

C6636101

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

MODEL 700™ M24

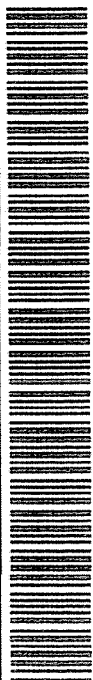
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

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

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

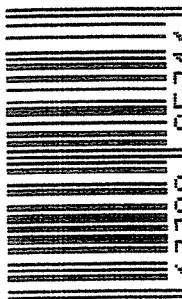
DU PONT

SERIAL NO. C6636101	20
ORDER NO. 5716	



5716 C6636101

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636101

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action	APR	9 1991	KR
	Magnaflux Bolt	APR	9 1991	CC
615	Rollmark Caliber	APR	9 1991	JS
617	Drill and Tap Sight Holes	APR	19 1991	KB
618	Polish Barrel	APR	19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	RM

op. #	BARBER - M24 0037713	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-16-91	SH
	G) Safety Off Force	3	3	3			5-16-91	SH
	H) Trigger Pull Test & Retainability						5-16-91	SH
	I) Firing Pin Indent	.020	.021	.021			5-16-91	SH
	J) Assemble Stock						5/17/91	RW
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/17/91	RW
	M) Iron Sight Alignment						5/17/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/17/91	RW
	O) Attach Scope to Rifle						5/17/91	RW
	P) Detach & Attach Scope 20 Times						5/17/91	RW
640	Gallery Target & Test						5/20/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/20/91	KT
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.70	2.58	2.70	2.65	2.60	5/21/91	SH
	C) Function						5-21-91	D/H
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636101

DATE 5-16-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.48	2.50	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.54	2.53	2.58	
PULL #3	2.37	2.56	2.55	2.70	
PULL #4	2.54	2.55	2.58	2.65	
PULL #5	2.55	2.41	2.49	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.27		
PULL #2	3.34	3.57		
PULL #3	3.44	3.57		
PULL #4	3.45	3.60		
PULL #5	3.26	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.30		4.42
PULL #2	4.59	4.36		4.39
PULL #3	4.46	4.34		4.39
PULL #4	4.34	4.42		4.48
PULL #5	4.34	4.47		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636101
20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.216231
1 TO	2	.205879
1 TO	3	.410099
1 TO	4	.286918
1 TO	5	.134417

4

-----POA

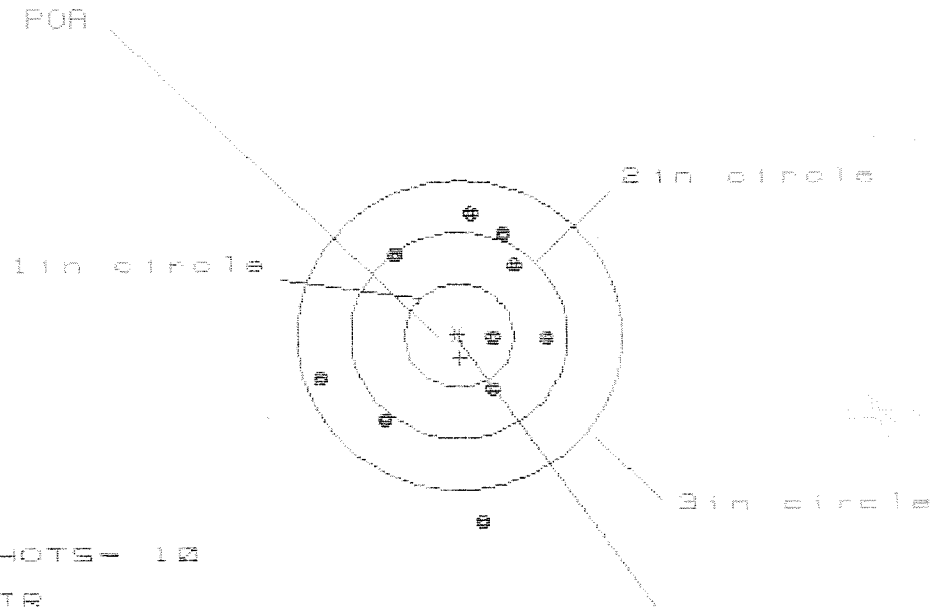
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0464
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0234
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0519665
THE AMR FOR THIS RIFLE IS: 1

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636101

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.156

VS= 3.030

GS= 3.030

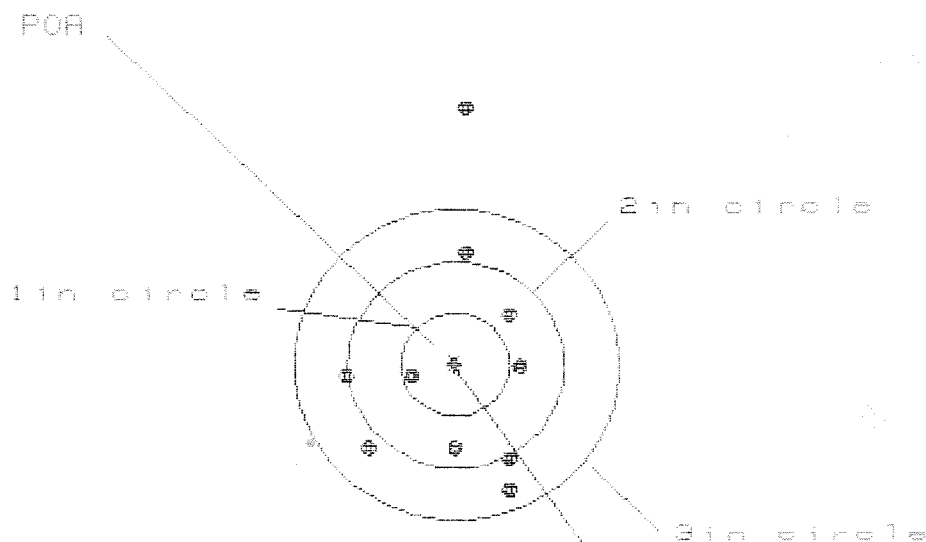
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	-.820	-.838	-.674
MINIMUM X	-1.336	-1.318	-.875
MAXIMUM Y	1.196	.992	.920
MINIMUM Y	-1.834	-1.061	-1.133
CENTROID X	-.010	-.028	.136
CENTROID Y	.216	.420	.492
POA TO CENTROID in.	.216	.421	.511
MIN RADIUS	.352	.432	.360
MEAN RADIUS	1.025	.916	.809
MAX RADIUS	1.841	1.439	1.432
HORIZONTAL SPREAD	2.156	2.156	1.549
VERTICAL SPREAD	3.030	2.853	2.853
EXTREME SPREAD	3.030	2.221	2.221
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

20 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HE = 1.640

VE = 3.643

GE = 3.670

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.614	1.622	1.689
MINIMUM X	-1.026	-1.018	-0.951
MAXIMUM Y	2.439	1.319	1.202
MINIMUM Y	-1.204	-1.933	-1.722
CENTROID X	.009	.001	-.066
CENTROID Y	.011	-.260	-.143
POA TO CENTROID in.	.014	.260	.158
MIN RADIUS	.391	.403	.305
MEAN RADIUS	1.034	.835	.802
MAX RADIUS	2.440	1.321	1.211
HORIZONTAL SPREAD	1.640	1.540	1.640
VERTICAL SPREAD	3.643	2.252	1.924
EXTREME SPREAD	3.670	2.297	2.014
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636101

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 2.945

VS = 2.664

CS = 3.068

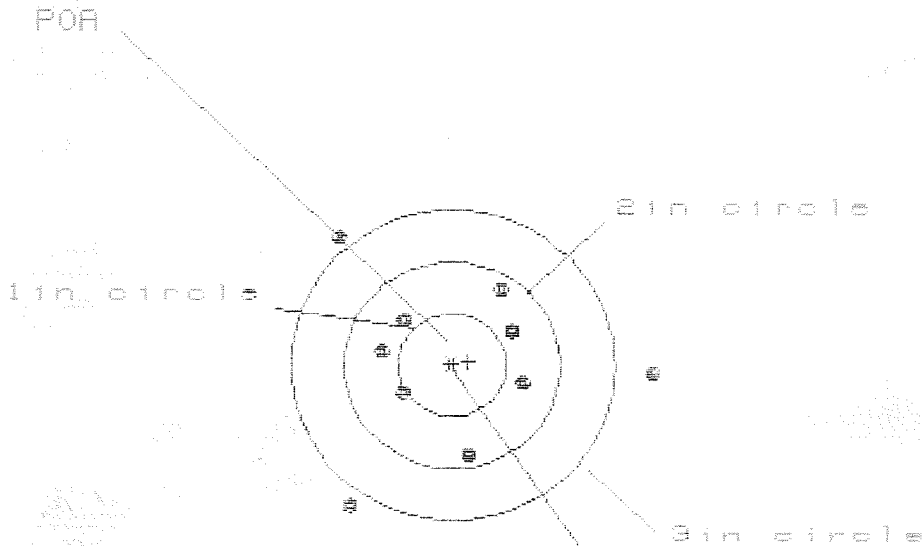
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.369	1.303	1.098
MINIMUM X	-1.576	-1.642	-1.657
MAXIMUM Y	1.564	1.320	1.291
MINIMUM Y	-1.101	-1.927	-1.956
CENTROID X	.020	.086	.291
CENTROID Y	-.193	-.367	-.338
POA TO CENTROID in.	.195	.377	.446
MIN RADIUS	.331	.329	.428
MEAN RADIUS	1.067	.984	.897
MAX RADIUS	1.672	1.658	1.293
HORIZONTAL SPREAD	2.945	2.945	1.755
VERTICAL SPREAD	2.664	2.247	2.247
EXTREME SPREAD	3.068	2.970	2.423
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

28 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 7

HS= 2.883

VS= 2.614

GS= 3.171

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.846	.895	.797
MINIMUM X	:	-1.037	-.832	-.930
MAXIMUM Y	:	1.221	1.210	1.035
MINIMUM Y	:	-1.393	-1.484	-1.089
CENTROID X	:	-.149	-.354	-.256
CENTROID Y	:	-.035	-.024	.151
POA TO CENTROID in.	:	.153	.355	.297
MIN RADIUS	:	.521	.387	.455
MEAN RADIUS	:	1.012	.900	.800
MAX RADIUS	:	1.849	1.608	1.391
HORIZONTAL SPREAD	:	2.883	1.727	1.727
VERTICAL SPREAD	:	2.614	2.614	2.124
EXTREME SPREAD	:	3.171	2.614	2.409
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			7	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.862

VS= 2.378

GS= 3.190

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.576
MINIMUM X	-1.286
MAXIMUM Y	1.181
MINIMUM Y	-1.197
CENTROID X	-.102
CENTROID Y	.118
POA TO CENTROID in.	.156
MIN RADIUS	.167
MEAN RADIUS	.862
MAX RADIUS	1.979
HORIZONTAL SPREAD	2.862
VERTICAL SPREAD	2.378
EXTREME SPREAD	3.190
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9