

C6587582

MODEL 700™ M24

Model **SWS**™

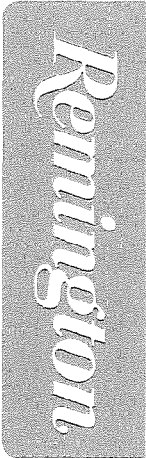
Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



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

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

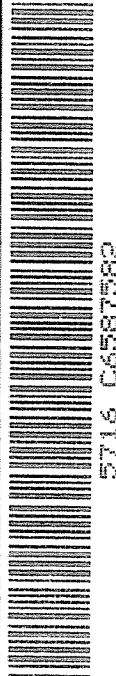
DUPONT

MODEL 700™ M24

SERIAL NO.
C6587582

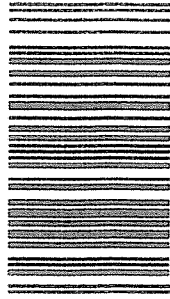
ORDER NO.
5716

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



5716 C6587582

UPC



0 47700 25746 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587582

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LL
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-26-91	HA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/24/91	JP
	G) Safety Off Force	3	3	3			4/24/91	JP
	H) Trigger Pull Test & Retainability						4/24/91	JP
	I) Firing Pin Indent	1023	1023	1023			4/24/91	JP
	J) Assemble Stock						4/25/91	RW
	K) Assemble Swivel Studs						5-11-91	DH
	L) Attach Front and Rear Sight Assemblies						4/25/91	RW
	M) Iron Sight Alignment						4/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	RW
	O) Attach Scope to Rifle						4/25/91	RW
	P) Detach & Attach Scope 20 Times						4/25/91	RW
640	Gallery Target & Test						4-26-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-26-91	NF
655	Final Inspection							
	A) Headspace						5-11-91	DH
	B) Trigger Pull	2.47	2.36	2.38	2.42	2.45	5/18/91	JP
	C) Function						5-11-91	DH
660	Pack						6-18-91	NF

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

SERIAL NO. C6587582DATE 4/24/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.36	2.44	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.45	2.40	2.36	
PULL #3	2.39	2.27	2.39	2.38	
PULL #4	2.38	2.45	2.40	2.42	
PULL #5	2.38	2.39	2.34	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.13		
PULL #2	3.33	3.19		
PULL #3	3.33	3.18		
PULL #4	3.29	3.17		
PULL #5	3.39	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.30		4.53
PULL #2	4.25	4.46		4.41
PULL #3	4.22	4.45		4.50
PULL #4	4.20	4.43		4.55
PULL #5	4.20	4.37		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587582
26 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.153395
1 TO	2	.365919
1 TO	3	.253332
1 TO	4	.139946
1 TO	5	.354346

Ø ←----POA

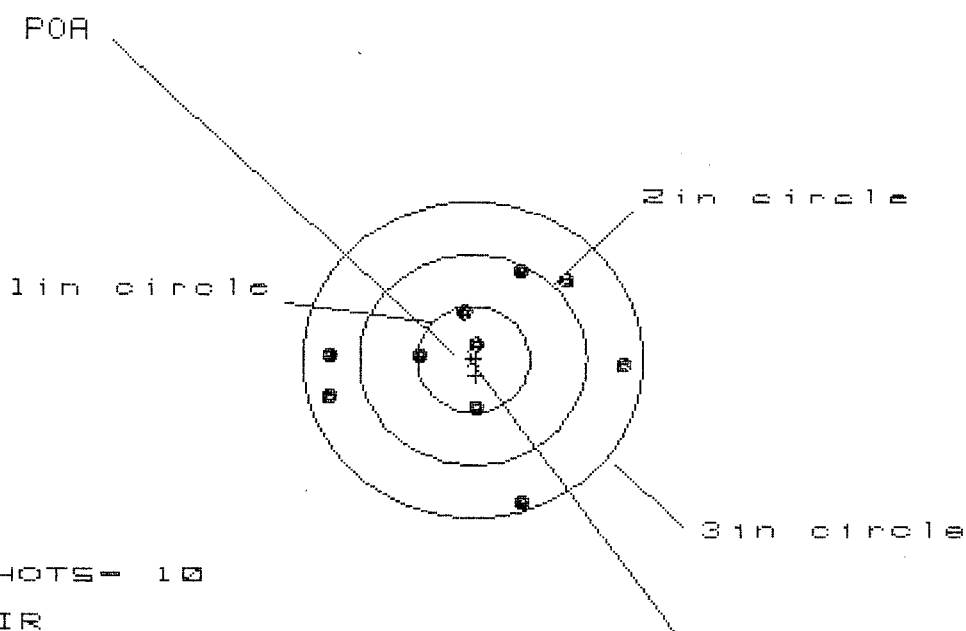
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1232
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0368
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128579
THE AMR FOR THIS RIFLE IS: .8506

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65875B2

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.570

VS= 2.189

GS= 2.572

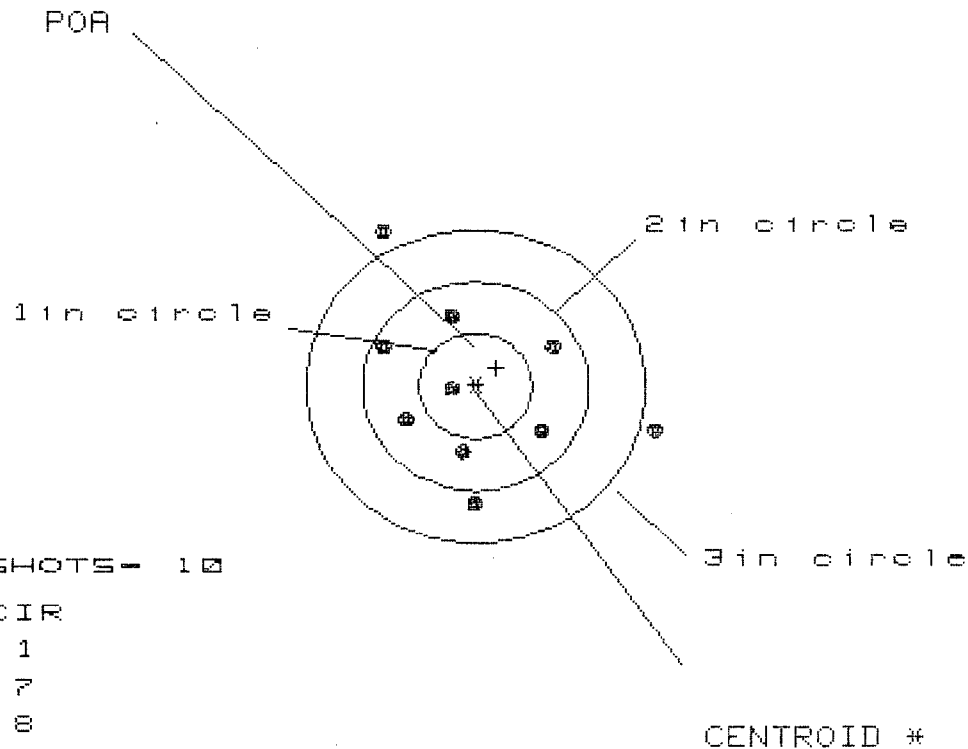
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.354	1.029
MINIMUM X	:	-1.269	-1.216	-1.047
MAXIMUM Y	:	.830	.679	.650
MINIMUM Y	:	-1.359	-.612	-.641
CENTROID X	:	-.027	-.080	-.249
CENTROID Y	:	.151	.302	.331
POA TO CENTROID in.	:	.154	.313	.414
MIN RADIUS	:	.185	.092	.256
MEAN RADIUS	:	.890	.799	.727
MAX RADIUS	:	1.439	1.373	1.183
HORIZONTAL SPREAD	:	2.570	2.570	2.076
VERTICAL SPREAD	:	2.189	1.291	1.291
EXTREME SPREAD	:	2.572	2.572	2.324
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587582

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.400

VS = 2.508

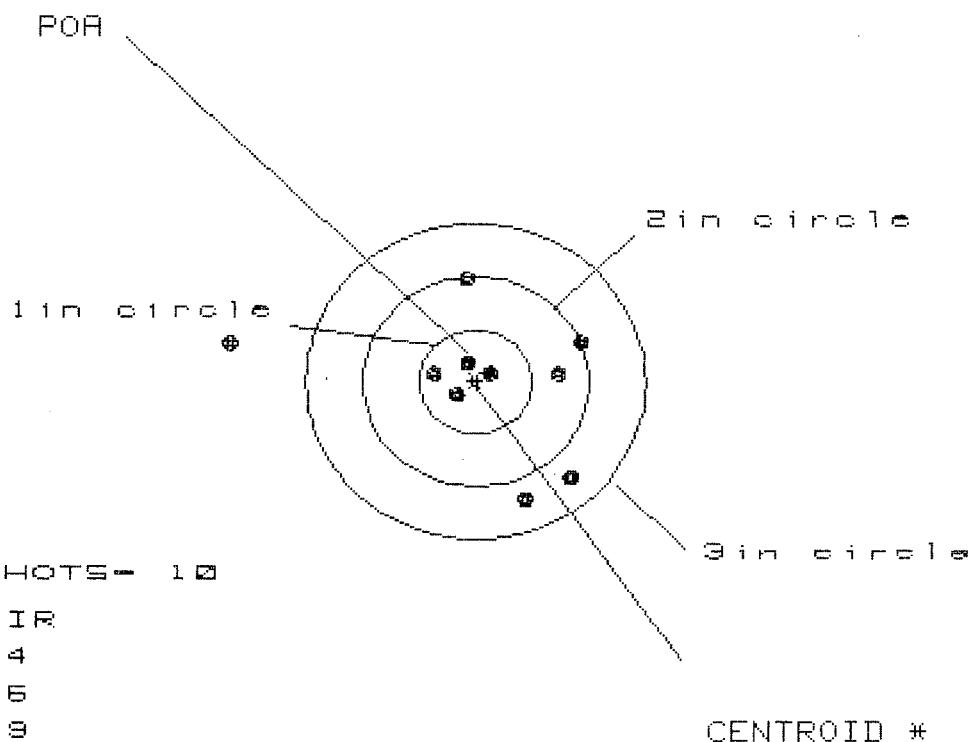
GS = 3.065

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.564	1.471	.815
MINIMUM X	:	-.836	-.913	-.729
MAXIMUM Y	:	1.438	.828	.790
MINIMUM Y	:	-1.070	-.910	-.948
CENTROID X	:	-.183	-.090	-.274
CENTROID Y	:	-.180	-.340	-.302
POA TO CENTROID in.	:	.257	.352	.408
MIN RADIUS	:	.235	.355	.175
MEAN RADIUS	:	.902	.811	.689
MAX RADIUS	:	1.663	1.503	.964
HORIZONTAL SPREAD	:	2.400	2.384	1.544
VERTICAL SPREAD	:	2.508	1.738	1.738
EXTREME SPREAD	:	3.065	2.540	1.748
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587582

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 3.022

VS = 2.174

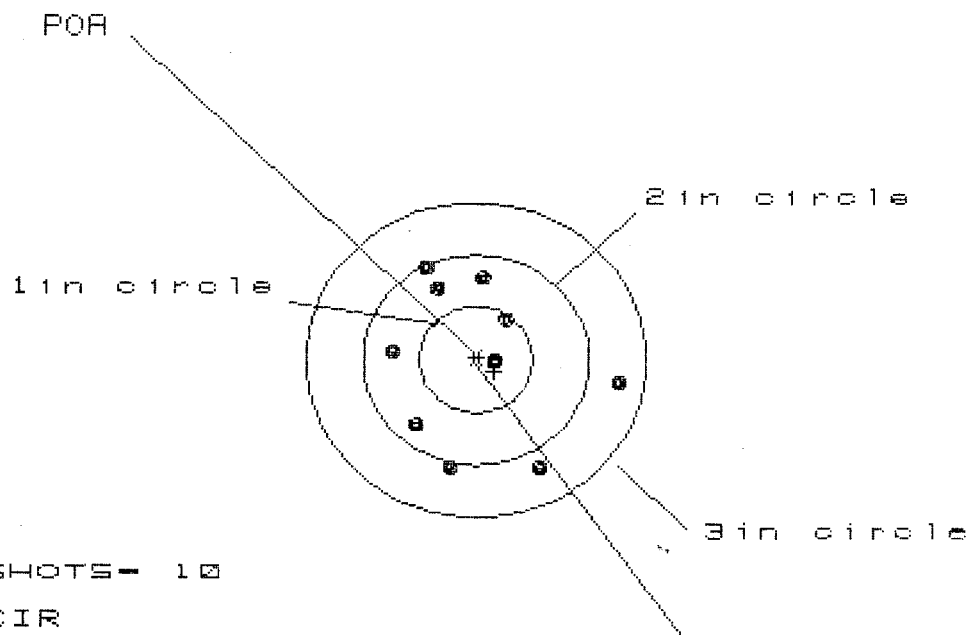
GS = 3.183

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.882	.644	.662
MINIMUM X	-2.140	-.656	-.638
MAXIMUM Y	1.012	1.051	.910
MINIMUM Y	-1.162	-1.123	-.988
CENTROID X	-.131	.107	.089
CENTROID Y	-.080	-.119	.022
POA TO CENTROID in.	.153	.160	.091
MIN RADIUS	.130	.175	.117
MEAN RADIUS	.825	.684	.605
MAX RADIUS	2.169	1.133	1.143
HORIZONTAL SPREAD	3.022	1.300	1.300
VERTICAL SPREAD	2.174	2.174	1.898
EXTREME SPREAD	3.183	2.219	2.081
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587582

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.067

VS = 1.868

GS = 2.157

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	.740	.502
MINIMUM X	:	-.759	-.614	-.522
MAXIMUM Y	:	.863	.838	.710
MINIMUM Y	:	-1.005	-1.030	-1.153
CENTROID X	:	-.163	-.308	-.400
CENTROID Y	:	.118	.143	.271
POA TO CENTROID in.	:	.201	.339	.484
MIN RADIUS	:	.162	.305	.416
MEAN RADIUS	:	.826	.763	.677
MAX RADIUS	:	1.326	1.268	1.153
HORIZONTAL SPREAD	:	2.067	1.354	1.024
VERTICAL SPREAD	:	1.868	1.868	1.863
EXTREME SPREAD	:	2.157	2.157	1.878
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65875B2

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.383

VS= 3.380

GS= 3.403

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.814	.795	.721
MINIMUM X	:	-.569	-.588	-.613
MAXIMUM Y	:	1.019	.757	.630
MINIMUM Y	:	-2.361	-.608	-.514
CENTROID X	:	-.112	-.093	-.019
CENTROID Y	:	-.193	.069	-.025
POA TO CENTROID in.:	:	.223	.116	.032
MIN RADIUS	:	.285	.117	.236
MEAN RADIUS	:	.810	.582	.542
MAX RADIUS	:	2.367	.958	.781
HORIZONTAL SPREAD	:	1.383	1.383	1.334
VERTICAL SPREAD	:	3.380	1.365	1.144
EXTREME SPREAD	:	3.403	1.657	1.471
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	