

C6611471

MODEL 700TM M24

Model **SWS** TM

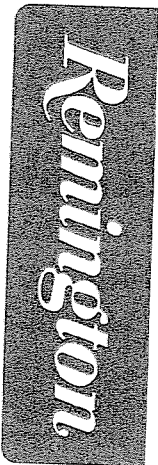
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Stillmond

BARBER - M24 0077483

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C66611417DATE 6-4-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.81	2.56		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.84	2.59		
PULL #3	2.60	2.79	2.62		
PULL #4	2.60	2.85	2.64		
PULL #5	2.63	2.82	2.73		
TOTAL	12.96	14.11	13.14		
AVG.	2.59	2.82	2.62		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.21		
PULL #2	3.19	3.12		
PULL #3	3.21	3.18		
PULL #4	3.20	3.19		
PULL #5	3.14	3.25		
TOTAL	15.87	15.95		
AVG.	3.17	3.19		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.19		4.11
PULL #2	4.20	4.13		4.07
PULL #3	4.25	4.19		4.15
PULL #4	4.26	4.08		4.04
PULL #5	4.19	4.16		4.07
TOTAL	21.19	20.75		20.44
AVG.	4.23	4.15		4.08

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611417
17 Apr 1988

CENTROIDAL DISTANCES

0 TO	1	.242745
1 TO	2	.421865
1 TO	3	.335037
1 TO	4	.311662
1 TO	5	.223544

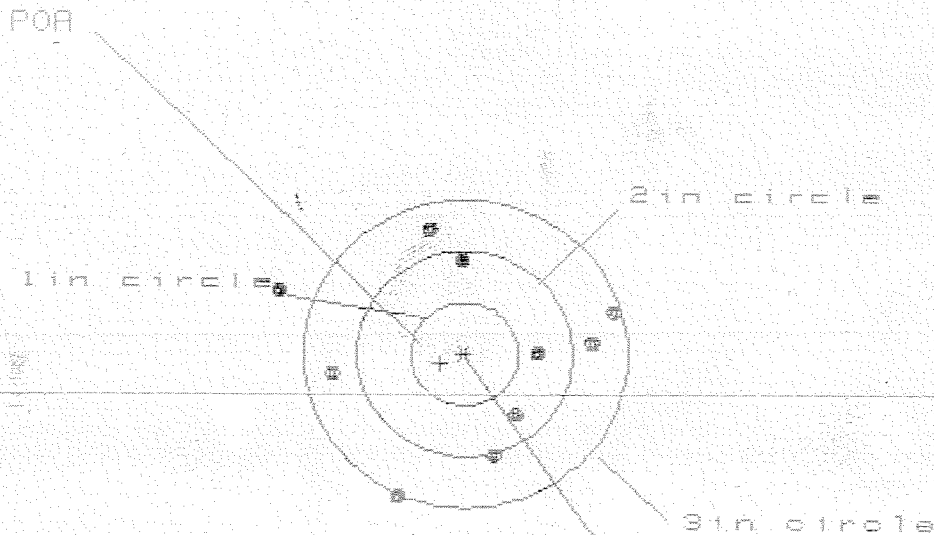
$\frac{25^3}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .063
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1654
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .176992
THE AMR FOR THIS RIFLE IS: .9912

17 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8611417

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 3.089

VS= 2.612

GS= 3.092

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.168	1.060
MINIMUM X	-1.729	-1.372	-1.480
MAXIMUM Y	1.190	1.255	1.086
MINIMUM Y	-1.423	-1.357	-1.117
CENTROID X	.227	.419	.527
CENTROID Y	.086	.021	.190
POA TO CENTROID in.	.243	.420	.560
MIN RADIUS	.637	.449	.355
MEAN RADIUS	1.175	1.063	.971
MAX RADIUS	1.827	1.606	1.513
HORIZONTAL SPREAD	3.089	2.540	2.540
VERTICAL SPREAD	2.612	2.612	2.202
EXTREME SPREAD	3.092	2.761	2.625
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 8		

12 Apr 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11417

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.703

VS= 2.973

GS= 3.320

CENTROID #

PATTERN #

2

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.883	1.956	1.304
MINIMUM X	-.820	-.747	-.502
MAXIMUM Y	2.063	1.151	.608
MINIMUM Y	-.910	-.681	-.537
CENTROID X	-.194	-.267	-.512
CENTROID Y	.113	-.116	-.260
POA TO CENTROID in.	.224	.291	.574
MIN RADIUS	.388	.339	.270
MEAN RADIUS	1.053	.867	.611
MAX RADIUS	2.166	2.270	1.342
HORIZONTAL SPREAD	2.703	2.703	1.806
VERTICAL SPREAD	2.973	1.832	1.145
EXTREME SPREAD	3.320	3.263	1.881
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

17 Apr 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C8611417

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 3.091

VS = 3.293

GS = 3.349

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

3

9

8

10

1.599

-1.492

1.235

-2.058

.316

.409

.516

.218

1.027

2.069

3.091

3.293

3.349

=

=

=

1.575

-1.516

1.007

-.983

.340

.637

.722

.294

.912

1.677

3.091

1.990

3.251

=

=

=

1.142

-1.319

.935

-1.055

.143

.709

.723

.141

.811

1.367

2.461

1.990

2.472

=

=

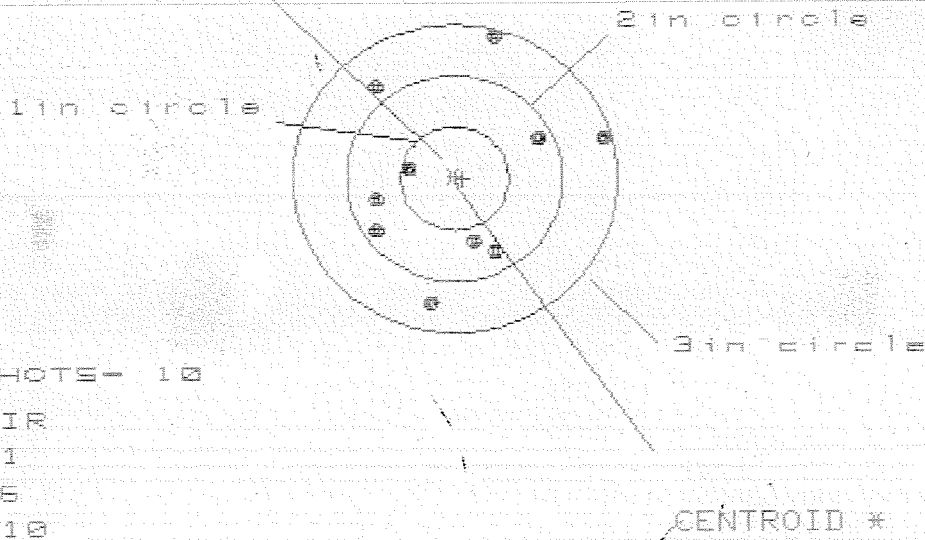
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17 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11417

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.125

VS= 2.677

GS= 2.731

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.355	1.393	.970
MINIMUM X	-.770	-.732	-.558
MAXIMUM Y	1.438	1.098	1.169
MINIMUM Y	-1.239	-1.079	-1.008
CENTROID X	-.075	-.113	-.287
CENTROID Y	.009	-.151	-.222
POA TO CENTROID in.	.076	.189	.363
MIN RADIUS	.460	.494	.422
MEAN RADIUS	.978	.893	.784
MAX RADIUS	1.479	1.504	1.291
HORIZONTAL SPREAD	2.125	2.125	1.528
VERTICAL SPREAD	2.677	2.177	2.177
EXTREME SPREAD	2.731	2.322	2.248
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

17 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6611417

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 2.052

VS= 1.796

GS= 2.581

PATTERN #

5

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.879	.730	.595
MINIMUM X	-1.173	-1.075	-.721
MAXIMUM Y	.638	.510	.545
MINIMUM Y	-1.158	-.719	-.684
CENTROID X	.041	-.057	.078
CENTROID Y	.210	.338	.303
POA TO CENTROID in.	.214	.343	.313
MIN RADIUS	.266	.266	.255
MEAN RADIUS	.723	.636	.553
MAX RADIUS	1.454	1.111	.749
HORIZONTAL SPREAD	2.052	1.805	1.316
VERTICAL SPREAD	1.796	1.229	1.229
EXTREME SPREAD	2.581	1.841	1.340
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611417

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			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611417

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			

Remington
MODEL 700™ M24

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

REG. U.S. PAT. & TM. OFF.

SERIAL NO. C6611471

ORDER NO. 5716

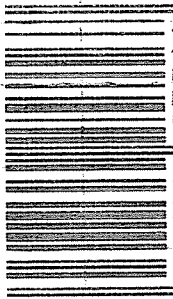
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20



5716 C6611471

UPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611471

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		RW
600	Proof	3 25 91		RW
607	Check Headspace	3 25 91		RW
610	Dis-assemble Gun	3 25 91		RW
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		U
615	Rollmark Caliber			JS
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)			TH
	Apply Coating (Bolt)			TH
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/91	GH

BARBER - M24 0077494		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	6	6	5 1/2			5-2-91	D/H
	G) Safety Off Force	3	3	3			5-2-91	D/H
	H) Trigger Pull Test & Retainability						5-11-91	SH
	I) Firing Pin Indent	1021	1020	1021			5-2-91	D/H
	J) Assemble Stock						5-13-91	RW
	K) Assemble Swivel Studs						5-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						5-13-91	RW
	M) Iron Sight Alignment						5-13-91	RW
	N) Detach Front & Rear Sights & place in numbered container						5-13-91	RW
	O) Attach Scope to Rifle						5-13-91	RW
	P) Detach & Attach Scope 20 Times						5-13-91	RW
640	Gallery Target & Test						5-3-91	D/H
	A) Time						5-3-91	D/H
	B) Malfunctions						5-3-91	D/H
	C) Pierced Primers						5-3-91	D/H
	D) Optical Clarity of Scope						5-3-91	D/H
645	Inspect for Live Ammo						5-3-91	D/H
655	Final Inspection							
	A) Headspace						5-11-91	D/H
	B) Trigger Pull	2.43	2.49	2.58	2.30	2.29	5-14-91	SH
	C) Function						5-14-91	D/H
660	Pack						6-14-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611471

DATE 5-1-91

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.22	2.20	2.43	MIN. SETTING,
PULL #2	2.22	2.25	2.19	2.49	NO AVG. OF 5
PULL #3	2.26	2.26	2.22	2.58	READINGS ACCEPT-
PULL #4	2.28	2.26	2.24	2.30	ABLE LESS THAN 2#
PULL #5	2.30	2.22	2.20	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.16		
PULL #2	3.20	3.16		
PULL #3	3.20	3.43		
PULL #4	3.23	3.43		
PULL #5	3.21	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.51		4.52
PULL #2	4.50	4.50		4.46
PULL #3	4.47	4.46		4.50
PULL #4	4.39	4.43		4.41
PULL #5	4.55	4.47		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611471
3 May 1991

CENTROIDAL DISTANCES

0 TO 1	.175263
1 TO 2	.301783
1 TO 3	.0234094
1 TO 4	.362035
1 TO 5	.407149

²
971 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.014
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0276123
THE AMR FOR THIS RIFLE IS: .954

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611471

CENTERFIRE PATTERNS

1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.013

VS= 2.440

GS= 2.615

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	.944	.842
MINIMUM X	:	-.935	-.815	-.884
MAXIMUM Y	:	1.274	1.122	.902
MINIMUM Y	:	-1.166	-1.025	-.885
CENTROID X	:	.174	.054	.156
CENTROID Y	:	-.021	-.162	-.302
POR TO CENTROID in.	:	.175	.171	.340
MIN RADIUS	:	.102	.201	.264
MEAN RADIUS	:	.876	.788	.708
MAX RADIUS	:	1.669	1.387	.997
HORIZONTAL SPREAD	:	2.013	1.759	1.726
VERTICAL SPREAD	:	2.440	2.147	1.787
EXTREME SPREAD	:	2.615	2.510	1.961
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811471

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 2.807

VS= 2.434

GS= 3.428

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.413	1.005	.850
MINIMUM X	:	-1.394	-1.237	-.868
MAXIMUM Y	:	.904	.785	.804
MINIMUM Y	:	-1.530	-1.649	-1.550
CENTROID X	:	-.019	-.176	-.021
CENTROID Y	:	.211	.330	.231
POA TO CENTROID in.	:	.212	.374	.232
MIN RADIUS	:	.294	.372	.282
MEAN RADIUS	:	1.030	.921	.855
MAX RADIUS	:	1.769	1.751	1.610
HORIZONTAL SPREAD	:	2.807	2.242	1.718
VERTICAL SPREAD	:	2.434	2.434	2.355
EXTREME SPREAD	:	3.428	3.043	2.459
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611471

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.242

VS= 2.297

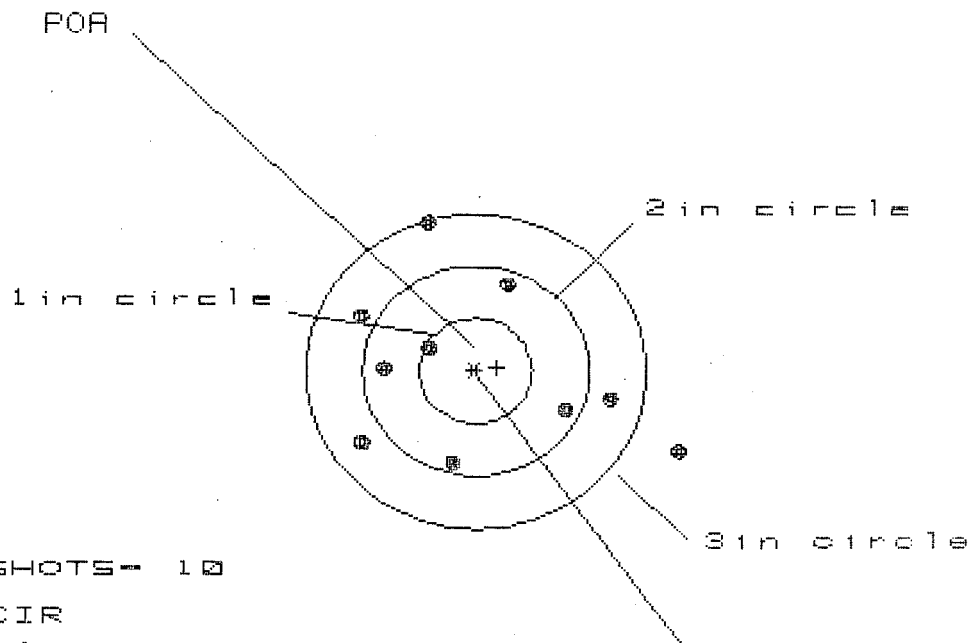
GS= 2.482

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.829	.671	.716
MINIMUM X	:	-1.413	-.833	-.788
MAXIMUM Y	:	1.154	1.108	1.088
MINIMUM Y	:	-1.143	-1.189	-1.050
CENTROID X	:	.196	.354	.309
CENTROID Y	:	-.013	.033	-.106
POA TO CENTROID in.	:	.197	.355	.327
MIN RADIUS	:	.221	.252	.107
MEAN RADIUS	:	.957	.886	.826
MAX RADIUS	:	1.473	1.285	1.140
HORIZONTAL SPREAD	:	2.242	1.504	1.504
VERTICAL SPREAD	:	2.297	2.297	2.138
EXTREME SPREAD	:	2.482	2.446	2.157
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611471

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.787

VS= 2.316

GS= 3.133

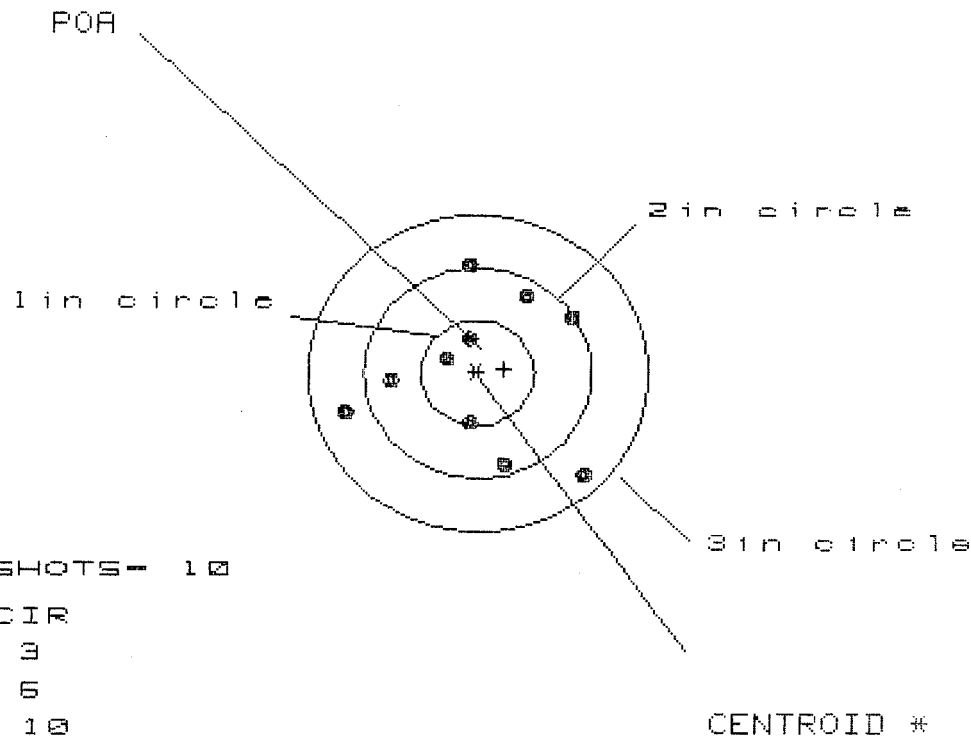
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.745	1.341	1.310
MINIMUM X	:	-1.042	-.848	-.879
MAXIMUM Y	:	1.429	1.339	.902
MINIMUM Y	:	-.887	-.977	-.810
CENTROID X	:	-.188	-.382	-.351
CENTROID Y	:	-.026	.064	-.103
POA TO CENTROID in.	:	.190	.387	.366
MIN RADIUS	:	.469	.255	.372
MEAN RADIUS	:	1.083	.949	.898
MAX RADIUS	:	1.927	1.392	1.327
HORIZONTAL SPREAD	:	2.787	2.189	2.189
VERTICAL SPREAD	:	2.316	2.316	1.712
EXTREME SPREAD	:	3.133	2.334	2.270
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611471

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.130

VS= 1.953

GS= 2.265

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.918	.942	.803
MINIMUM X	-1.212	-1.110	-.819
MAXIMUM Y	1.021	.918	.853
MINIMUM Y	-.932	-1.003	-1.068
CENTROID X	-.233	-.335	-.196
CENTROID Y	-.032	.071	.136
POA TO CENTROID in.	.235	.342	.238
MIN RADIUS	.318	.187	.168
MEAN RADIUS	.824	.746	.682
MAX RADIUS	1.308	1.225	1.081
HORIZONTAL SPREAD	2.130	2.052	1.622
VERTICAL SPREAD	1.953	1.921	1.921
EXTREME SPREAD	2.265	2.265	1.943
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		