

06611493

MODEL 700™ M24

Model **515**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

*Remington*



SWS TRIGGER PULL TEST

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

SERIAL NO. C6611493  
DATE 7-19-96  
TESTER DA

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.77             | 2.34                     | 2.54                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.25             | 2.24                     | 2.30                           |                                                                        |
| PULL #3 | 2.47             | 2.35                     | 2.30                           |                                                                        |
| PULL #4 | 2.48             | 2.18                     | 2.48                           |                                                                        |
| PULL #5 | 2.57             | 2.24                     | 2.72                           |                                                                        |
| TOTAL   | 12.54            | 11.35                    | 12.34                          |                                                                        |
| AVG.    | 2.50             | 2.27                     | 2.46                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.25             | 3.00                     |          |
| PULL #2 | 3.07             | 2.90                     |          |
| PULL #3 | 3.11             | 2.84                     |          |
| PULL #4 | 3.34             | 3.07                     |          |
| PULL #5 | 3.11             | 3.00                     |          |
| TOTAL   | 15.88            | 14.81                    |          |
| AVG.    | 3.17             | 2.96                     |          |

|         | 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 | 4.39             | 4.04                     |                                | 4.46                                 |
| PULL #2 | 4.27             | 4.05                     |                                | 4.49                                 |
| PULL #3 | 4.39             | 4.48                     |                                | 4.45                                 |
| PULL #4 | 4.44             | 4.50                     |                                | 4.12                                 |
| PULL #5 | 4.52             | 4.52                     |                                | 4.38                                 |
| TOTAL   | 22.01            | 21.59                    |                                | 21.90                                |
| AVG.    | 4.40             | 4.31                     |                                | 4.38                                 |

| op. #        | OP. NAME                                                    | READINGS |      |      | DATE | INIT       |
|--------------|-------------------------------------------------------------|----------|------|------|------|------------|
| 625<br>cont. | F) Safety On Force                                          | 6.5      | 6.5  | 6    | 8/2  | SF         |
|              | G) Safety Off Force                                         | 3.5      | 5    | 4.5  | 8/2  | SF         |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |            |
|              | I) Firing Pin Indent                                        | .022     | .021 | .021 | 8/2  | SF         |
|              | 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                                             | 248      | 246  | 253  | 252  | 258 8/2 SF |
|              | C) Function                                                 |          |      |      |      |            |
| 660          | Pack                                                        |          |      |      |      |            |

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          |          |      |         |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          |      |         |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          |      |         |
|              | D) Oil Firing Pin Ass'y                                        |          |      |         |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          |      |         |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C.6611493

DATE 5/14/91

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.41             | 2.29                     | 2.33                           | 2.15 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.32                     | 2.28                           | 2.16 |                                                                        |
| PULL #3 | 2.19             | 2.37                     | 2.30                           | 2.18 |                                                                        |
| PULL #4 | 2.37             | 2.30                     | 2.36                           | 2.18 |                                                                        |
| PULL #5 | 2.28             | 2.31                     | 2.38                           | 2.19 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.56             | 3.49                     |  |          |
| PULL #2 | 3.30             | 3.54                     |  |          |
| PULL #3 | 3.56             | 3.62                     |  |          |
| PULL #4 | 3.54             | 3.59                     |  |          |
| PULL #5 | 3.39             | 3.59                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 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 | 4.23             | 4.50                     |                                | 4.49                                 |
| PULL #2 | 4.21             | 4.42                     |                                | 4.52                                 |
| PULL #3 | 4.16             | 4.53                     |                                | 4.54                                 |
| PULL #4 | 4.49             | 4.50                     |                                | 4.50                                 |
| PULL #5 | 4.57             | 4.53                     |                                | 4.48                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611493

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>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<br>Action                                     | 3 28 91  |         | KR   |
|              | Magnaflux Bolt                                                 | 3 28 91  |         | K    |
| 615          | Rollmark Caliber                                               | 3 28 91  |         | LS   |
| 617          | Drill and Tap Sight Holes                                      | APR      | 3 1991  | LB   |
| 618          | Polish Barrel                                                  | APR      | 3 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |         | TA   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly                                                 |          |         |      |
|              | A) Clean inside of<br>Bolt Assembly                            |          | 4/16/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 4/16/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 4/16/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 4/16/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 5-14-91 | SM   |

| op. #        | OP. NAME                                                          | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                                | 5        | 5    | 5    |      |      | 5-14-91 | SL   |
|              | G) Safety Off Force                                               | 4        | 4    | 4    |      |      | 5-14-91 | SL   |
|              | H) Trigger Pull Test &<br>Retainability                           |          |      |      |      |      | 5-14-91 | SL   |
|              | I) Firing Pin Indent                                              | 10205    | 1021 | 1021 |      |      | 5-14-91 | SL   |
|              | J) Assemble Stock                                                 |          |      |      |      |      | 5/16/91 | RW   |
|              | K) Assemble Swivel Studs                                          |          |      |      |      |      | 5-20-91 | A    |
|              | L) Attach Front and Rear<br>Sight Assemblies                      |          |      |      |      |      | 5/16/91 | RW   |
|              | M) Iron Sight Alignment                                           |          |      |      |      |      | 5/16/91 | RW   |
|              | N) Detach Front & Rear<br>Sights & place in<br>numbered container |          |      |      |      |      | 5/16/91 | RW   |
|              | O) Attach Scope to Rifle                                          |          |      |      |      |      | 5/16/91 | RW   |
|              | P) Detach & Attach Scope<br>20 Times                              |          |      |      |      |      | 5/16/91 | RW   |
| 640          | Gallery Target & Test                                             |          |      |      |      |      | 5-16-91 | AF   |
|              | A) Time                                                           |          |      |      |      |      | "       | AF   |
|              | B) Malfunctions                                                   |          |      |      |      |      | "       | AF   |
|              | C) Pierced Primers                                                |          |      |      |      |      | "       | AF   |
|              | D) Optical Clarity of Scope                                       |          |      |      |      |      | "       | AF   |
| 645          | Inspect for Live Ammo                                             |          |      |      |      |      | 5-16-91 | AF   |
| 655          | Final Inspection                                                  |          |      |      |      |      |         |      |
|              | A) Headspace                                                      |          |      |      |      |      | 5-20-91 | A    |
|              | B) Trigger Pull                                                   | 2.15     | 2.16 | 2.18 | 2.18 | 2.19 | 5/24/91 | SL   |
|              | C) Function                                                       |          |      |      |      |      | 5-20-91 | A    |
| 660          | Pack                                                              |          |      |      |      |      | 6-17-91 | AF   |

**Remington®**

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

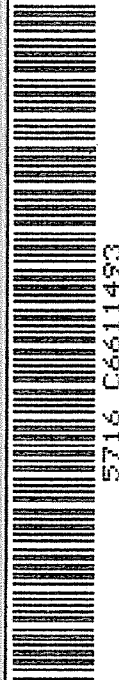
**MODEL 700™ H24**

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

**SERIAL NO.**  
C6611493

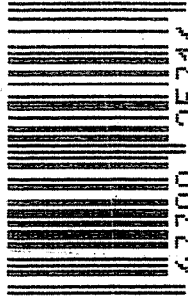
**ORDER NO.**  
5716

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



5716 C6611493

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611493  
16 May 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .115521  |
| 1 TO | 2 | .261926  |
| 1 TO | 3 | .145825  |
| 1 TO | 4 | .0870919 |
| 1 TO | 5 | .108208  |

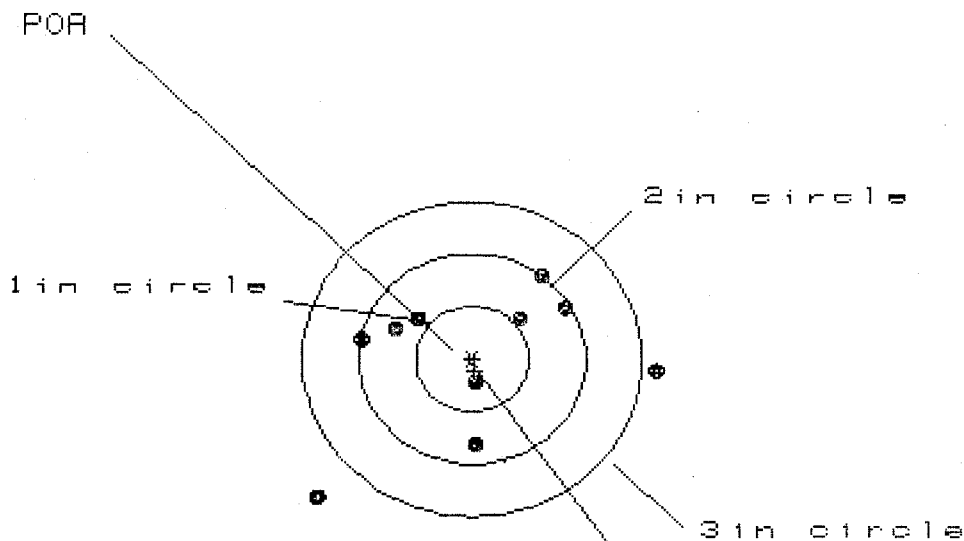
29 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.073  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0504  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0387023  
THE AMR FOR THIS RIFLE IS: 1.045

16 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611493

# CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in - 1

2 in - 8

3 in - 8

HS - 2.972

VS - 2.074

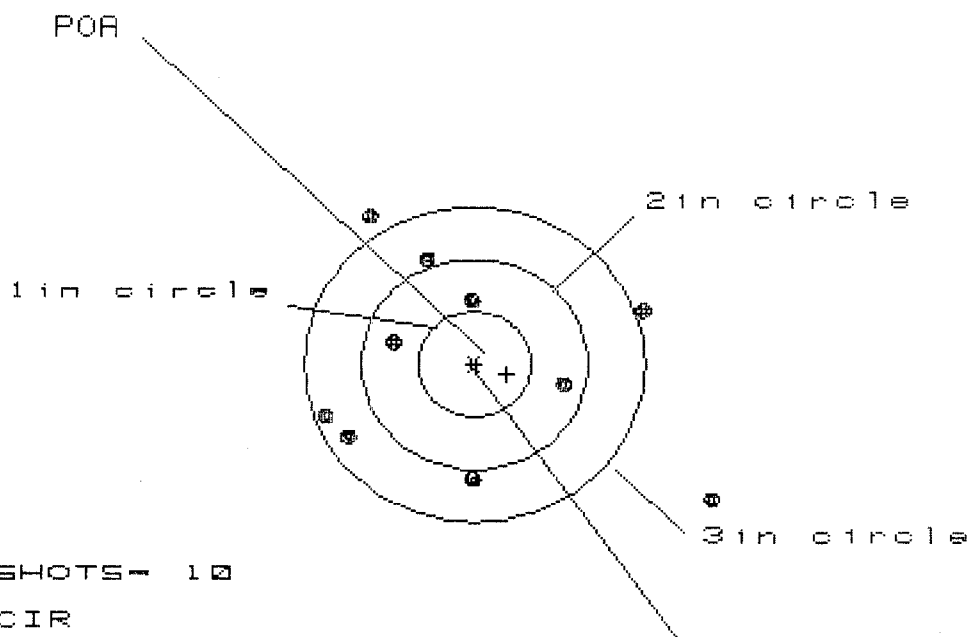
GS - 3.208

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : |        |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.639  | 1.491  | .812  |
| MINIMUM X                   | : | -1.333 | -1.099 | -.913 |
| MAXIMUM Y                   | : | .755   | .609   | .577  |
| MINIMUM Y                   | : | -1.319 | -.936  | -.968 |
| CENTROID X                  | : | -.024  | .124   | -.062 |
| CENTROID Y                  | : | .113   | .259   | .291  |
| POA TO CENTROID in.         | : | .115   | .287   | .298  |
| MIN RADIUS                  | : | .213   | .321   | .396  |
| MEAN RADIUS                 | : | .927   | .806   | .704  |
| MAX RADIUS                  | : | 1.875  | 1.513  | .971  |
| HORIZONTAL SPREAD           | : | 2.972  | 2.590  | 1.725 |
| VERTICAL SPREAD             | : | 2.074  | 1.545  | 1.545 |
| EXTREME SPREAD              | : | 3.208  | 2.604  | 1.751 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

16 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06611493

# CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1 in - 0

2 in - 3

3 in - 7

HS - 3.444

VS - 2.688

GS - 4.036

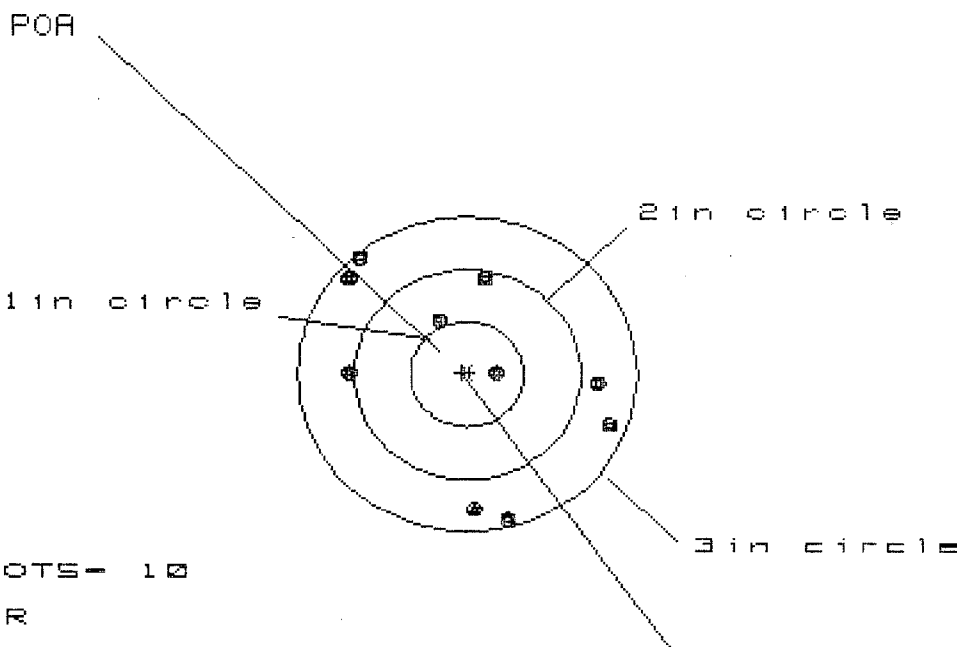
CENTROID \*

| PATTERN #                   | : | 12     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 2.130  | 1.753  | 1.673  |
| MINIMUM X                   | : | -1.314 | -1.077 | -1.157 |
| MAXIMUM Y                   | : | 1.415  | 1.274  | 1.058  |
| MINIMUM Y                   | : | -1.273 | -1.270 | -1.111 |
| CENTROID X                  | : | -.285  | -.522  | -.441  |
| CENTROID Y                  | : | .091   | .232   | .073   |
| POA TO CENTROID in.         | : | .299   | .571   | .447   |
| MIN RADIUS                  | : | .564   | .460   | .590   |
| MEAN RADIUS                 | : | 1.282  | 1.100  | 1.067  |
| MAX RADIUS                  | : | 2.482  | 1.801  | 1.768  |
| HORIZONTAL SPREAD           | : | 3.444  | 2.830  | 2.830  |
| VERTICAL SPREAD             | : | 2.688  | 2.544  | 2.169  |
| EXTREME SPREAD              | : | 4.036  | 3.007  | 3.007  |
| NUMBER IN ONE INCH CIRCLE   | = | 0      | 0      | 0      |
| NUMBER IN TWO INCH CIRCLE   | = | 3      | 3      | 3      |
| NUMBER IN THREE INCH CIRCLE | = | 7      | 7      | 7      |

16 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611493

# CENTERFIRE PATTERNS # 3



# OF SHOTS - 10

# IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.316

VS= 2.572

GS= 2.920

| PATTERN #                     | : | 3      | 3      | 3      |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.258  | 1.149  | 1.185  |
| MINIMUM X                     | : | -1.058 | -1.167 | -1.131 |
| MAXIMUM Y                     | : | 1.147  | 1.027  | .865   |
| MINIMUM Y                     | : | -1.425 | -1.298 | -1.349 |
| CENTROID X                    | : | .044   | .153   | .117   |
| CENTROID Y                    | : | -.016  | -.143  | .019   |
| POA TO CENTROID in.           | : | .047   | .210   | .119   |
| MIN RADIUS                    | : | .266   | .225   | .190   |
| MEAN RADIUS                   | : | 1.092  | 1.043  | .980   |
| MAX RADIUS                    | : | 1.510  | 1.522  | 1.389  |
| HORIZONTAL SPREAD             | : | 2.316  | 2.316  | 2.316  |
| VERTICAL SPREAD               | : | 2.572  | 2.325  | 2.214  |
| EXTREME SPREAD                | : | 2.920  | 2.721  | 2.677  |
| NUMBER IN ONE INCH CIRCLE =   | : | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | : | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE = | : | 9      |        |        |

16 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611493

# CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.663

VS= 1.774

GS= 2.762

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.280  | 1.127  | 1.214  |
| MINIMUM X                   | : | -1.383 | -1.214 | -1.127 |
| MAXIMUM Y                   | : | .712   | .775   | .650   |
| MINIMUM Y                   | : | -1.062 | -.999  | -.452  |
| CENTROID X                  | : | -.001  | .153   | .066   |
| CENTROID Y                  | : | .029   | -.034  | .091   |
| POA TO CENTROID in.         | : | .029   | .157   | .112   |
| MIN RADIUS                  | : | .398   | .557   | .416   |
| MEAN RADIUS                 | : | 1.001  | .947   | .893   |
| MAX RADIUS                  | : | 1.493  | 1.257  | 1.214  |
| HORIZONTAL SPREAD           | : | 2.663  | 2.341  | 2.341  |
| VERTICAL SPREAD             | : | 1.774  | 1.774  | 1.102  |
| EXTREME SPREAD              | : | 2.762  | 2.424  | 2.381  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

16 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611493

# CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in - 4

2 in - 10

3 in = 10

HS= 1.605

VS= 1.265

GS= 1.657

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 5     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .909  | .822  | .314  |
| MINIMUM X                   | : | -.696 | -.595 | -.493 |
| MAXIMUM Y                   | : | .748  | .730  | .663  |
| MINIMUM Y                   | : | -.517 | -.535 | -.571 |
| CENTROID X                  | : | -.099 | -.200 | -.302 |
| CENTROID Y                  | : | .035  | .053  | .120  |
| POA TO CENTROID in.         | : | .105  | .206  | .325  |
| MIN RADIUS                  | : | .151  | .093  | .032  |
| MEAN RADIUS                 | : | .535  | .486  | .420  |
| MAX RADIUS                  | : | .923  | .980  | .679  |
| HORIZONTAL SPREAD           | : | 1.605 | 1.417 | .807  |
| VERTICAL SPREAD             | : | 1.265 | 1.265 | 1.234 |
| EXTREME SPREAD              | : | 1.657 | 1.657 | 1.255 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 10    |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |