

C6636181

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
 MODEL 700™ H24

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

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

SERIAL NO.
 C6636181

ORDER NO.
 5716

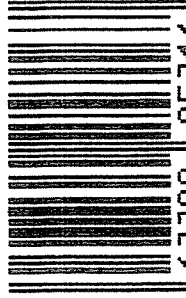
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6636181

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636181

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	K.S.
600	Proof		4/9/91	K.S.
607	Check Headspace		4/9/91	K.S.
610	Dis-assemble Gun		4/9/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	K
615	Rollmark Caliber		4/10/91	GLB
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 9 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	AS
	Apply Coating (Bolt)			AS
625	Final Assembly A) Clean inside of Bolt Assembly		5/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/17/91	KS
	C) Inspect Ejector Hole for Chamfer		5/17/91	KS
	D) Oil Firing Pin Ass'y		5/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-18-91	D/H

op. #	BARBER M24 0038636	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5			5-18-91	AC
	G) Safety Off Force	4	4	4			5-18-91	AC
	H) Trigger Pull Test & Retainability						5-18-91	DH
	I) Firing Pin Indent	.020	.021	.021			5-18-91	AC
	J) Assemble Stock						5-22-91	KS
	K) Assemble Swivel Studs						5-18-91	KS
	L) Attach Front and Rear Sight Assemblies						5-22-91	KS
	M) Iron Sight Alignment						5-22-91	KS
	N) Detach Front & Rear Sights & place in numbered container						5-22-91	KS
	O) Attach Scope to Rifle						5-22-91	KS
	P) Detach & Attach Scope 20 Times						5-22-91	KS
640	Gallery Target & Test						5/22-91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5-22-91	KT
655	Final Inspection							
	A) Headspace						5-23-91	DH
	B) Trigger Pull	2.56	2.58	2.56	2.64	2.61	5/23/91	DH
	C) Function						5-23-91	DH
660	Pack						6-20-91	NF

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

SERIAL NO. C6636181
DATE 5-18-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.72	2.75	2.72	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.72	2.65	2.77	2.58	
PULL #3	2.70	2.76	2.72	2.56	
PULL #4	2.72	2.64	2.81	2.64	
PULL #5	2.75	2.71	2.85	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.65		
PULL #2	3.42	3.65		
PULL #3	3.61	3.64		
PULL #4	3.57	3.65		
PULL #5	3.55	3.72		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.64	4.65		4.24
PULL #2	4.55	4.63		4.25
PULL #3	4.60	4.58		4.20
PULL #4	4.62	4.62		4.21
PULL #5	4.65	4.60		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636181
22 MAR 1991

CENTROIDAL DISTANCES

0 TO	1	.280216
1 TO	2	.330194
1 TO	3	.261262
1 TO	4	.178997
1 TO	5	.270118

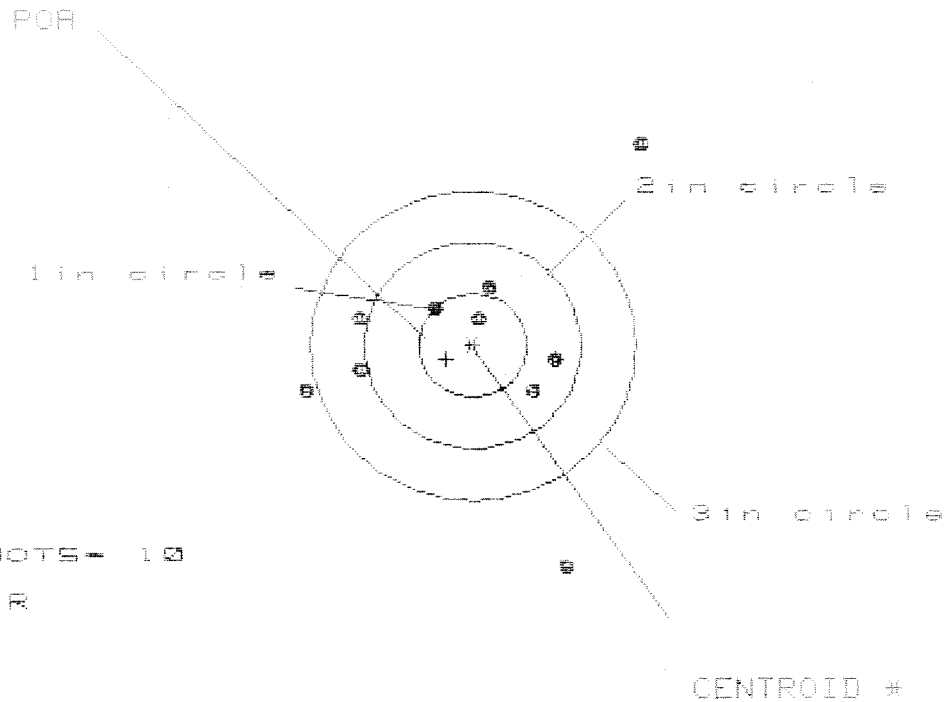
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0797007
THE AMR FOR THIS RIFLE IS: .9558

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66361B1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 3.029

VS = 4.097

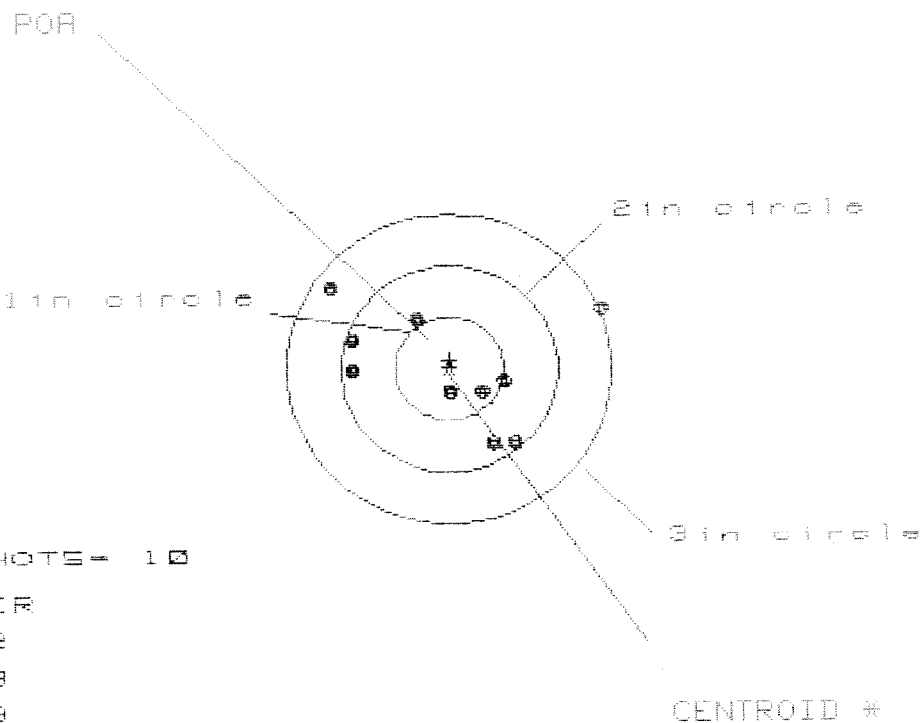
GS = 4.146

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.505	1.039	1.087
MINIMUM X	-1.524	-1.356	-1.226
MAXIMUM Y	1.970	.741	.503
MINIMUM Y	-2.127	-1.908	-.445
CENTROID X	.245	.078	-.052
CENTROID Y	.136	-.083	.155
POA TO CENTROID in.	.281	.114	.164
MIN RADIUS	.240	.506	.388
MEAN RADIUS	1.126	1.004	.797
MAX RADIUS	2.480	2.172	1.302
HORIZONTAL SPREAD	3.029	2.395	2.313
VERTICAL SPREAD	4.097	2.649	.948
EXTREME SPREAD	4.146	3.029	2.331
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

22 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 0

HS = 2.590

VS = 1.506

GS = 2.598

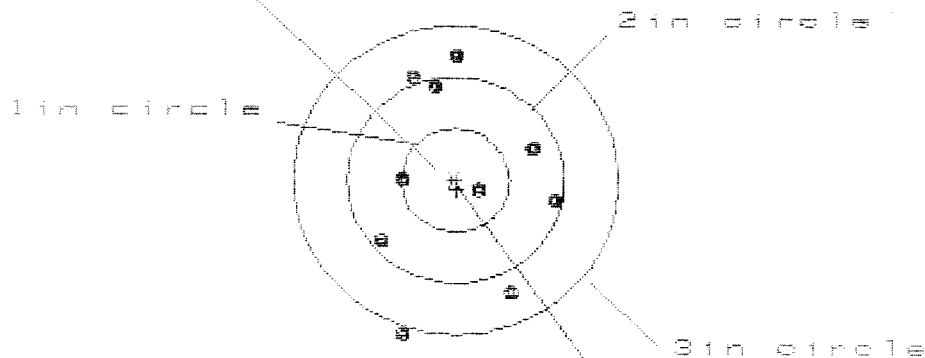
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.445	.744	.621
MINIMUM X	:	-1.145	-.985	-.847
MAXIMUM Y	:	.777	.840	.637
MINIMUM Y	:	-.729	-.666	-.562
CENTROID X	:	-.003	-.163	-.040
CENTROID Y	:	-.082	-.145	-.249
POA TO CENTROID in.	:	.082	.218	.253
MIN RADIUS	:	.232	.254	.093
MEAN RADIUS	:	.812	.729	.617
MAX RADIUS	:	1.552	1.294	.943
HORIZONTAL SPREAD	:	2.590	1.729	1.468
VERTICAL SPREAD	:	1.506	1.506	1.198
EXTREME SPREAD	:	2.598	2.277	1.750
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636181

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 1.604

VS = 2.637

GS = 2.688

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.897
MINIMUM X	-.707
MAXIMUM Y	1.193
MINIMUM Y	-1.444
CENTROID X	-.012
CENTROID Y	.089
FOR TO CENTROID in.	.089
MIN RADIUS	.200
MEAN RADIUS	.930
MAX RADIUS	1.521
HORIZONTAL SPREAD	1.604
VERTICAL SPREAD	2.637
EXTREME SPREAD	2.688
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86381B1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 1.290

VS= 3.146

GS= 3.188

CENTROID *

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.640
MINIMUM X	:	-.649
MAXIMUM Y	:	1.505
MINIMUM Y	:	-1.641
CENTROID X	:	.071
CENTROID Y	:	.094
POA TO CENTROID in.	:	.118
MIN RADIUS	:	.195
MEAN RADIUS	:	.872
MAX RADIUS	:	1.677
HORIZONTAL SPREAD	:	1.290
VERTICAL SPREAD	:	3.146
EXTREME SPREAD	:	3.188
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	8

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C883B1B1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.062

VS= 3.033

GS= 3.100

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.881
MINIMUM X	-1.181
MAXIMUM Y	1.600
MINIMUM Y	-1.433
CENTROID X	.053
CENTROID Y	-.054
POA TO CENTROID in.	.075
MIN RADIUS	.153
MEAN RADIUS	1.039
MAX RADIUS	1.607
HORIZONTAL SPREAD	2.062
VERTICAL SPREAD	3.033
EXTREME SPREAD	3.100
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8