

C6498819

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498819

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>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<br>Action                                     |          | 7-12-90 | KR   |
|              | Magnaflux Bolt                                                 |          | 7-12-90 | KR   |
| 615          | Rollmark Caliber                                               |          | 7-12-90 | R.B. |
| 617          | Drill and Tap Sight Holes                                      |          | 7/13/90 | R.B. |
| 618          | Polish Barrel R.B.                                             |          | 7/16/90 | W.B. |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-23-90 | T.A. |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 7/25/90 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 7/25/90 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 7/25/90 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 7/25/90 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/18/90 | JA   |

| op. #        | OP. NAME                                                    | READINGS |      |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 3        | 3    | 3     |      |      | 8/10/90 | JM   |
|              | G) Safety Off Force                                         | 2        | 2    | 2     |      |      | 8/10/90 | JM   |
|              | H) Trigger Pull Test & Retainability                        |          |      |       |      |      | 8/18/90 | JM   |
|              | I) Firing Pin Indent                                        | .225     | .022 | .0225 |      |      | 8/10/90 | JM   |
|              | J) Assemble Stock                                           |          |      |       |      |      | 8/21/90 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |       |      |      | 8/21/90 | JM   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       |      |      | 8/21/90 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |       |      |      | 8/21/90 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       |      |      | 8/21/90 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |       |      |      | 8/21/90 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       |      |      | 8/21/90 | RW   |
| 640          | Gallery Target & Test                                       |          |      |       |      |      | 8/21/90 | NF   |
|              | A) Time                                                     |          |      |       |      |      | 8/21/90 | NF   |
|              | B) Malfunctions                                             |          |      |       |      |      | 8/21/90 | NF   |
|              | C) Pierced Primers                                          |          |      |       |      |      | 8/21/90 | NF   |
|              | D) Optical Clarity of Scope                                 |          |      |       |      |      | 8/21/90 | NF   |
| 645          | Inspect for Live Ammo                                       |          |      |       |      |      | 8/21/90 | NF   |
| 655          | Final Inspection                                            |          |      |       |      |      | 8/29/90 | JM   |
|              | A) Headspace                                                |          |      |       |      |      | 8/22/90 | JM   |
|              | B) Trigger Pull                                             | 2.42     | 2.42 | 2.40  | 2.40 | 2.20 | 8/22/90 | JM   |
|              | C) Function                                                 |          |      |       |      |      | 8/29/90 | JM   |
| 660          | Pack                                                        |          |      |       |      |      | 9/20/90 | NF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C64988/19

DATE 8/18/90

TESTER JU

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.44             | 2.34                     | 2.35                           | 2.42  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.37             | 2.35                     | 2.27                           | 2.42  |                                                                        |
| PULL #3 | 2.38             | 2.38                     | 2.35                           | 2.40  |                                                                        |
| PULL #4 | 2.34             | 2.35                     | 2.33                           | 2.40  |                                                                        |
| PULL #5 | 2.27             | 2.35                     | 2.39                           | 2.20  |                                                                        |
| TOTAL   | 11.80            | 11.77                    | 11.69                          | 11.84 |                                                                        |
| AVG.    | 2.36             | 2.354                    | 2.338                          | 2.368 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.31             | 3.31                     |  |          |
| PULL #2 | 3.31             | 3.34                     |  |          |
| PULL #3 | 3.34             | 3.32                     |  |          |
| PULL #4 | 3.36             | 3.36                     |  |          |
| PULL #5 | 3.33             | 3.30                     |  |          |
| TOTAL   | 16.65            | 16.63                    |  |          |
| AVG.    | 3.33             | 3.326                    |  |          |

|         | 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 | 4.31             | 4.41                     |                                | 4.31                                 |
| PULL #2 | 4.41             | 4.38                     |                                | 4.30                                 |
| PULL #3 | 4.28             | 4.29                     |                                | 4.40                                 |
| PULL #4 | 4.44             | 4.35                     |                                | 4.34                                 |
| PULL #5 | 4.38             | 4.37                     |                                | 4.32                                 |
| TOTAL   | 21.82            | 21.80                    |                                | 21.67                                |
| AVG.    | 4.364            | 4.36                     |                                | 4.334                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06498819  
22 Aug 1990

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .707764 |
| 1 TO 2 | .645776 |
| 1 TO 3 | .83764  |
| 1 TO 4 | .386167 |
| 1 TO 5 | .535239 |

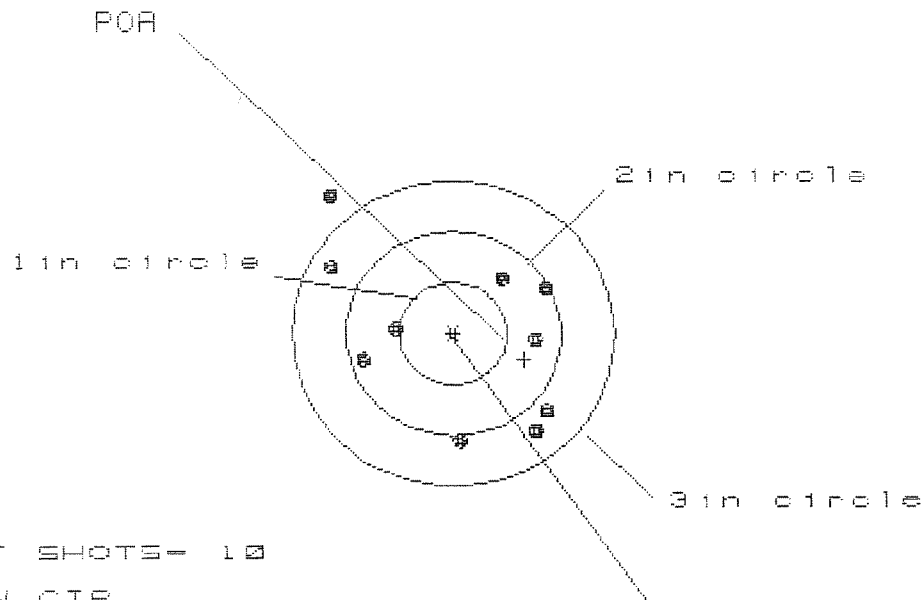
1 5  
4 300 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.306  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0234  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .306893  
THE AMR FOR THIS RIFLE IS: 1.029

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6438813

# CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.040

VS = 2.416

GS = 3.046

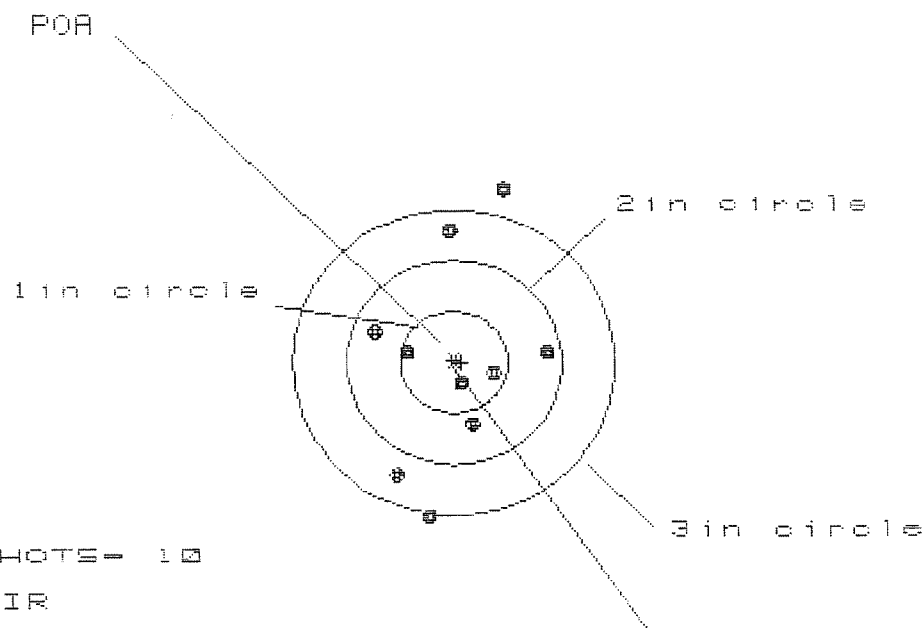
CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .873   | .744   | .582   |
| MINIMUM X                     | -1.167 | -1.296 | -1.159 |
| MAXIMUM Y                     | 1.381  | .795   | .754   |
| MINIMUM Y                     | -1.035 | -.881  | -.782  |
| CENTROID X                    | -.661  | -.532  | -.370  |
| CENTROID Y                    | .253   | .099   | .000   |
| POA TO CENTROID in.           | .708   | .541   | .370   |
| MIN RADIUS                    | .571   | .679   | .547   |
| MEAN RADIUS                   | 1.045  | .939   | .838   |
| MAX RADIUS                    | 1.803  | 1.520  | 1.159  |
| HORIZONTAL SPREAD             | 2.040  | 2.040  | 1.741  |
| VERTICAL SPREAD               | 2.416  | 1.676  | 1.536  |
| EXTREME SPREAD                | 3.046  | 2.519  | 1.892  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 5

3in = 2

HS= 1.604

VS= 3.243

GS= 3.332

CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 2      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .885   | .940   | .914   |
| MINIMUM X                   | : | -.719  | -.664  | -.690  |
| MAXIMUM Y                   | : | 1.727  | 1.452  | 1.286  |
| MINIMUM Y                   | : | -1.516 | -1.324 | -1.060 |
| CENTROID X                  | : | -.066  | -.121  | -.095  |
| CENTROID Y                  | : | .002   | -.190  | -.024  |
| POR TO CENTROID in.         | : | .066   | .225   | .098   |
| MIN RADIUS                  | : | .189   | .089   | .172   |
| MEAN RADIUS                 | : | .916   | .793   | .725   |
| MAX RADIUS                  | : | 1.797  | 1.453  | 1.286  |
| HORIZONTAL SPREAD           | : | 1.604  | 1.604  | 1.604  |
| VERTICAL SPREAD             | : | 3.243  | 2.776  | 2.346  |
| EXTREME SPREAD              | : | 3.332  | 2.789  | 2.401  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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# CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.833

VS= 2.070

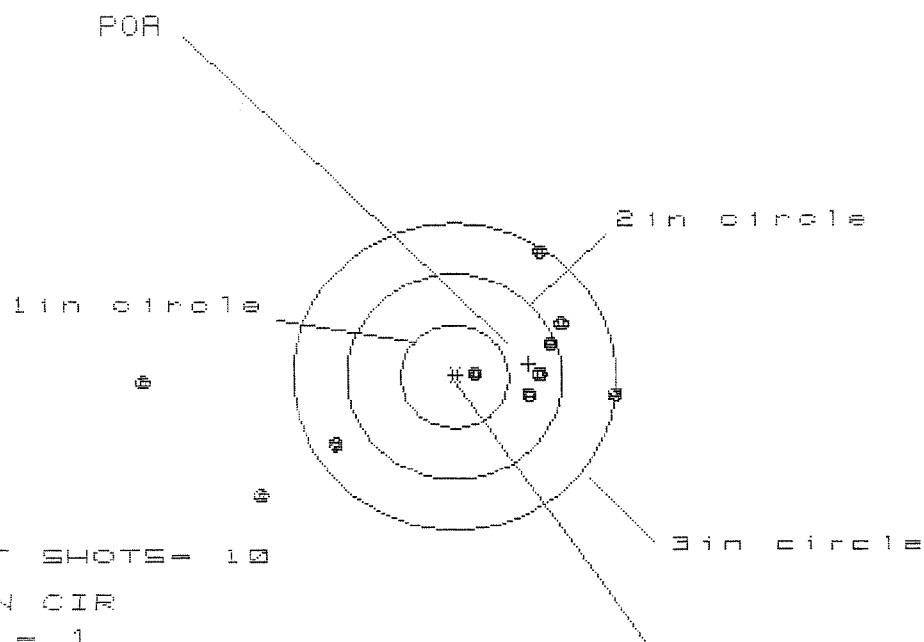
GS= 2.265

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 3      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .899   | .986  | .990  |
| MINIMUM X                   | : | -.934  | -.847 | -.843 |
| MAXIMUM Y                   | : | .974   | .790  | .667  |
| MINIMUM Y                   | : | -1.096 | -.988 | -.716 |
| CENTROID X                  | : | .014   | -.073 | -.077 |
| CENTROID Y                  | : | -.243  | -.351 | -.228 |
| POA TO CENTROID in.         | : | .243   | .359  | .240  |
| MIN RADIUS                  | : | .212   | .274  | .153  |
| MEAN RADIUS                 | : | .795   | .735  | .682  |
| MAX RADIUS                  | : | 1.253  | 1.059 | 1.024 |
| HORIZONTAL SPREAD           | : | 1.833  | 1.833 | 1.833 |
| VERTICAL SPREAD             | : | 2.070  | 1.778 | 1.383 |
| EXTREME SPREAD              | : | 2.265  | 1.904 | 1.904 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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# CENTERFIRE PATTERNS # 4



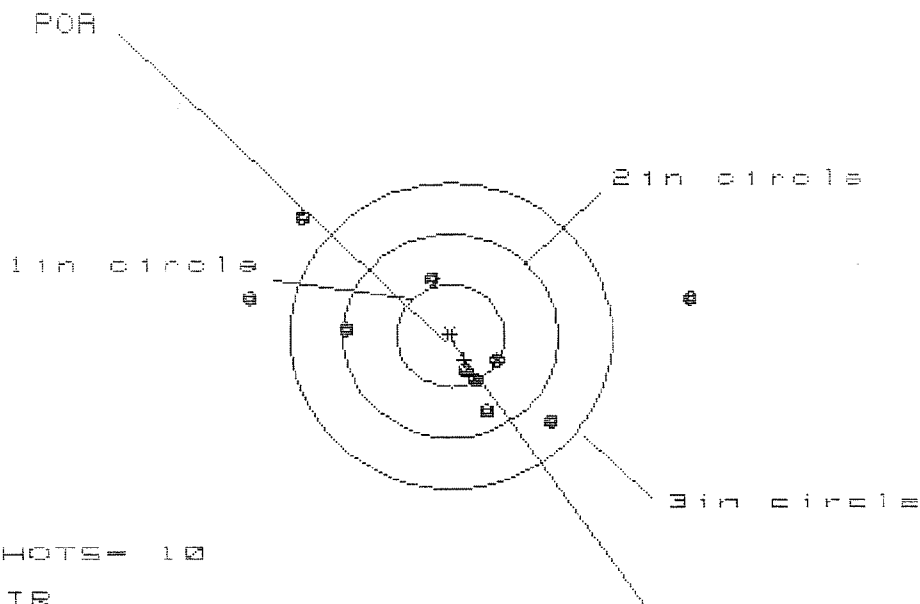
HS= 4.369  
VS= 2.417  
GS= 4.370

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.465  | 1.142  | .880   |
| MINIMUM X                   | : | -2.904 | -2.098 | -1.691 |
| MAXIMUM Y                   | : | 1.265  | 1.252  | 1.106  |
| MINIMUM Y                   | : | -1.152 | -1.165 | -.780  |
| CENTROID X                  | : | -.691  | -.368  | -.106  |
| CENTROID Y                  | : | -.132  | -.119  | .027   |
| POR TO CENTROID in.         | : | .703   | .387   | .109   |
| MIN RADIUS                  | : | .209   | .121   | .247   |
| MEAN RADIUS                 | : | 1.302  | .993   | .722   |
| MAX RADIUS                  | : | 2.907  | 2.400  | 1.862  |
| HORIZONTAL SPREAD           | : | 4.369  | 3.240  | 2.571  |
| VERTICAL SPREAD             | : | 2.417  | 2.417  | 1.886  |
| EXTREME SPREAD              | : | 4.370  | 3.499  | 2.650  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 6

3in = 7

HS = 4.130

VS = 2.033

GS = 4.130

CENTROID \*

| PATTERN #                     | 5      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 2.261  | 1.224  | 1.022  |
| MINIMUM X                     | -1.869 | -1.618 | -1.277 |
| MAXIMUM Y                     | 1.167  | 1.204  | 1.256  |
| MINIMUM Y                     | -.866  | -.829  | -.777  |
| CENTROID X                    | -.126  | -.377  | -.175  |
| CENTROID Y                    | .237   | .200   | .148   |
| POA TO CENTROID in.           | .269   | .427   | .229   |
| MIN RADIUS                    | .350   | .458   | .286   |
| MEAN RADIUS                   | 1.088  | .970   | .822   |
| MAX RADIUS                    | 2.286  | 1.671  | 1.791  |
| HORIZONTAL SPREAD             | 4.130  | 2.842  | 2.299  |
| VERTICAL SPREAD               | 2.033  | 2.033  | 2.033  |
| EXTREME SPREAD                | 4.130  | 3.104  | 3.069  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 7      |        |

**Remington**



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

MODEL 700<sup>TM</sup> M24

SERIAL NO.  
C6498819

ORDER NO.  
5716

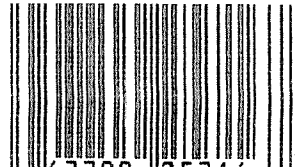
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

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5716 C6498819

UPC



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KINZER V. REMINGTON

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