

C6649165

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

SERIAL NO.
C6649165

ORDER NO.
5716

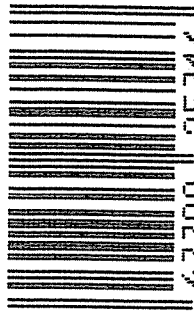
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

20



5716 C6649165

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649165

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KL
600	Proof		6/27/91	KL
607	Check Headspace		6/27/91	KL
610	Dis-assemble Gun		6/27/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KL
	C) Inspect Ejector Hole for Chamfer		8/22/91	KL
	D) Oil Firing Pin Ass'y		8/22/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	KL

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5½	8-23-91	DH		
	G) Safety Off Force	2½	2	2¼	8-23-91	DH		
	H) Trigger Pull Test & Retainability				8/23/91	SH		
	I) Firing Pin Indent	.023	.022	.023	8-23-91	DH		
	J) Assemble Stock				8/27/91	FX		
	K) Assemble Swivel Studs				8-27-91	DH		
	L) Attach Front and Rear Sight Assemblies				8/27/91	FX		
	M) Iron Sight Alignment				8/27/91	FX		
	N) Detach Front & Rear Sights & place in numbered container				8/27/91	FX		
	O) Attach Scope to Rifle				8/27/91	FX		
	P) Detach & Attach Scope 20 Times				8/27/91	FX		
640	Gallery Target & Test				8-28-91	DH		
	A) Time				8-28-91	DH		
	B) Malfunctions				8-28-91	DH		
	C) Pierced Primers				8-28-91	DH		
	D) Optical Clarity of Scope				8-28-91	DH		
645	Inspect for Live Ammo				8-28-91	DH		
655	Final Inspection				8-27-91	DH		
	A) Headspace							
	B) Trigger Pull	267	262	260	261	260	8-28-91	DH
	C) Function						8-27-91	DH
660	Pack						9-18-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6649165

DATE 8-23-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.28	2.33	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.20	2.28	2.62	
PULL #3	2.22	2.22	2.30	2.60	
PULL #4	2.37	2.21	2.20	2.61	
PULL #5	2.30	2.29	2.36	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.53		
PULL #2	3.53	3.77		
PULL #3	3.51	3.69		
PULL #4	3.48	3.68		
PULL #5	3.52	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.38		4.35
PULL #2	4.37	4.59		4.33
PULL #3	4.33	4.46		4.42
PULL #4	4.35	4.44		4.53
PULL #5	4.41	4.42		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649165
28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.374086
1 TO	2	.395153
1 TO	3	.395471
1 TO	4	.566149
1 TO	5	.338339

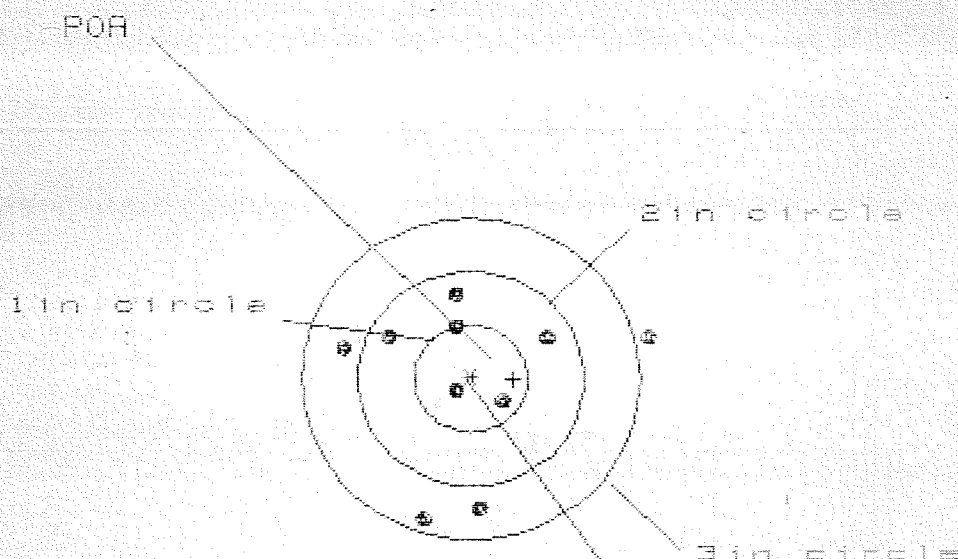
1.34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0928
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1102
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144069
THE AMR FOR THIS RIFLE IS: .9358

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649165

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.658

VS= 2.107

GS= 2.661

CENTROID *

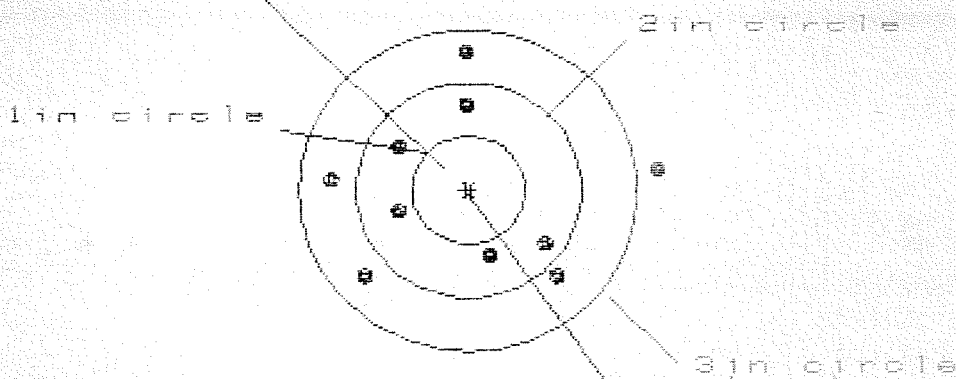
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.556	.868	.836
MINIMUM X	:	-1.102	-.929	-.961
MAXIMUM Y	:	.796	.843	.685
MINIMUM Y	:	-1.311	-1.264	-1.293
CENTROID X	:	-.374	-.547	-.515
CENTROID Y	:	.008	-.039	.119
POA TO CENTROID in.	:	.374	.549	.529
MIN RADIUS	:	.147	.058	.190
MEAN RADIUS	:	.870	.777	.694
MAX RADIUS	:	1.612	1.289	1.306
HORIZONTAL SPREAD	:	2.658	1.797	1.797
VERTICAL SPREAD	:	2.107	2.107	1.978
EXTREME SPREAD	:	2.661	2.133	1.983
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in - 0

2in - 5

3in - 9

HS- 2.951

VS- 2.132

GS- 2.956

CENTROID *

PATTERN #

2

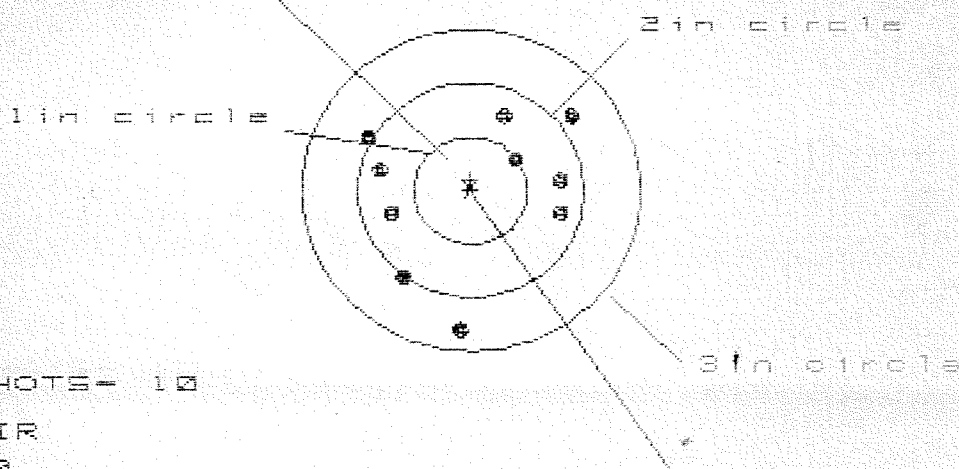
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.691	.996	1.022
MINIMUM X	-1.260	-1.072	-1.046
MAXIMUM Y	1.320	1.346	.996
MINIMUM Y	-.812	-.786	-.618
CENTROID X	.021	-.167	-.194
CENTROID Y	-.003	-.029	-.197
POA TO CENTROID in.	.021	.169	.276
MIN RADIUS	.591	.451	.392
MEAN RADIUS	1.017	.915	.842
MAX RADIUS	1.708	1.363	1.195
HORIZONTAL SPREAD	2.951	2.068	2.068
VERTICAL SPREAD	2.132	2.132	1.614
EXTREME SPREAD	2.956	2.288	2.244
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 1.770

VS= 1.993

GS= 2.213

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.887	.879	.874
MINIMUM X	:	-.883	-.891	-.781
MAXIMUM Y	:	.713	.571	.617
MINIMUM Y	:	-1.280	-.983	-.912
CENTROID X	:	.007	.015	-.094
CENTROID Y	:	-.098	.044	-.027
POA TO CENTROID in.	:	.098	.047	.098
MIN RADIUS	:	.517	.431	.561
MEAN RADIUS	:	.892	.831	.806
MAX RADIUS	:	1.282	1.162	1.044
HORIZONTAL SPREAD	:	1.770	1.770	1.655
VERTICAL SPREAD	:	1.993	1.554	1.529
EXTREME SPREAD	:	2.213	2.158	1.825
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.876

VS= 2.439

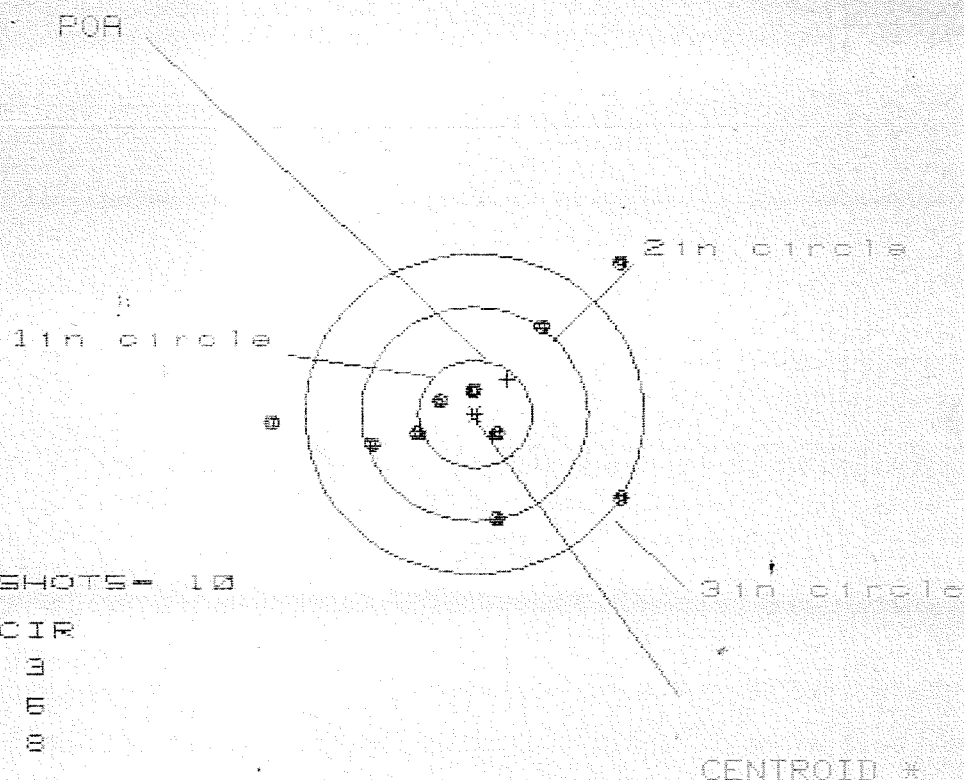
GS= 2.481

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	.965	1.051
MINIMUM X	-.877	-.911	-.825
MAXIMUM Y	1.084	.933	1.027
MINIMUM Y	-1.355	-.942	-.848
CENTROID X	.173	.207	.121
CENTROID Y	-.138	.013	-.082
POB TO CENTROID in.	.221	.207	.146
MIN RADIUS	.418	.547	.492
MEAN RADIUS	.940	.882	.856
MAX RADIUS	1.388	1.220	1.093
HORIZONTAL SPREAD	1.876	1.876	1.876
VERTICAL SPREAD	2.439	1.875	1.875
EXTREME SPREAD	2.481	2.238	1.998
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 3.154

VS = 2.374

GS = 3.517

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.319	1.402	1.190
MINIMUM X	:	-1.845	-1.698	-1.958
MAXIMUM Y	:	1.410	.970	.974
MINIMUM Y	:	-.964	-.807	-.803
CENTROID X	:	-.291	-.438	-.226
CENTROID Y	:	-.320	-.477	-.481
POA TO CENTROID in.	:	.433	.647	.531
MIN RADIUS	:	.206	.326	.169
MEAN RADIUS	:	.960	.837	.726
MAX RADIUS	:	1.931	1.698	1.323
HORIZONTAL SPREAD	:	3.164	3.100	2.148
VERTICAL SPREAD	:	2.374	1.777	1.777
EXTREME SPREAD	:	3.517	3.160	2.196
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		