

C6611403

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ M24

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

SERIAL NO.
C6611403

ORDER NO.
5716

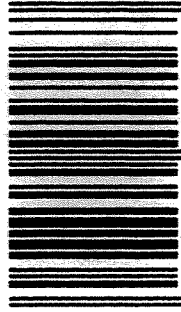
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611403

UPC



0 47700 25716 7

M-24

GEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611403

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GS
617	Drill and Tap Sight Holes	1 30	91	LB
618	Polish Barrel <i>LB</i>	1 30	91	LB
620	Apply Coatings (Barrel Action)		2-10-91	LB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/13/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/13/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/13/91	WB
	I) Firing Pin Indent	.0215	.0215	.0215			2/13/91	WB
	J) Assemble Stock						2/14/91	RW
	K) Assemble Swivel Studs						2-25-91	AC
	L) Attach Front and Rear Sight Assemblies						2/14/91	RW
	M) Iron Sight Alignment						2/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/14/91	RW
	O) Attach Scope to Rifle						2/14/91	RW
	P) Detach & Attach Scope 20 Times						2/14/91	RW
640	Gallery Target & Test						2-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-14-91	NF
655	Final Inspection							
	A) Headspace						2-25-91	AC
	B) Trigger Pull	2.28	2.43	2.46	2.40	2.46	2/21/91	WB
	C) Function						2-25-91	AC
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. 06611403

DATE 2/13/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.30	2.28	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.30	2.33	2.43	
PULL #3	2.29	2.37	2.38	2.46	
PULL #4	2.30	2.21	2.21	2.40	
PULL #5	2.23	2.24	2.27	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.29		
PULL #2	3.29	3.17		
PULL #3	3.34	3.25		
PULL #4	3.24	3.35		
PULL #5	3.22	3.50		
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	4.39		4.43
PULL #2	4.37	4.30		4.37
PULL #3	4.48	4.26		4.43
PULL #4	4.35	4.40		4.36
PULL #5	4.51	4.32		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611403
15 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.0834386
1 TO	2	.180546
1 TO	3	.268226
1 TO	4	.223002
1 TO	5	.121491

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1312
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132902

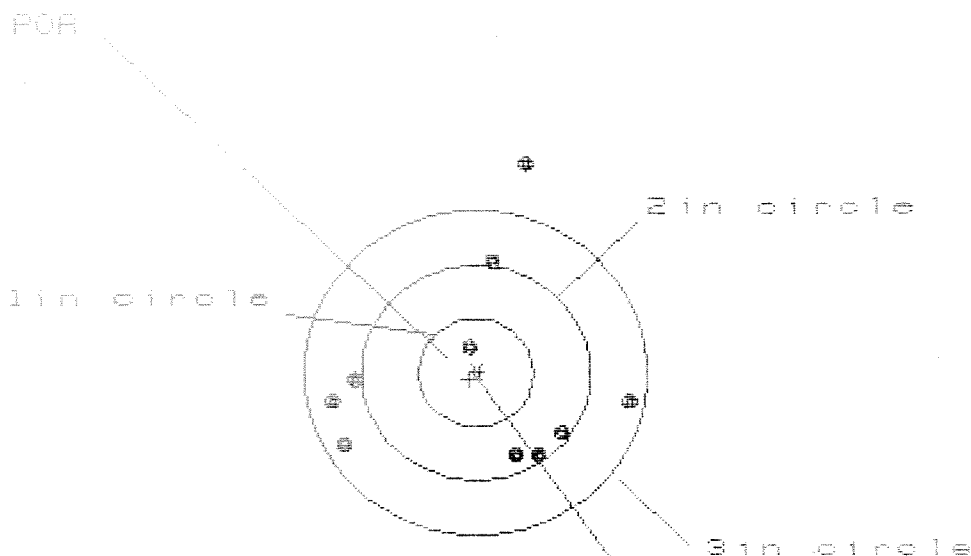
THE AMP FOR THIS RIFLE IS: .9084

15 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6611403

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.586

VS= 2.725

GS= 3.023

CENTROID #

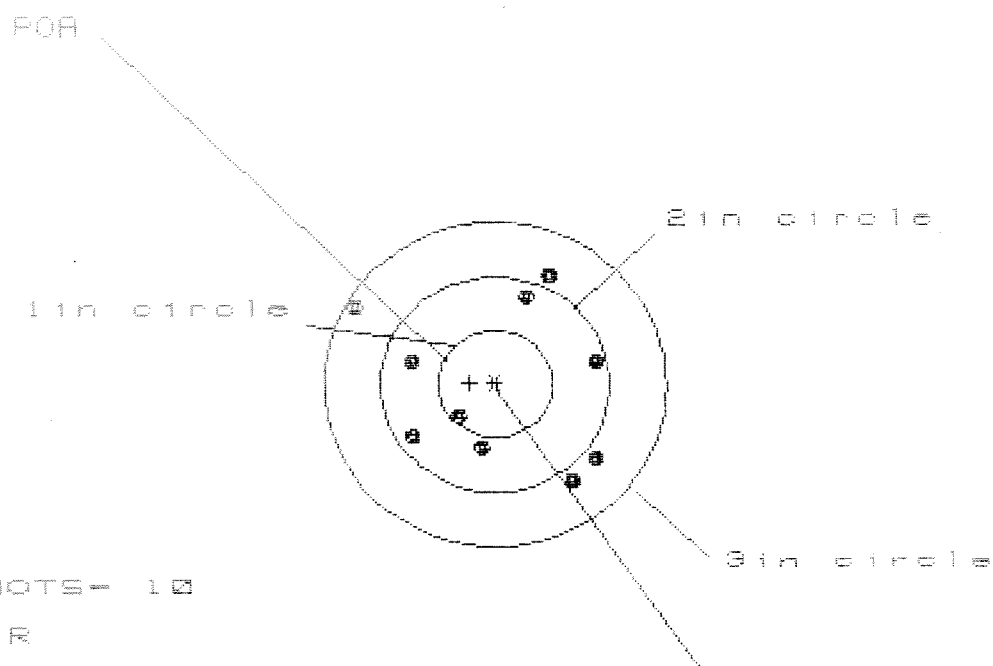
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.298	1.343	1.003
MINIMUM X	-1.288	-1.243	-1.075
MAXIMUM Y	1.931	1.291	1.281
MINIMUM Y	-0.794	-0.580	-0.590
CENTROID X	.059	.014	-.154
CENTROID Y	.059	-.156	-.146
POR TO CENTROID in.	.083	.157	.212
MIN RADIUS	.298	.505	.517
MEAN RADIUS	1.111	1.000	.952
MAX RADIUS	1.973	1.346	1.322
HORIZONTAL SPREAD	2.586	2.586	2.078
VERTICAL SPREAD	2.725	1.871	1.871
EXTREME SPREAD	3.023	2.587	2.147
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

15 Feb 1991

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.073

VS= 1.907

GS= 2.526

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.744	.781
MINIMUM X	-1.196	-.899	-.862
MAXIMUM Y	1.035	1.119	1.018
MINIMUM Y	-.872	-.788	-.648
CENTROID X	.225	.358	.321
CENTROID Y	-.012	-.096	-.236
POA TO CENTROID in.	.225	.371	.398
MIN RADIUS	.423	.486	.407
MEAN RADIUS	.923	.860	.799
MAX RADIUS	1.413	1.158	1.042
HORIZONTAL SPREAD	2.073	1.643	1.643
VERTICAL SPREAD	1.907	1.907	1.666
EXTREME SPREAD	2.526	1.970	1.871
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

15 Feb 1981

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.156

VS= 2.899

GS= 3.372

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.194	1.294	1.061
MINIMUM X	-1.962	-1.862	-1.424
MAXIMUM Y	1.136	.940	.918
MINIMUM Y	-1.763	-.877	-.899
CENTROID X	.211	.111	.344
CENTROID Y	-.162	.034	.056
POA TO CENTROID in.	.266	.116	.348
MIN RADIUS	.361	.335	.387
MEAN RADIUS	1.132	1.021	.885
MAX RADIUS	1.979	1.870	1.434
HORIZONTAL SPREAD	3.156	3.156	2.485
VERTICAL SPREAD	2.899	1.817	1.817
EXTREME SPREAD	3.372	3.234	2.591
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

15 Feb 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 6

2 in - 8

3 in - 10

HS- 2.753

VS- .911

GS- 2.754

CENTROID #

PATTERN #

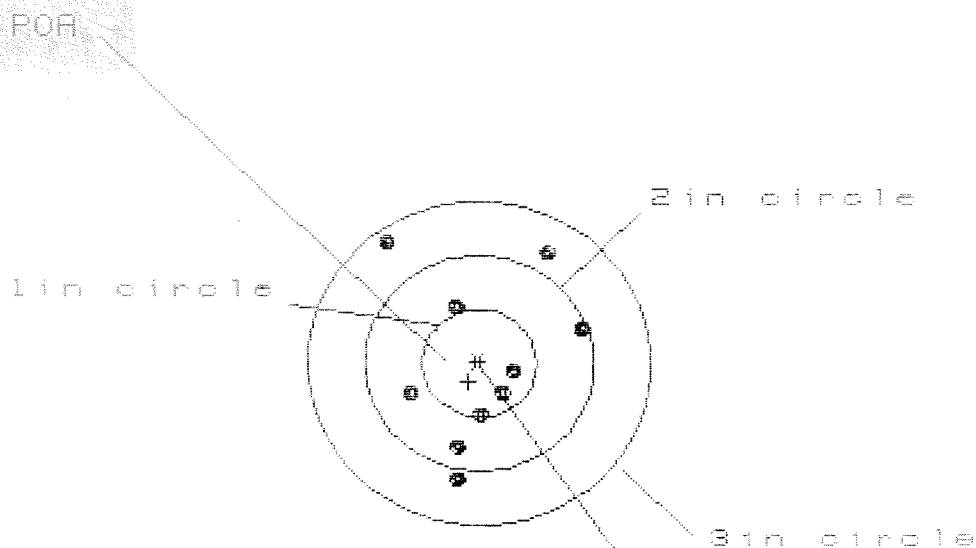
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.385	1.012	.860
MINIMUM X	-1.368	-1.214	-.392
MAXIMUM Y	.489	.468	.450
MINIMUM Y	-.422	-.443	-.461
CENTROID X	.060	-.094	.058
CENTROID Y	-.164	-.143	-.125
POA TO CENTROID in.	.174	.171	.138
MIN RADIUS	.043	.094	.037
MEAN RADIUS	.592	.497	.391
MAX RADIUS	1.397	1.223	.866
HORIZONTAL SPREAD	2.753	2.226	1.252
VERTICAL SPREAD	.911	.911	.911
EXTREME SPREAD	2.754	2.227	1.330
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

15 Feb 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.679

VS= 2.213

GS= 2.293

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.852	.761	.829
MINIMUM X	:	-.827	-.677	-.689
MAXIMUM Y	:	1.174	1.190	.785
MINIMUM Y	:	-1.039	-.909	-.760
CENTROID X	:	.101	.192	.123
CENTROID Y	:	.173	.043	-.106
POA TO CENTROID in.	:	.200	.197	.163
MIN RADIUS	:	.272	.185	.204
MEAN RADIUS	:	.784	.674	.570
MAX RADIUS	:	1.436	1.312	1.001
HORIZONTAL SPREAD	:	1.679	1.438	1.438
VERTICAL SPREAD	:	2.213	2.099	1.545
EXTREME SPREAD	:	2.293	2.272	1.705
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	