

C6611596

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

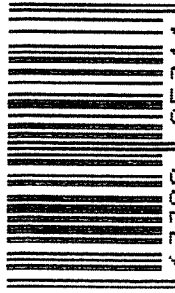
SERIAL NO.
C6611596

ORDER NO.
5716

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



LPC



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611596

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/17/91	K.S.
600	Proof		3/17/91	K.S.
607	Check Headspace		3/17/91	K.S.
610	Dis-assemble Gun		3/17/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GS
617	Drill and Tap Sight Holes	APR	3 1991	K.B
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-16-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/25/91	JK

op. #	BARBER M24 0079369 OFF. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/25/91	JP
	G) Safety Off Force	3	3	3			4/25/91	JP
	H) Trigger Pull Test & Retainability						4/25/91	JP
	I) Firing Pin Indent	0235	0235	0235			4/25/91	JP
	J) Assemble Stock						4/29/91	KS
	K) Assemble Swivel Studs						5-18-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/29/91	KS
	M) Iron Sight Alignment						4/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/29/91	KS
	O) Attach Scope to Rifle						4/29/91	KS
	P) Detach & Attach Scope 20 Times						4/29/91	KS
640	Gallery Target & Test						4-30-91	AC
	A) Time						4-30-91	AC
	B) Malfunctions						4-30-91	AC
	C) Pierced Primers						4-30-91	AC
	D) Optical Clarity of Scope						4-30-91	AC
645	Inspect for Live Ammo						4-30-91	AC
655	Final Inspection							
	A) Headspace						5-18-91	D/H
	B) Trigger Pull	2.59	2.55	2.60	2.61	2.55	5/10/91	JP
	C) Function						5-18-91	D/H
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. C-6611596

DATE 4/25/91

TESTER J. J. J. (P)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.28	2.48	2.59	MINIMUM SETTING,
PULL #2	2.43	2.34	2.39	2.55	NO AVG. OF 5
PULL #3	2.45	2.38	2.36	2.60	READINGS ACCEPT-
PULL #4	2.39	2.37	2.30	2.61	ABLE LESS THAN 2#
PULL #5	2.48	2.46	2.33	2.55	NOT (M)
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS	
PULL #1	3.27	3.39		
PULL #2	3.31	3.25		
PULL #3	3.25	3.33		
PULL #4	3.32	3.37		
PULL #5	3.36	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.36		4.44
PULL #2	4.29	4.35		4.39
PULL #3	4.56	4.55		4.35
PULL #4	4.45	4.48		4.39
PULL #5	4.27	4.22		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611596
30 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.232691
1 TO	2	.528346
1 TO	3	.364078
1 TO	4	.163527
1 TO	5	.171686

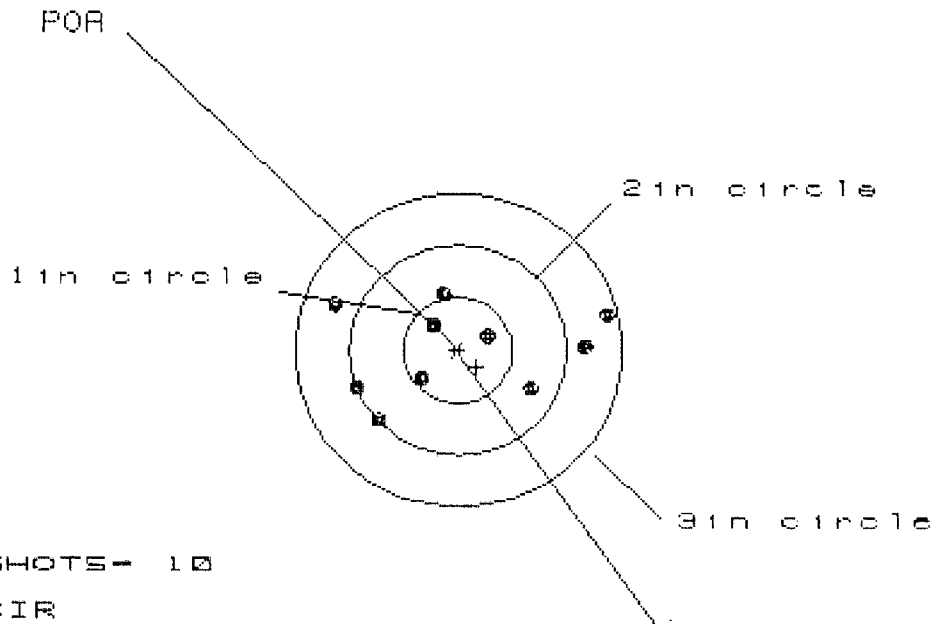
Sp2 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .039
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0394289
THE AMR FOR THIS RIFLE IS: .9526

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611596

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.499

VS= 1.234

GS= 2.500

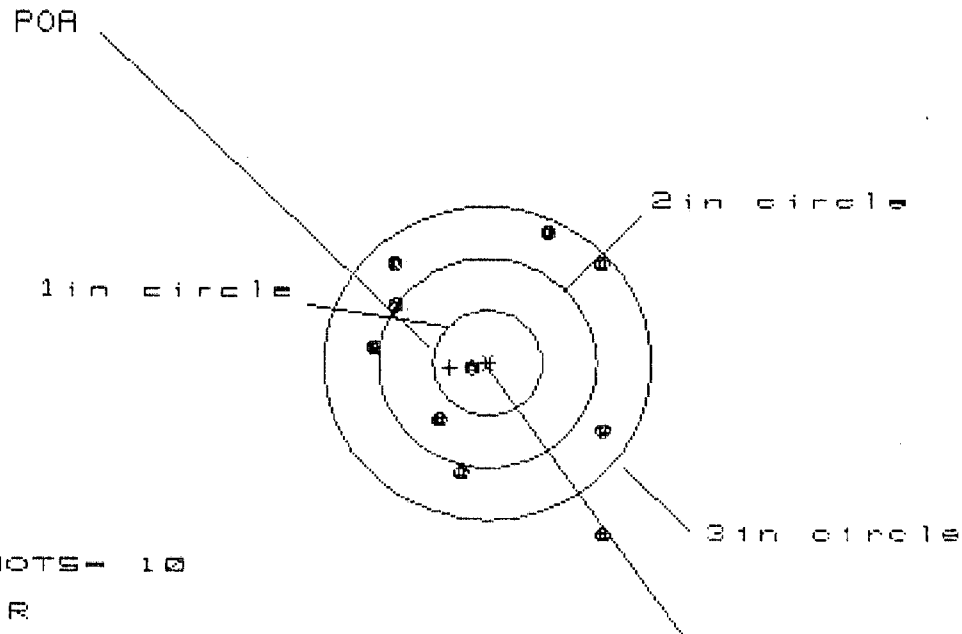
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.337	1.318	1.192
MINIMUM X	-1.161	-1.013	-.909
MAXIMUM Y	.551	.591	.648
MINIMUM Y	-.683	-.643	-.586
CENTROID X	-.168	-.316	-.190
CENTROID Y	.161	.121	.064
POA TO CENTROID in.	.232	.339	.200
MIN RADIUS	.306	.290	.333
MEAN RADIUS	.827	.752	.708
MAX RADIUS	1.384	1.320	1.199
HORIZONTAL SPREAD	2.499	2.331	2.100
VERTICAL SPREAD	1.234	1.234	1.234
EXTREME SPREAD	2.500	2.363	2.140
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.130

VS= 2.850

GS= 3.147

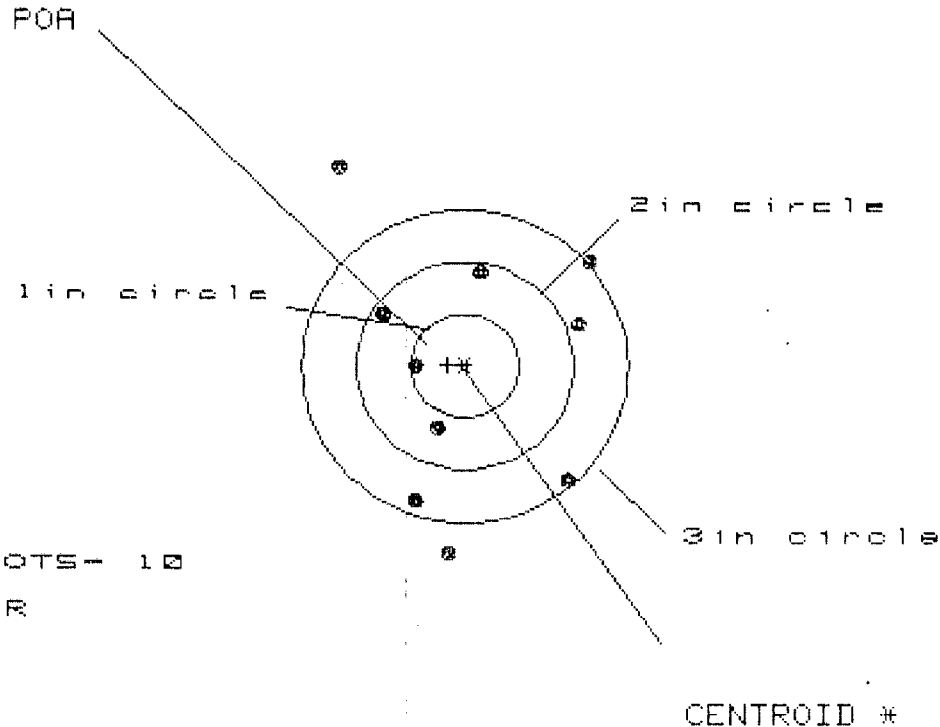
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.055	1.126	1.264
MINIMUM X	:	-1.075	-.958	-.817
MAXIMUM Y	:	1.246	1.068	1.168
MINIMUM Y	:	-1.604	-1.232	-1.131
CENTROID X	:	.347	.230	.089
CENTROID Y	:	.043	.221	.120
POA TO CENTROID in.	:	.349	.319	.150
MIN RADIUS	:	.205	.247	.147
MEAN RADIUS	:	1.116	1.007	.917
MAX RADIUS	:	1.920	1.401	1.463
HORIZONTAL SPREAD	:	2.130	2.084	2.081
VERTICAL SPREAD	:	2.850	2.300	2.300
EXTREME SPREAD	:	3.147	2.453	2.453
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 2.355

VS = 3.735

GS = 3.866

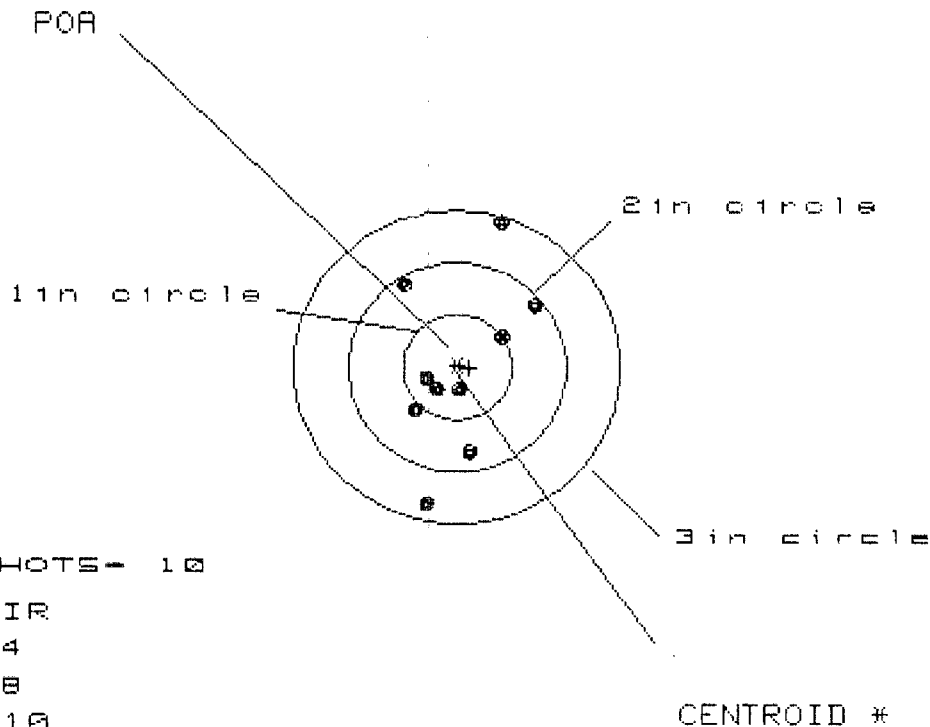
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.163	1.030	.990
MINIMUM X	:	-1.192	-.848	-.889
MAXIMUM Y	:	1.901	1.247	1.044
MINIMUM Y	:	-1.834	-1.623	-1.236
CENTROID X	:	.155	.288	.329
CENTROID Y	:	-.007	-.218	-.015
POA TO CENTROID in.	:	.155	.361	.329
MIN RADIUS	:	.452	.567	.624
MEAN RADIUS	:	1.244	1.130	1.053
MAX RADIUS	:	2.244	1.655	1.439
HORIZONTAL SPREAD	:	2.355	1.878	1.878
VERTICAL SPREAD	:	3.735	2.870	2.280
EXTREME SPREAD	:	3.866	3.175	2.819
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.135

VS= 2.756

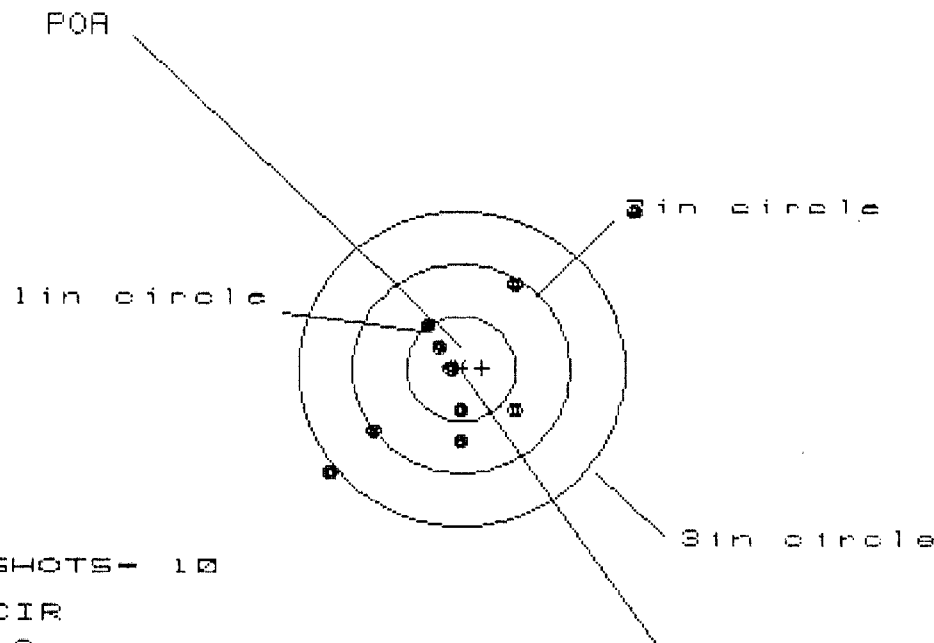
GS= 2.830

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.673	.715	.688
MINIMUM X	-.462	-.420	-.447
MAXIMUM Y	1.425	.937	.790
MINIMUM Y	-1.331	-1.172	-.799
CENTROID X	-.113	-.155	-.128
CENTROID Y	.007	-.152	-.005
POA TO CENTROID in.	.113	.217	.128
MIN RADIUS	.236	.108	.227
MEAN RADIUS	.738	.618	.564
MAX RADIUS	1.476	1.192	.922
HORIZONTAL SPREAD	1.135	1.135	1.135
VERTICAL SPREAD	2.756	2.109	1.589
EXTREME SPREAD	2.830	2.146	1.696
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.819

VS= 2.557

GS= 3.806

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.600	.678	.548
MINIMUM X	:	-1.219	-1.041	-.799
MAXIMUM Y	:	1.538	1.021	.915
MINIMUM Y	:	-1.019	-.848	-.589
CENTROID X	:	-.192	-.370	-.240
CENTROID Y	:	-.009	-.180	-.074
POA TO CENTROID in.	:	.193	.412	.251
MIN RADIUS	:	.115	.173	.087
MEAN RADIUS	:	.838	.669	.561
MAX RADIUS	:	2.220	1.343	1.066
HORIZONTAL SPREAD	:	2.819	1.719	1.347
VERTICAL SPREAD	:	2.557	1.869	1.504
EXTREME SPREAD	:	3.806	2.539	1.970
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		