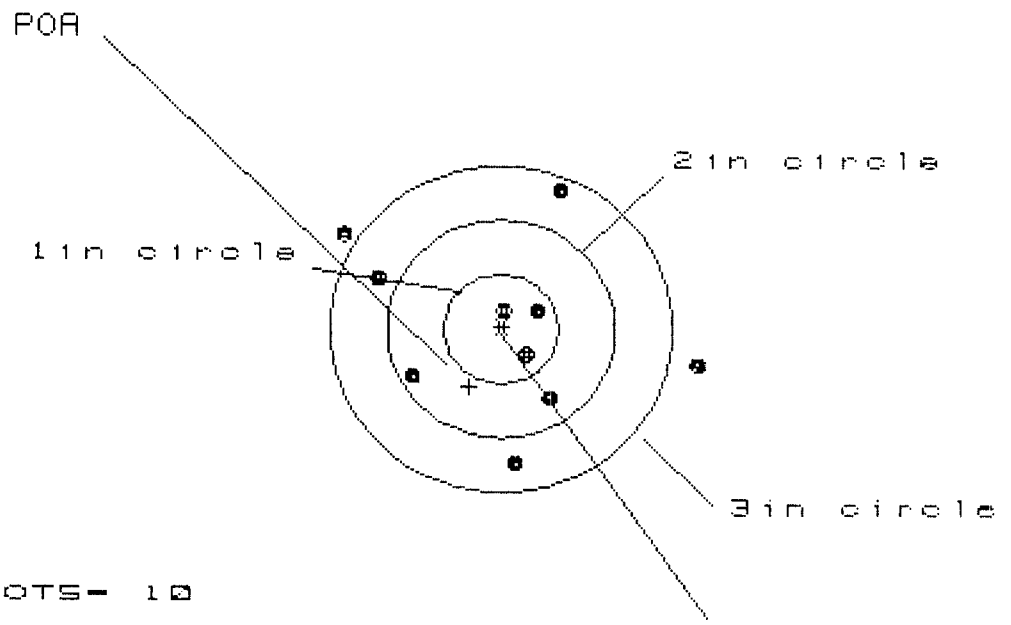
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2832
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2738
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .393915

THE AMR FOR THIS RIFLE IS: .903

17 Feb 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C6225578

CENTERFIRE PATTERNS # 1




# OF SHOTS= 10

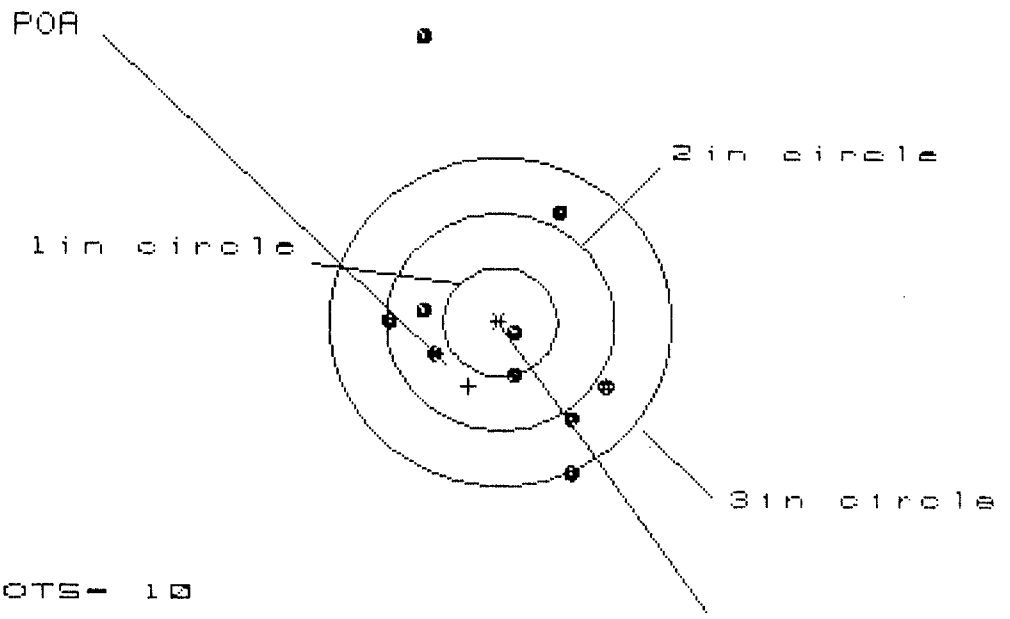
# IN CIR
1in = 3
2in = 5
3in = 8

HS= 3.098
VS= 2.446
GS= 3.344

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 1 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.729 | .669 | .522 |
| MINIMUM X | : | -1.369 | -1.177 | -1.019 |
| MAXIMUM Y | : | 1.223 | 1.180 | 1.285 |
| MINIMUM Y | : | -1.223 | -1.266 | -1.161 |
| CENTROID X | : | .279 | .087 | .234 |
| CENTROID Y | : | .530 | .573 | .468 |
| POA TO CENTROID in. | : | .599 | .579 | .523 |
| MIN RADIUS | : | .147 | .216 | .213 |
| MEAN RADIUS | : | .952 | .879 | .770 |
| MAX RADIUS | : | 1.771 | 1.444 | 1.387 |
| HORIZONTAL SPREAD | : | 3.098 | 1.846 | 1.541 |
| VERTICAL SPREAD | : | 2.446 | 2.446 | 2.446 |
| EXTREME SPREAD | : | 3.344 | 2.592 | 2.468 |
| NUMBER IN ONE INCH CIRCLE | = | | 3 | |
| NUMBER IN TWO INCH CIRCLE | = | | 5 | |
| NUMBER IN THREE INCH CIRCLE | = | | 8 | |

17 Feb 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C6225578

CENTERFIRE PATTERNS # 2



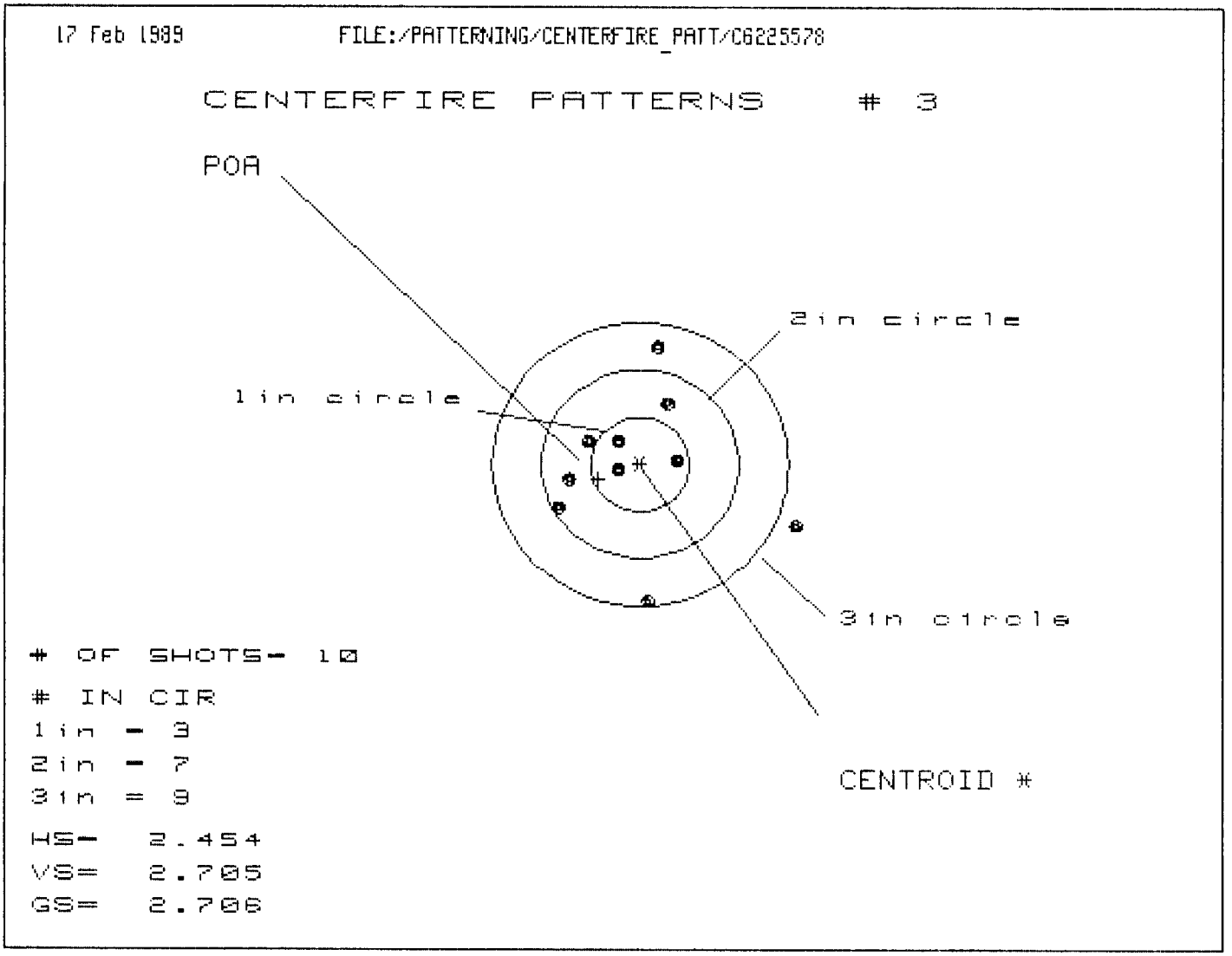

# OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 8

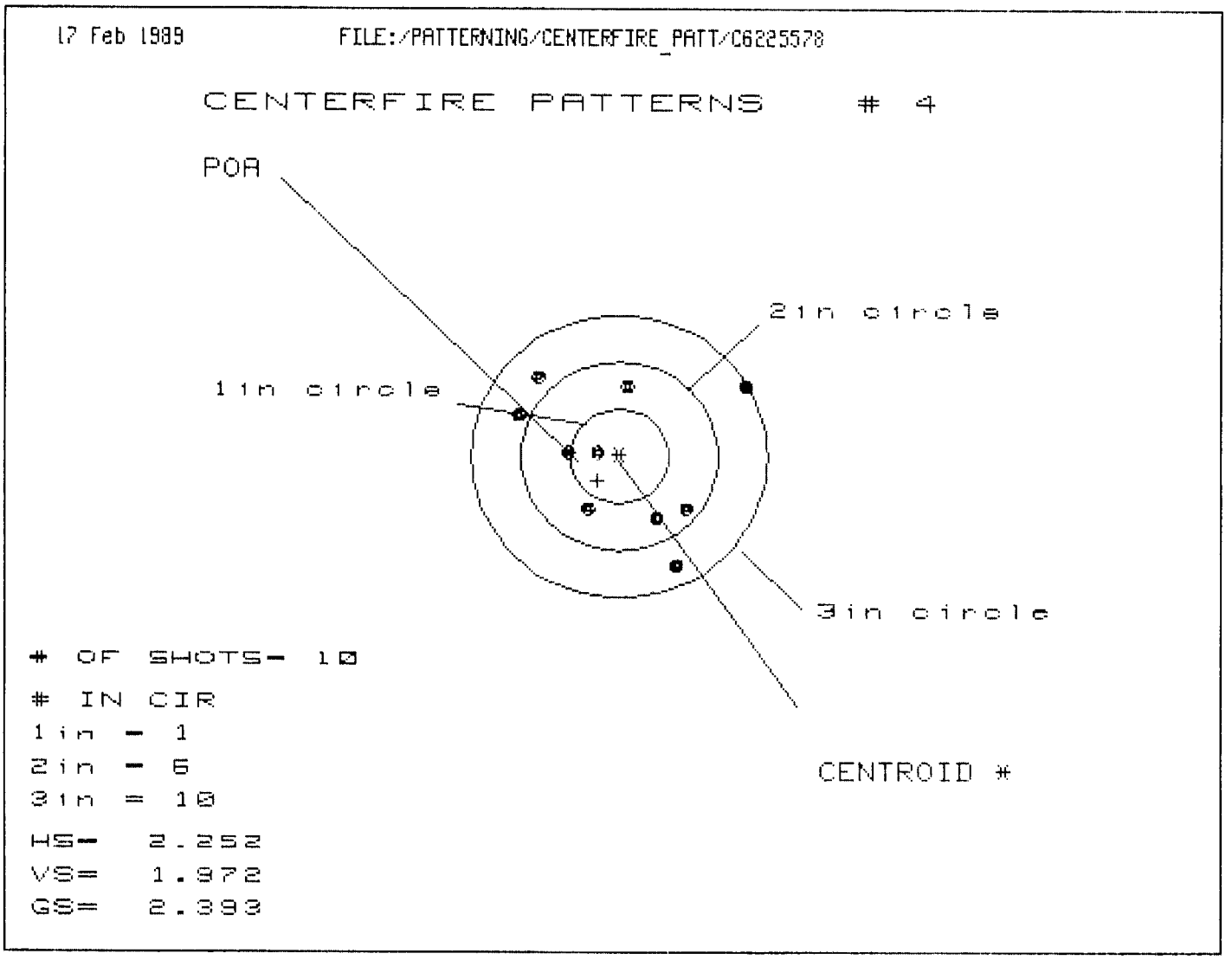
HS= 1.879
VS= 3.990
GS= 4.196

PATTERN # : 2

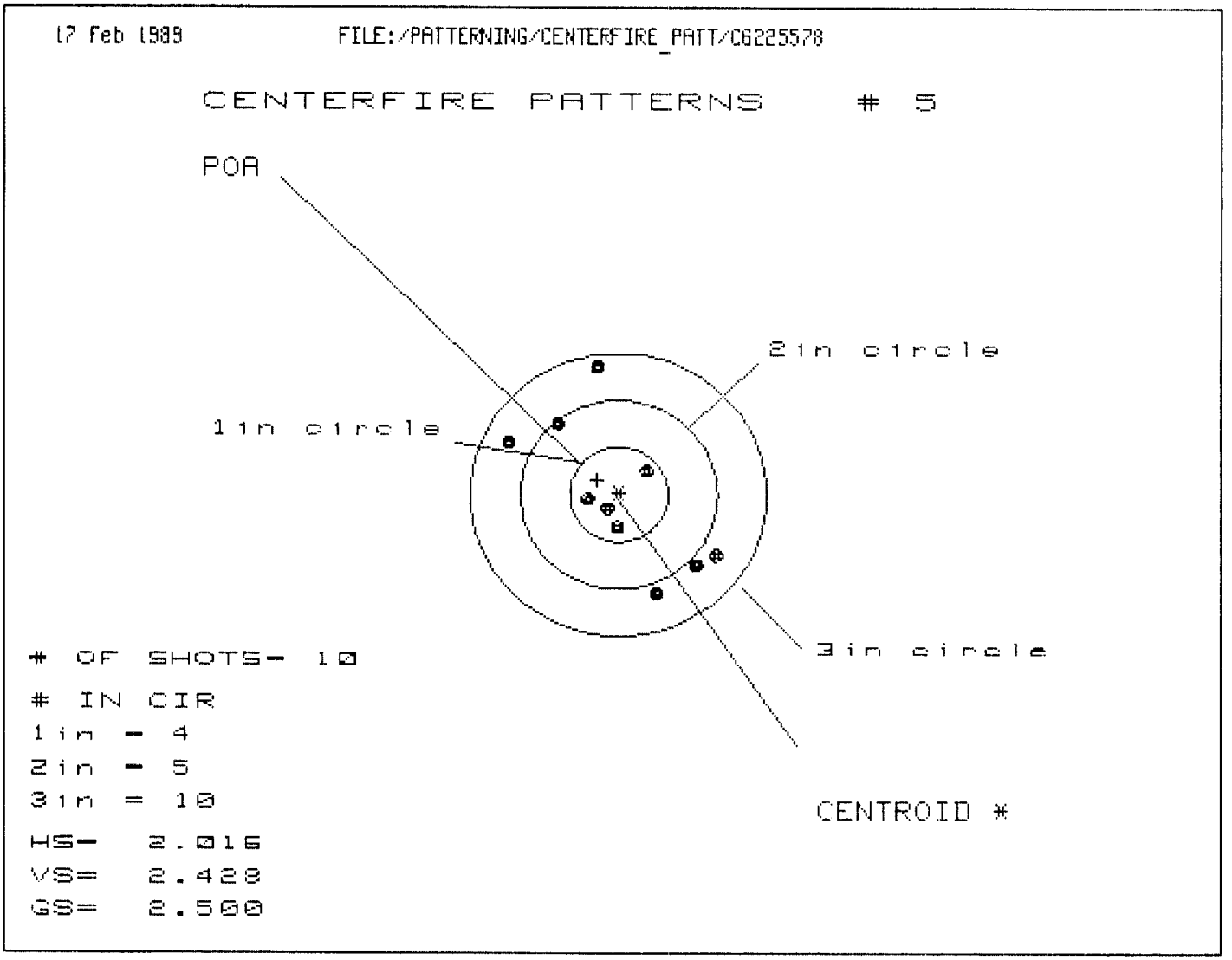
| | | | |
|---|---|---|---|
| SHOTS (BEST OF) : | 10 | 9 | 8 |
| MAXIMUM X : | .940 | .866 | .935 |
| MINIMUM X : | -.939 | -1.013 | -.944 |
| MAXIMUM Y : | 2.582 | 1.302 | 1.162 |
| MINIMUM Y : | -1.408 | -1.122 | -.696 |
| CENTROID X : | .276 | .350 | .281 |
| CENTROID Y : | .587 | .301 | .441 |
| POA TO CENTROID in.: | .649 | .461 | .523 |
| MIN RADIUS : | .145 | .184 | .104 |
| MEAN RADIUS : | 1.043 | .808 | .748 |
| MAX RADIUS : | 2.667 | 1.373 | 1.266 |
| HORIZONTAL SPREAD : | 1.879 | 1.879 | 1.879 |
| VERTICAL SPREAD : | 3.990 | 2.424 | 1.858 |
| EXTREME SPREAD : | 4.196 | 2.427 | 1.980 |
| NUMBER IN ONE INCH CIRCLE = | | 1 | |
| NUMBER IN TWO INCH CIRCLE = | | 5 | |
| NUMBER IN THREE INCH CIRCLE = | | 8 | |




| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 3 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.602 | .514 | .547 |
| MINIMUM X | : | -.852 | -.674 | -.641 |
| MAXIMUM Y | : | 1.294 | 1.224 | 1.038 |
| MINIMUM Y | : | -1.411 | -1.481 | -.668 |
| CENTROID X | : | .422 | .244 | .211 |
| CENTROID Y | : | .153 | .223 | .409 |
| POA TO CENTROID in. | : | .449 | .331 | .460 |
| MIN RADIUS | : | .195 | .142 | .041 |
| MEAN RADIUS | : | .831 | .689 | .569 |
| MAX RADIUS | : | 1.721 | 1.505 | 1.107 |
| HORIZONTAL SPREAD | : | 2.454 | 1.188 | 1.188 |
| VERTICAL SPREAD | : | 2.705 | 2.705 | 1.706 |
| EXTREME SPREAD | : | 2.706 | 2.706 | 1.990 |
| NUMBER IN ONE INCH CIRCLE | = | | 3 | |
| NUMBER IN TWO INCH CIRCLE | = | | 7 | |
| NUMBER IN THREE INCH CIRCLE | = | | 9 | |




| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 4 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.248 | .792 | .881 |
| MINIMUM X | : | -1.004 | -.865 | -.776 |
| MAXIMUM Y | : | .801 | .885 | .749 |
| MINIMUM Y | : | -1.171 | -1.087 | -.659 |
| CENTROID X | : | .222 | .083 | -.006 |
| CENTROID Y | : | .255 | .171 | .307 |
| POA TO CENTROID in. | : | .338 | .190 | .307 |
| MIN RADIUS | : | .238 | .161 | .008 |
| MEAN RADIUS | : | .876 | .783 | .685 |
| MAX RADIUS | : | 1.456 | 1.300 | 1.079 |
| HORIZONTAL SPREAD | : | 2.252 | 1.657 | 1.657 |
| VERTICAL SPREAD | : | 1.972 | 1.972 | 1.408 |
| EXTREME SPREAD | : | 2.393 | 2.393 | 1.984 |
| NUMBER IN ONE INCH CIRCLE | = | | 1 | |
| NUMBER IN TWO INCH CIRCLE | = | | 6 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |




| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 5 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .935 | .917 | .779 |
| MINIMUM X | : | -1.081 | -1.099 | -.813 |
| MAXIMUM Y | : | 1.364 | .902 | .995 |
| MINIMUM Y | : | -1.064 | -.912 | -.819 |
| CENTROID X | : | .217 | .235 | .373 |
| CENTROID Y | : | -.156 | -.308 | -.401 |
| POA TO CENTROID in. | : | .267 | .387 | .547 |
| MIN RADIUS | : | .205 | .179 | .229 |
| MEAN RADIUS | : | .813 | .733 | .669 |
| MAX RADIUS | : | 1.374 | 1.327 | 1.284 |
| HORIZONTAL SPREAD | : | 2.016 | 2.016 | 1.592 |
| VERTICAL SPREAD | : | 2.428 | 1.814 | 1.814 |
| EXTREME SPREAD | : | 2.500 | 2.358 | 2.113 |
| NUMBER IN ONE INCH CIRCLE | = | | 4 | |
| NUMBER IN TWO INCH CIRCLE | = | | 5 | |
| NUMBER IN THREE INCH CIR | | | 10 | |

MOD. _____ GA. CAL. _____ GUN # C622578

| # TEST | DATE | MALFUNCTION/DEFECT | ASSEM. # |
|---|---|---|---|
| | 1st | Extractor sticks back | Blacksmith Dick |
| | 2nd | 2/15/89 New Extractor | |
| | 3rd | 100 Rd. OK. | |
| | 4th | | |

FUNCTION RD 6654 Rev 1

| TEST INIT. ACTION TO CORRECT | | ASSEM. # |
|---|---|---|
| PROOF | 100 Rds OK A.C. | |
| TEST | | |
| TGT | | |
| PROOF | | |
| TEST | | |
| TGT | | |
| PROOF | ENGINEER | |
| TEST | | |
| TGT | | |
| PROOF | ENGINEER | |
| TEST | | |
| TGT | | |