C634966

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

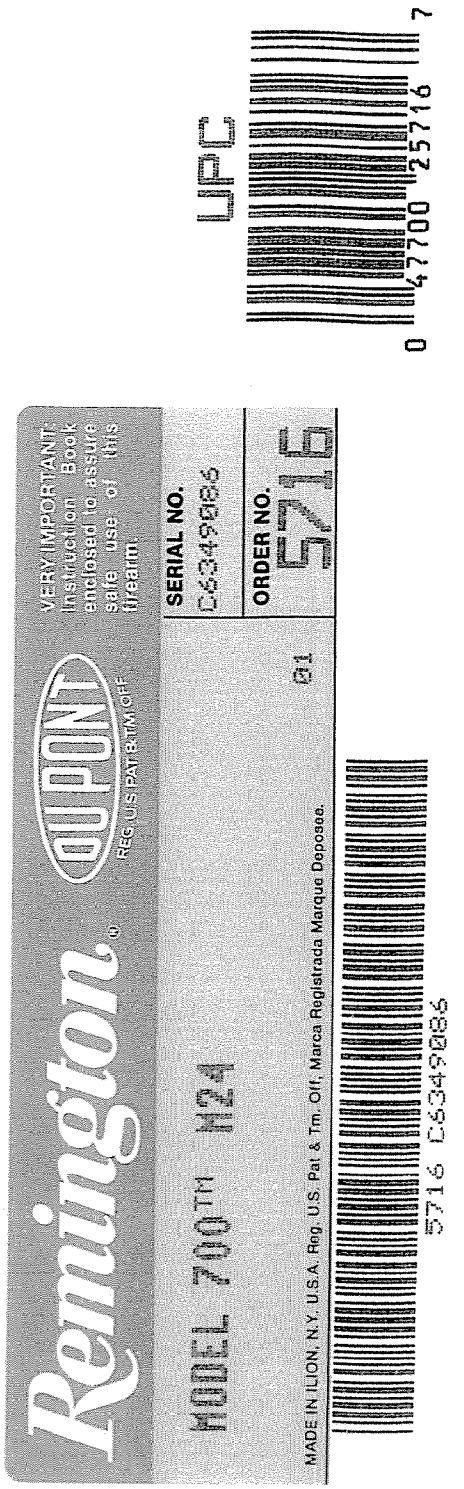
Remington

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF		Ream Ejector hole	5/23/90 RM
TEST		Polish Ejector	
TGT			
PROOF		100 Rds.	
TEST		Ok	AC
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

MOD. _____ GA. _____ CAL. _____ GUN # C6349086

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	slave brass + dent gear	
	2nd	100 Rd. OK 5-29-90	
	3rd		
	4th		

FUNCTION RD 6654 Rev 1


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT:
Instruction Book
Enclosed is to assure
Safe use of this
firearm.
MODEL 700 TM M24
SERIAL NO.
C6349085
ORDER NO.
5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
@1
5716 C6349085
UPC
0 47700 25716 7

3.00

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349086

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	90	RW
600	Proof	4 12	90	A
607	Check Headspace	4 12	90	A
610	Dis-assemble Gun	4 12	90	RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		G.S.
617	Drill and Tap Sight Holes		4/23/90	CB
618	Polish Barrel RB		4/24/90	CB
620	Apply Coatings (Barrel Action)		4/30-90	JH
	Apply Coating (Bolt)		4/30	JH
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/9/90	JH

BARBER - M24 0107501

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/9/90	DH
	G) Safety Off Force	3	3	3			5/14/90	DH
	H) Trigger Pull Test & Retainability						5/8/90	DH
	I) Firing Pin Indent	.023	.022	.0225			5/9/90	DH
	J) Assemble Stock						5/14/90	RW
	K) Assemble Swivel Studs						5/14/90	DH
	L) Attach Front and Rear Sight Assemblies						5/14/90	RW
	M) Iron Sight Alignment						5/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/14/90	RW
	O) Attach Scope to Rifle						5/15/90	DH
	P) Detach & Attach Scope 20 Times						5/15/90	DH
640	Gallery Target & Test						5-15-90	DH
	A) Time						5-15-90	DH
	B) Malfunctions						5-15-90	DH
	C) Pierced Primers						5-15-90	DH
	D) Optical Clearity of Scope						5-15-90	DH
645	Inspect for Live Ammo						5-15-90	DH
655	Final Inspection A) Headspace						6/14/90	DH
	B) Trigger Pull	2.83	2.83	2.73	2.90	2.86	6/13/90	BS
	C) Function						6/13/90	DH
660	Pack						6/19/90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349086

DATE 5/4/90

TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.28	2.46	2.83	MIN. SETTING,
PULL #2	2.55	2.28	2.43	2.83	NO AVG. OF 5
PULL #3	2.14	2.25	2.40	2.73	READINGS ACCEPT-
PULL #4	2.24	2.22	2.35	2.90	ABLE LESS THAN 2#
PULL #5	2.44	2.23	2.30	2.86	
TOTAL	11.89	11.26	11.94		
AVG.	2.378	2.252	2.388		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.36		
PULL #2	3.50	3.27		
PULL #3	3.16	3.24		
PULL #4	3.12	3.28		
PULL #5	3.35	3.37		
TOTAL	16.34	16.52		
AVG.	3.268	3.304		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.37		4.41
PULL #2	4.44	4.34		4.28
PULL #3	4.53	4.22		4.40
PULL #4	4.53	4.23		4.28
PULL #5	4.25	4.17		4.35
TOTAL	21.91	21.33		21.72
AVG.	4.382	4.266		4.344

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349086
16 May 1990

CENTROIDAL DISTANCES

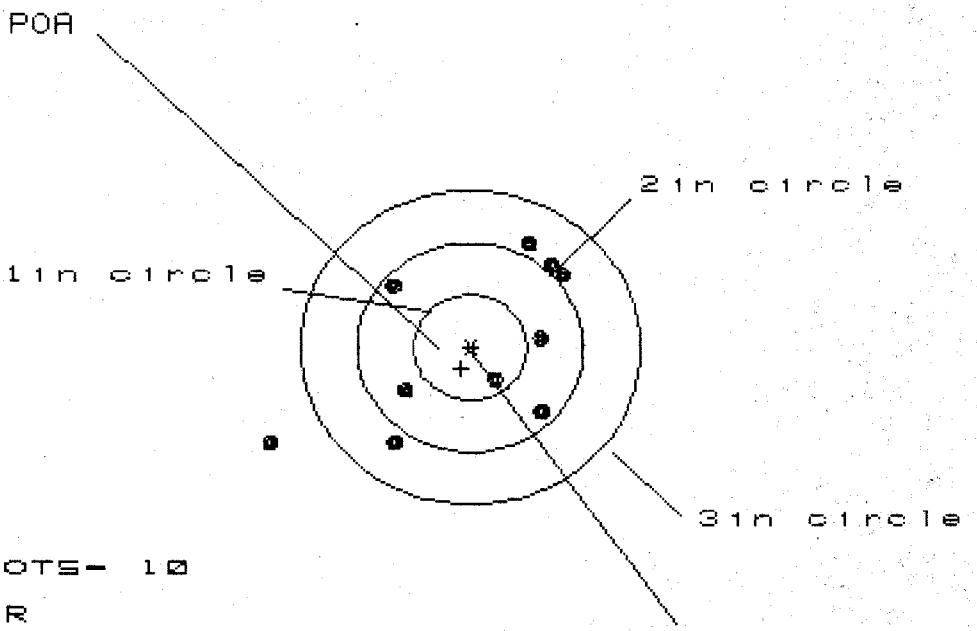
0	TO	1	.221353
1	TO	2	.359685
1	TO	3	.278568
1	TO	4	.463026
1	TO	5	.369265

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1264
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0364
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131537

THE AMR FOR THIS RIFLE IS: .9324

15 May 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6349086

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 9

HS= 2.582
VS= 1.927
GS= 3.043

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.839	.645	.542
MINIMUM X	:	-1.743	-.835	-.938
MAXIMUM Y	:	.988	.887	.757
MINIMUM Y	:	-.939	-1.040	-.816
CENTROID X	:	.081	.275	.378
CENTROID Y	:	.206	.307	.437
POA TO CENTROID in.	:	.222	.412	.578
MIN RADIUS	:	.414	.428	.342
MEAN RADIUS	:	.988	.846	.764
MAX RADIUS	:	1.966	1.331	1.079
HORIZONTAL SPREAD	:	2.582	1.480	1.480
VERTICAL SPREAD	:	1.927	1.927	1.573
EXTREME SPREAD	:	3.043	2.240	1.795
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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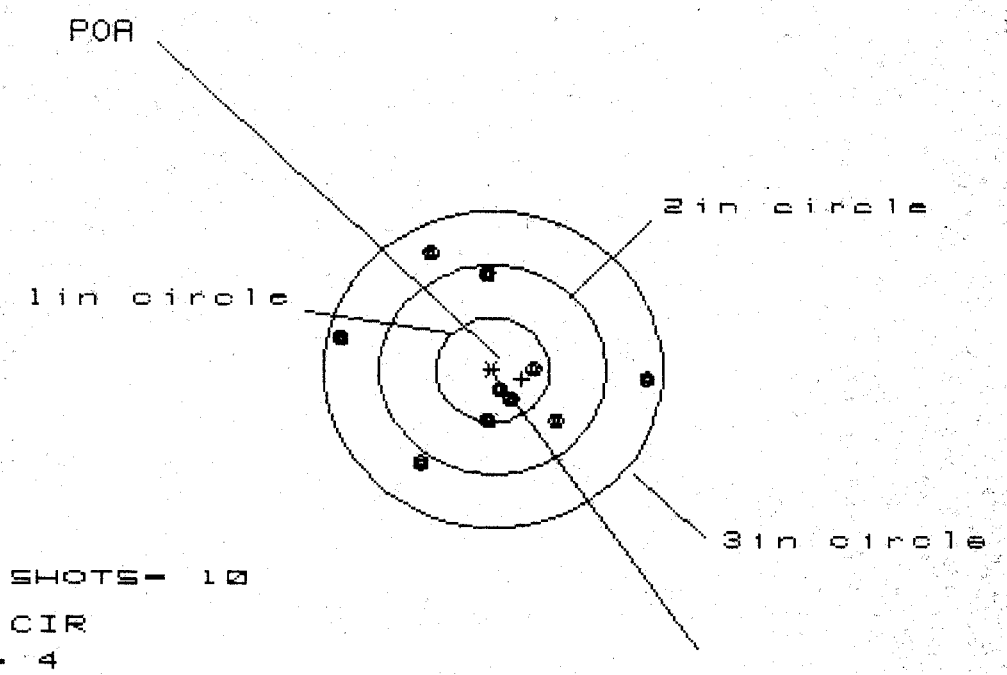
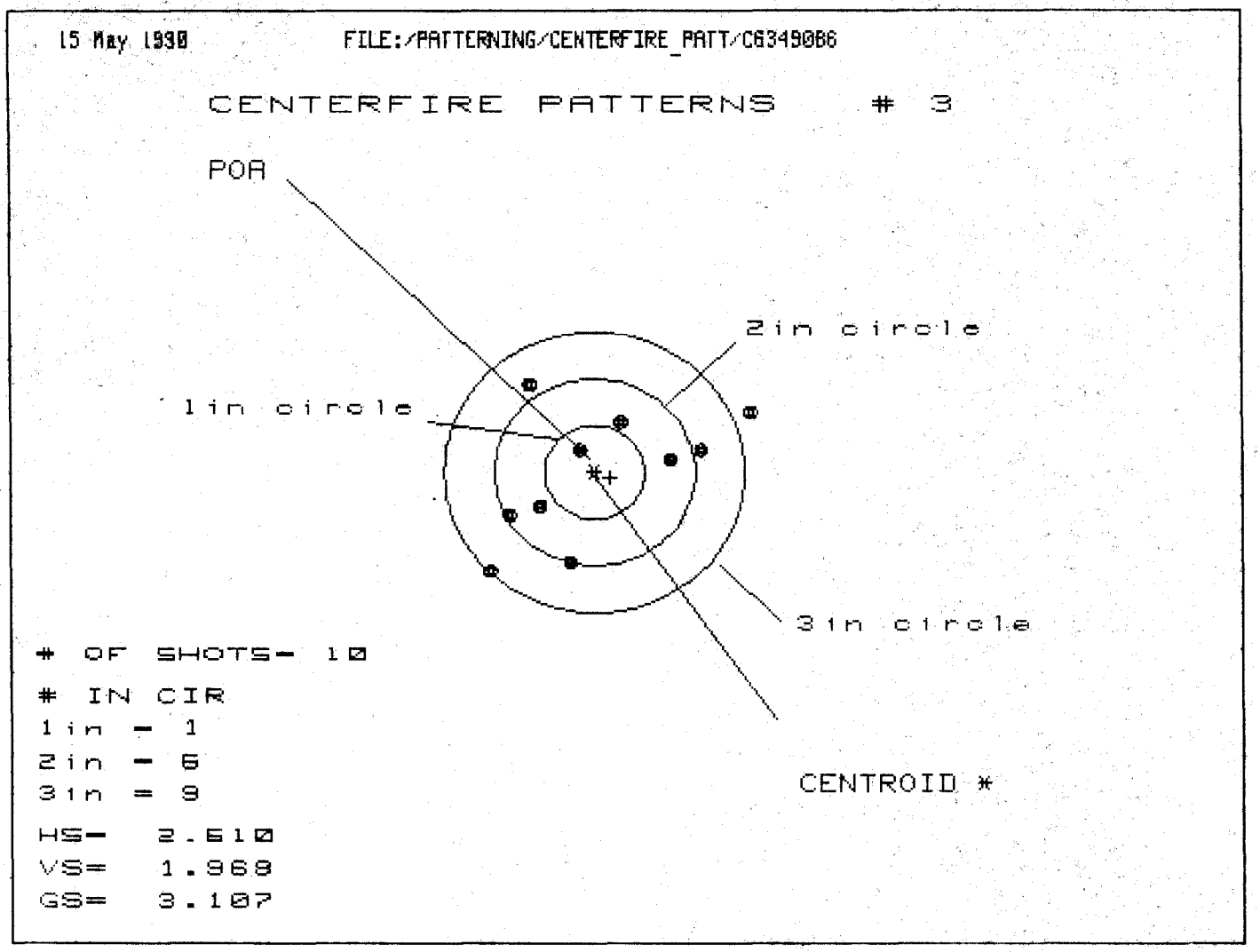
CENTERFIRE PATTERNS # 2



# OF SHOTS= 10
# IN CIR
1in = 4
2in = 6
3in = 10
HS= 2.738
VS= 1.963
GS= 2.774

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.358	1.205	.571
MINIMUM X	:	-1.380	-.821	-.670
MAXIMUM Y	:	1.129	1.165	1.153
MINIMUM Y	:	-.834	-.798	-.810
CENTROID X	:	-.257	-.104	-.255
CENTROID Y	:	.083	.047	.059
POA TO CENTROID in.	:	.270	.114	.261
MIN RADIUS	:	.186	.177	.162
MEAN RADIUS	:	.823	.722	.674
MAX RADIUS	:	1.416	1.333	1.256
HORIZONTAL SPREAD	:	2.738	2.026	1.241
VERTICAL SPREAD	:	1.963	1.963	1.963
EXTREME SPREAD	:	2.774	2.240	1.971
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.575	1.218	1.111
MINIMUM X	:	-1.035	-.860	-.795
MAXIMUM Y	:	.928	.999	.878
MINIMUM Y	:	-1.040	-.969	-1.001
CENTROID X	:	-.155	-.330	-.223
CENTROID Y	:	.058	-.013	.108
POA TO CENTROID in.	:	.166	.331	.248
MIN RADIUS	:	.346	.359	.269
MEAN RADIUS	:	.968	.871	.803
MAX RADIUS	:	1.702	1.295	1.129
HORIZONTAL SPREAD	:	2.610	2.078	1.906
VERTICAL SPREAD	:	1.968	1.968	1.879
EXTREME SPREAD	:	3.107	2.446	2.038
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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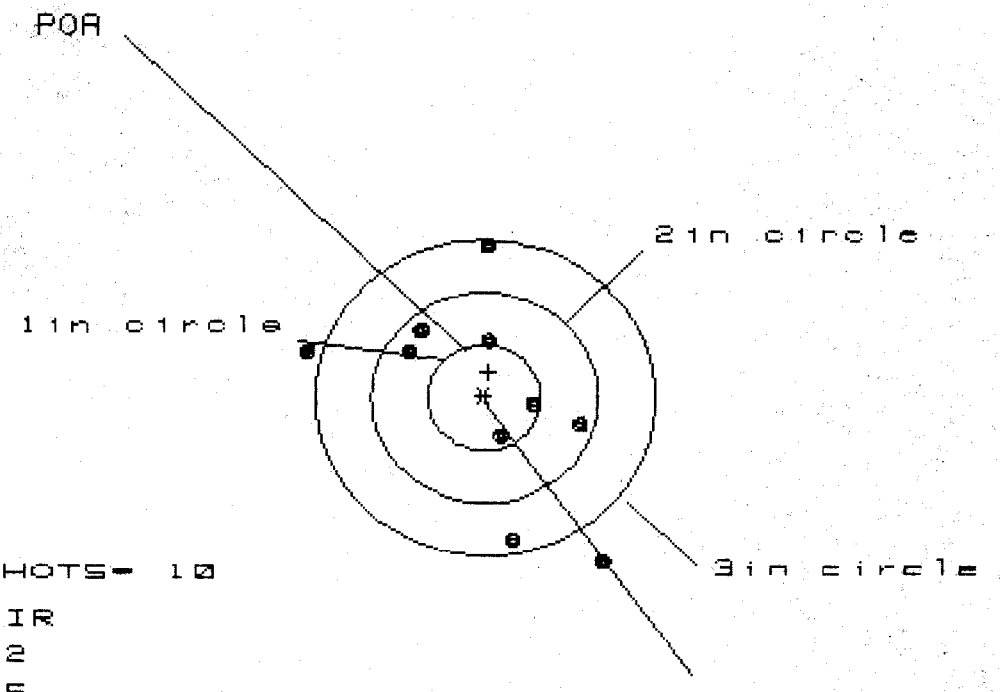
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

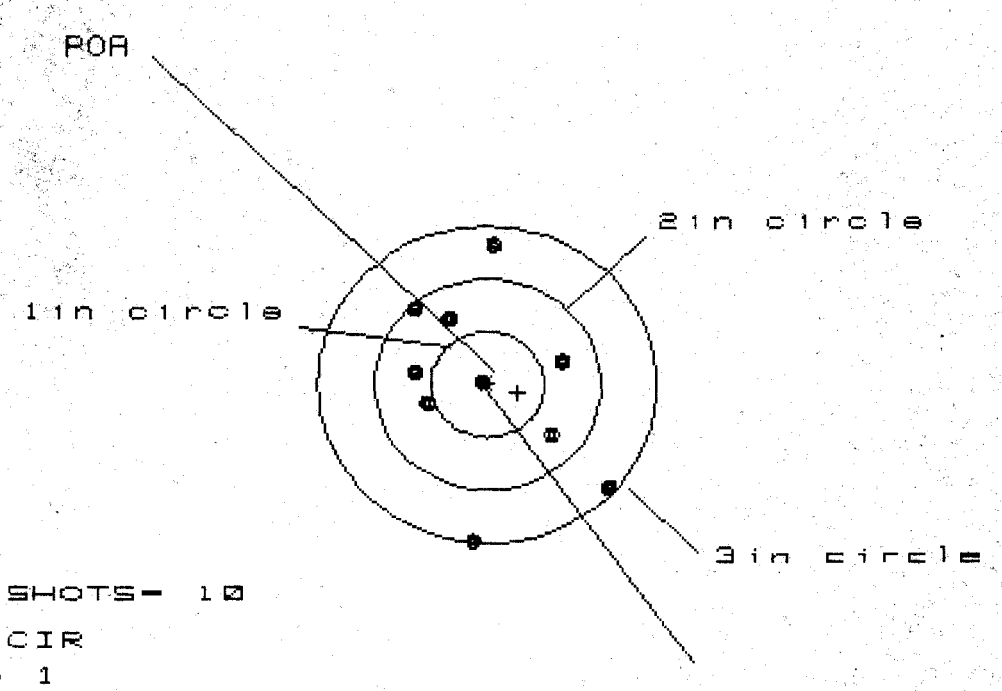
# IN CIR
1in = 2
2in = 6
3in = 8

HS= 2.552
VS= 2.988
GS= 3.258

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.006	.981	.802
MINIMUM X	:	-1.546	-1.435	-.690
MAXIMUM Y	:	1.448	1.277	1.317
MINIMUM Y	:	-1.540	-1.539	-1.499
CENTROID X	:	-.036	-.147	.032
CENTROID Y	:	-.242	-.071	-.111
POA TO CENTROID in.	:	.245	.164	.115
MIN RADIUS	:	.382	.432	.442
MEAN RADIUS	:	1.027	.920	.837
MAX RADIUS	:	1.839	1.581	1.510
HORIZONTAL SPREAD	:	2.552	2.416	1.492
VERTICAL SPREAD	:	2.988	2.816	2.816
EXTREME SPREAD	:	3.258	2.826	2.826
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

15 May 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6345086

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 1
2in = 7
3in = 10

HS= 1.733
VS= 2.812
GS= 2.815

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.087	1.075	.776
MINIMUM X	:	-.647	-.658	-.524
MAXIMUM Y	:	1.348	1.185	1.042
MINIMUM Y	:	-1.464	-1.148	-.741
CENTROID X	:	-.265	-.253	-.388
CENTROID Y	:	.077	.240	.383
POA TO CENTROID in.	:	.276	.349	.545
MIN RADIUS	:	.047	.120	.283
MEAN RADIUS	:	.856	.781	.665
MAX RADIUS	:	1.468	1.573	1.053
HORIZONTAL SPREAD	:	1.733	1.733	1.300
VERTICAL SPREAD	:	2.812	2.333	1.783
EXTREME SPREAD	:	2.815	2.562	1.850
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	