

C6636198

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM 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.

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6636198

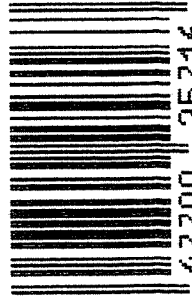
ORDER NO.
5716

20



5716 C6636198

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636198

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/11/91	LS
615	Rollmark Caliber		APR 19 1991	CS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	PA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/91	JS

op. #	BARBER - M24 0038814	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5 1/4			5-23-91	D/H
	G) Safety Off Force	3	3	3			5-23-91	D/H
	H) Trigger Pull Test & Retainability						5/23/91	D/H
	I) Firing Pin Indent	.021	.021	.022			5-23-91	D/H
	J) Assemble Stock						5/23/91	KS
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/23/91	KS
	M) Iron Sight Alignment						5/23/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	KS
	O) Attach Scope to Rifle						5/23/91	KS
	P) Detach & Attach Scope 20 Times						5/23/91	KS
640	Gallery Target & Test						5-24-91	D/H
	A) Time						5-24-91	D/H
	B) Malfunctions						5-24-91	D/H
	C) Pierced Primers						5-24-91	D/H
	D) Optical Clarity of Scope						5-24-91	D/H
645	Inspect for Live Ammo						5-24-91	D/H
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.76	2.66	2.68	2.67	2.70	6/1/91	JM.
	C) Function						6-1-91	D/H
660	Pack						6-20-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± 50#
3.00# ± 75#
4.00# ± 100#

SERIAL NO. C6636198

DATE 5/23/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.45	2.50	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.46	2.45	2.66	
PULL #3	2.41	2.46	2.48	2.68	
PULL #4	2.40	2.45	2.46	2.67	
PULL #5	2.40	2.48	2.46	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.42		
PULL #2	3.66	3.40		
PULL #3	3.64	3.41		
PULL #4	3.66	3.41		
PULL #5	3.50	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.55		4.64
PULL #2	4.40	4.59		4.40
PULL #3	4.40	4.60		4.37
PULL #4	4.43	4.63		4.34
PULL #5	4.46	4.60		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636198
25 May 1991

CENTROIDAL DISTANCES

0 TO	1	.171292
1 TO	2	.341849
1 TO	3	.266248
1 TO	4	.0347131
1 TO	5	.372392

$\frac{8}{24}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1374
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0772
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .157603
THE AMR FOR THIS RIFLE IS: .9732

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536196

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.949

VS= 3.376

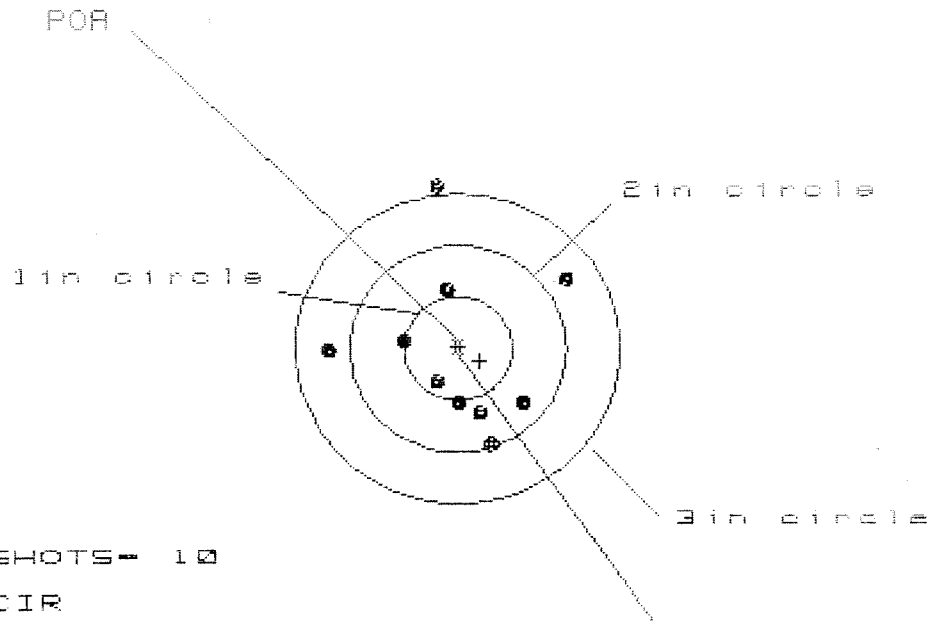
GS= 3.381

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.302	1.259	.844
MINIMUM X	-.647	-.690	-.532
MAXIMUM Y	1.746	1.375	1.079
MINIMUM Y	-1.630	-1.436	-1.264
CENTROID X	-.021	.022	-.136
CENTROID Y	-.170	-.364	-.536
POR TO CENTROID in.	.171	.364	.553
MIN RADIUS	.328	.182	.248
MEAN RADIUS	1.031	.933	.813
MAX RADIUS	1.788	1.864	1.267
HORIZONTAL SPREAD	1.949	1.949	1.376
VERTICAL SPREAD	3.376	2.811	2.343
EXTREME SPREAD	3.381	3.189	2.344
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636190

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.153

VS= 2.489

GS= 2.524

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.974	.957	.683
MINIMUM X	:	-1.179	-1.196	-1.077
MAXIMUM Y	:	1.592	.874	.895
MINIMUM Y	:	-.897	-.720	-.611
CENTROID X	:	-.202	-.185	-.304
CENTROID Y	:	.120	-.057	-.166
POA TO CENTROID in.	:	.235	.193	.347
MIN RADIUS	:	.395	.259	.097
MEAN RADIUS	:	.835	.705	.595
MAX RADIUS	:	1.600	1.296	1.111
HORIZONTAL SPREAD	:	2.153	2.153	1.760
VERTICAL SPREAD	:	2.489	1.594	1.506
EXTREME SPREAD	:	2.524	2.268	1.839
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

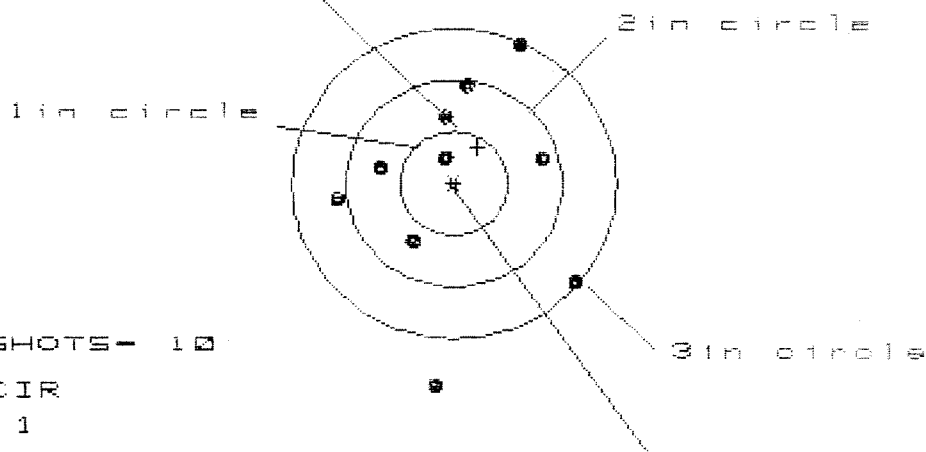
25 May 1991

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CENTERFIRE PATTERNS

3

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.207

VS = 3.325

GS = 3.428

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.093
MINIMUM X	-1.114
MAXIMUM Y	1.358
MINIMUM Y	-1.967
CENTROID X	-.219
CENTROID Y	-.348
POA TO CENTROID in.	.411
MIN RADIUS	.265
MEAN RADIUS	1.016
MAX RADIUS	1.980
HORIZONTAL SPREAD	2.207
VERTICAL SPREAD	3.325
EXTREME SPREAD	3.428
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

25 May 1991

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CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.483

VS= 2.265

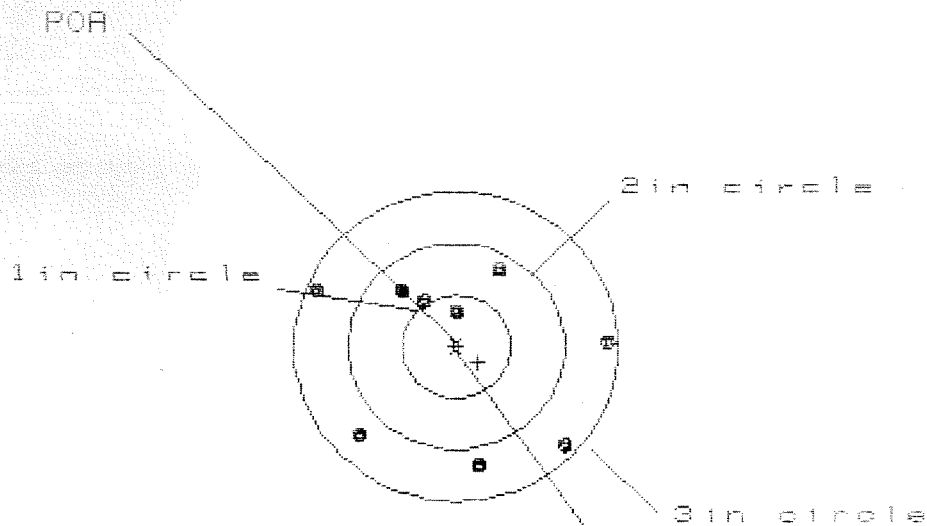
GS= 2.620

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.456	1.542	.718
MINIMUM X	:	-1.027	-.865	-.673
MAXIMUM Y	:	1.147	1.078	1.069
MINIMUM Y	:	-1.118	-1.187	-1.196
CENTROID X	:	-.044	-.206	-.398
CENTROID Y	:	-.144	-.075	-.066
POR TO CENTROID in.	:	.150	.219	.404
MIN RADIUS	:	.140	.177	.308
MEAN RADIUS	:	1.036	.951	.860
MAX RADIUS	:	1.581	1.543	1.196
HORIZONTAL SPREAD	:	2.483	2.407	1.391
VERTICAL SPREAD	:	2.265	2.265	2.265
EXTREME SPREAD	:	2.620	2.417	2.360
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

23 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.688

VS= 1.966

GS= 2.737

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.416	1.111	.972
MINIMUM X	-1.272	-1.115	-.928
MAXIMUM Y	.785	.784	.848
MINIMUM Y	-1.181	-1.182	-1.118
CENTROID X	-.281	-.358	-.219
CENTROID Y	.156	.157	.093
POA TO CENTROID in.	.255	.391	.238
MIN RADIUS	.345	.378	.408
MEAN RADIUS	.948	.883	.853
MAX RADIUS	1.416	1.451	1.384
HORIZONTAL SPREAD	2.688	2.226	1.900
VERTICAL SPREAD	1.966	1.966	1.966
EXTREME SPREAD	2.737	2.652	2.159
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		