

06649103

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TH M24

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

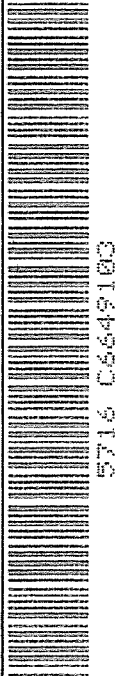
DUPONT
REG. U.S. PAT. & TM. OFF.

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

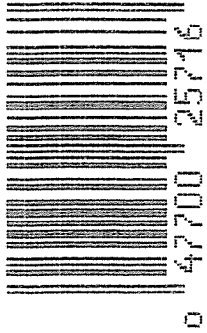
SERIAL NO.
C6649103

ORDER NO.
5716

20



LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649103

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8/2/91	WB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-4-91	DH

op. #	BARBER - M24 0064849 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 ³ / ₄	6	6			9-4-91	DH
	G) Safety Off Force	3	3	3			9-4-91	DH
	H) Trigger Pull Test & Retainability						9-4-91	DH
	I) Firing Pin Indent	.020	.020	.021			9-4-91	DH
	J) Assemble Stock						9/5/91	RW
	K) Assemble Swivel Studs						9-10-91	K
	L) Attach Front and Rear Sight Assemblies						9/5/91	RW
	M) Iron Sight Alignment						9/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	RW
	O) Attach Scope to Rifle						9/5/91	RW
	P) Detach & Attach Scope 20 Times						9/5/91	RW
640	Gallery Target & Test						9-5-91	AC
	A) Time						9-5-91	AC
	B) Malfunctions						9-5-91	AC
	C) Pierced Primers						9-5-91	AC
	D) Optical Clarity of Scope						9-5-91	AC
645	Inspect for Live Ammo						9-5-91	AC
655	Final Inspection							
	A) Headspace						9-10-91	K
	B) Trigger Pull	2.34	2.32	2.34	2.39	2.39	9-6-91	DH
	C) Function						9-10-91	AC
660	Pack						9-17-91	DH

FIM1

BARBER - M24 0064850

ETAQ

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649103DATE 7-4-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.73	2.61	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.63	2.67	2.32	
PULL #3	2.34	2.34	2.51	2.34	
PULL #4	2.34	2.31	2.77	2.39	
PULL #5	2.46	2.61	2.61	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.54		
PULL #2	3.28	3.01		
PULL #3	3.40	3.62		
PULL #4	3.56	3.60		
PULL #5	3.55	3.71		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.00		4.06
PULL #2	4.33	4.32		4.01
PULL #3	4.21	4.13		4.07
PULL #4	4.19	4.38		4.33
PULL #5	4.27	4.06		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649103
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0655134
1 TO	2	.144014
1 TO	3	.393081
1 TO	4	.155261
1 TO	5	.0780064

43 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0344
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0012
THE PRESENT AVERAGE POI RADIUS FOR THIS RIFLE IS: .034427
THE POI FOR THIS RIFLE IS: .8614

93.

FILE:/PATTERNING/CENTERFIRE_PATT/066485183

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.0021

VS = 2.664

GS = 2.738

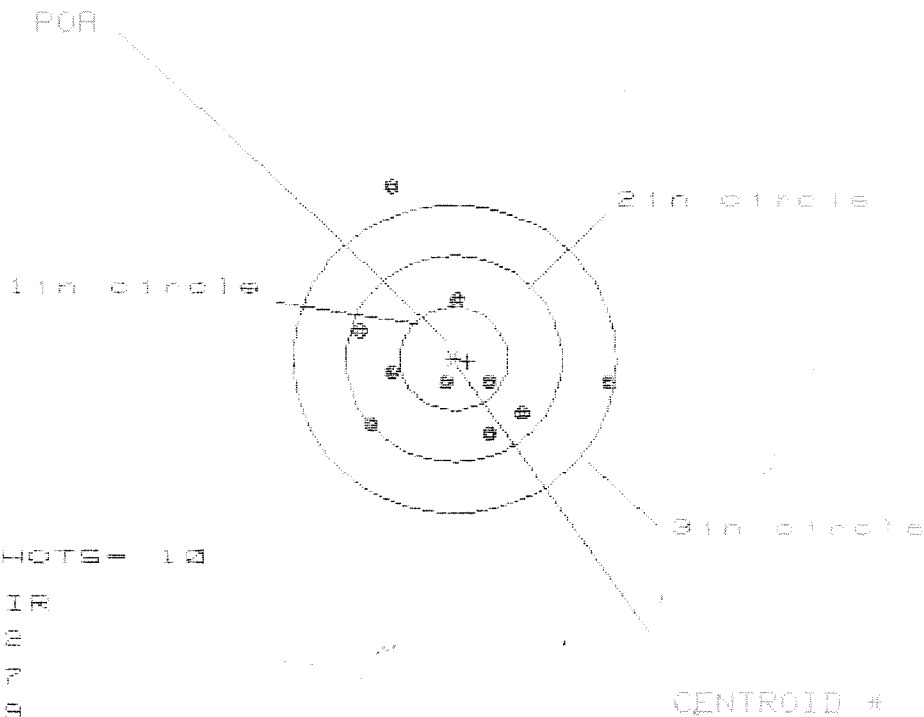
PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.855	.748
MINIMUM X	-1.144	-1.166	-1.273
MAXIMUM Y	1.610	.805	.696
MINIMUM Y	-1.054	-.876	-.747
CENTROID X	-.014	.008	.115
CENTROID Y	-.064	-.242	-.136
FOR TO CENTROID in.	.065	.242	.176
RIP X-RADIUS	.436	.503	.480
Y-RIP X-RADIUS	.925	.841	.759
RIP RADIUS	1.622	1.253	1.394
HORIZONTAL SPREAD	2.021	2.021	2.021
VERTICAL SPREAD	2.664	1.681	1.445
EXTREME SPREAD	2.738	2.398	2.327
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

1 365 (59)

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.358

VS = 2.349

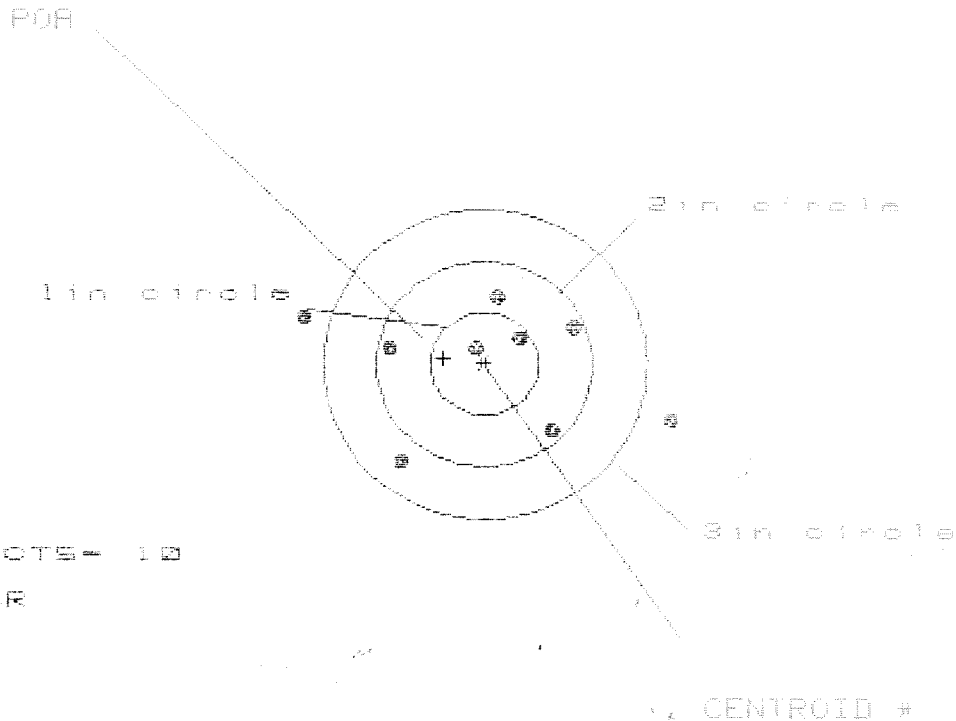
GS = 2.695

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.454	1.394	.773
MINIMUM X	-.905	-.965	-.791
MAXIMUM Y	1.645	.733	.734
MINIMUM Y	-.705	-.522	-.521
CENTROID X	-.128	-.668	-.242
CENTROID Y	.024	-.158	-.159
POR TO CENTROID in.	.130	.172	.290
MIN RADIUS	.243	.162	.042
MEAN RADIUS	.854	.726	.626
MAX RADIUS	1.729	1.394	.938
HORIZONTAL SPREAD	2.359	2.359	1.564
VERTICAL SPREAD	2.349	1.355	1.355
EXTREME SPREAD	2.695	2.410	1.755
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

5 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 3.388

VS = 1.549

ES = 3.537

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.782	1.816	.829
MINIMUM X	-1.687	-1.498	-.891
MAXIMUM Y	.614	.551	.600
MINIMUM Y	-.935	-.998	-.949
CENTROID X	.379	.190	.378
CENTROID Y	-.056	.007	-.042
POR TO CENTROID in.	.383	.190	.380
MIN RADIUS	.178	.082	.157
MEAN RADIUS	.082	.771	.656
MAX RADIUS	1.792	1.548	1.247
HORIZONTAL SPREAD	3.389	2.514	1.720
VERTICAL SPREAD	1.549	1.549	1.545
EXTREME SPREAD	3.537	2.558	2.675
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

5 Sep 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 1.744

VS = 2.996

GS = 3.148

CENTROID #

PATTERN #

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.983

1.037

.982

MINIMUM X

-.761

-.707

-.762

MAXIMUM Y

1.608

.861

.710

MINIMUM Y

-1.388

-1.209

-.898

CENTROID X

-.005

-.059

-.004

CENTROID Y

.091

-.088

.063

POA TO CENTROID (in.)

.091

.106

.063

MIN RADIUS

.341

.162

.317

MEAN RADIUS

.896

.787

.725

MAX RADIUS

1.678

1.284

1.041

HORIZONTAL SPREAD

1.744

1.744

1.744

VERTICAL SPREAD

2.996

2.070

1.608

EXTREME SPREAD

3.148

2.088

1.919

NUMBER IN ONE

INCH CIRCLE =

1

NUMBER IN TWO

INCH CIRCLE =

7

NUMBER IN THREE

INCH CIRCLE =

9

5 Sep 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06649103

CENTERFIRE PATTERNS

3

FOR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 8

HS = 2.270

VS = 1.460

GS = 0.553

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.099	.785	.576
MINIMUM X	-1.271	-1.038	-.410
MAXIMUM Y	.767	.815	.734
MINIMUM Y	-.693	-.645	-.548
CENTROID X	-.060	-.293	-.164
CENTROID Y	-.001	-.049	.002
FOR TO CENTROID IN.	.060	.297	.167
MIN RADIUS	.184	.323	.179
MEAN RADIUS	.750	.584	.484
MAX RADIUS	2.143	1.222	.841
HORIZONTAL SPREAD	3.370	1.743	.986
VERTICAL SPREAD	1.460	1.460	1.191
EXTREME SPREAD	3.553	2.085	1.302
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	