

BARBER - M24 0004632

C6522289

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522289

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/27/90	K.S.
600	Proof		4/27/90	K.S.
607	Check Headspace		4/27/90	K.S.
610	Dis-assemble Gun		4/27/90	K.S.
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	G.L.
617	Drill and Tap Sight Holes		7/11/90	K.B.
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7/23/90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/90	KS
	C) Inspect Ejector Hole for Chamfer		8/1/90	KS
	D) Oil Firing Pin Ass'y		8/1/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/25/90	YCL

BARBER - M24 0004634

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/27/90	JH
	G) Safety Off Force	3	3	3			7/27/90	JH
	H) Trigger Pull Test & Retainability						8/25/90	JH
	I) Firing Pin Indent	.023	.023	.023			7/27/90	JH
	J) Assemble Stock						8/2/90	KS
	K) Assemble Swivel Studs						8/30/90	JS
	L) Attach Front and Rear Sight Assemblies						8/2/90	KS
	M) Iron Sight Alignment						8/2/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/2/90	KS
	O) Attach Scope to Rifle						8/2/90	KS
	P) Detach & Attach Scope 20 Times						8/2/90	KS
640	Gallery Target & Test						8-8-90	DH
	A) Time						8-8-90	DH
	B) Malfunctions						8-8-90	DH
	C) Pierced Primers						8-8-90	DH
	D) Optical Clarity of Scope						8-8-90	DH
645	Inspect for Live Ammo						8-8-90	DH
655	Final Inspection							
	A) Headspace						8/30/90	JS
	B) Trigger Pull	2.60	2.45	2.40	2.44	2.15	8/25/90	JH
	C) Function						8/30/90	JS
660	Pack						9/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C65 22289

DATE 8/25/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.37	2.45	2.50	MIN. SETTING,
PULL #2	2.44	2.53	2.51	2.45	NO AVG. OF 5
PULL #3	2.46	2.13	2.32	2.40	READINGS ACCEPT-
PULL #4	2.44	2.37	2.11	2.44	ABLE LESS THAN 2#
PULL #5	2.46	2.26	2.50	2.15	
TOTAL	12.20	11.66	11.89	11.94	
AVG.	2.44	2.332	2.378	2.388	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.33		
PULL #2	3.28	3.29		
PULL #3	3.24	3.38		
PULL #4	3.33	3.07		
PULL #5	3.43	3.48		
TOTAL	16.40	16.55		
AVG.	3.28	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.39		4.48
PULL #2	4.50	4.38		4.36
PULL #3	4.40	4.36		4.50
PULL #4	4.21	4.33		4.43
PULL #5	4.48	4.35		4.33
TOTAL	22.00	21.81		22.10
AVG.	4.4	4.362		4.42

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522289
8 Aug 1990

CENTROIDAL DISTANCES

0 TO 1	.657492
1 TO 2	.767
1 TO 3	.547308
1 TO 4	.7042
1 TO 5	.916057

+ 1
5 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .6946
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1282
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .706332
THE AMR FOR THIS RIFLE IS: .7988

8 Aug 1998

FILE: /PATTERNING/CENTERFIRE_PATT/06522289

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.376

VS= 1.510

GS= 1.609

CENTROID #

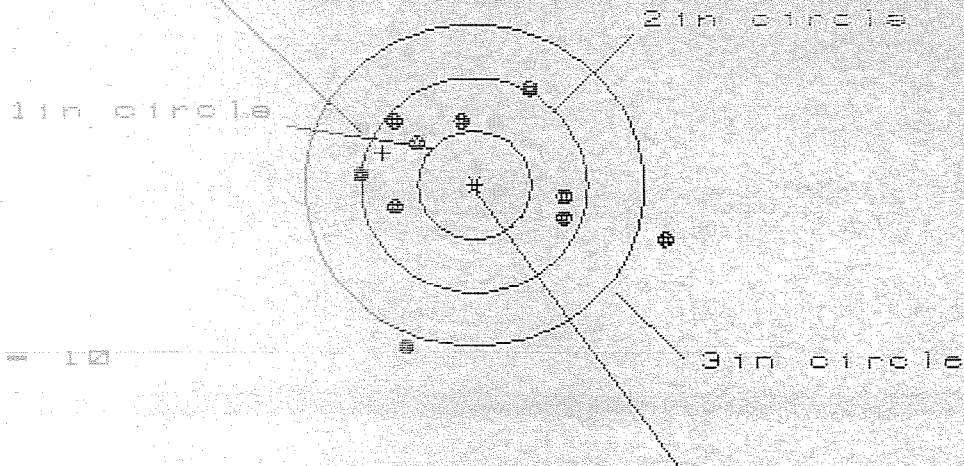
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.638	.657	.567
MINIMUM X	-.738	-.719	-.628
MAXIMUM Y	.661	.567	.526
MINIMUM Y	-.849	-.687	-.728
CENTROID X	.514	.495	.585
CENTROID Y	.410	.504	.545
POA TO CENTROID in.	.657	.706	.799
MIN RADIUS	.270	.298	.230
MEAN RADIUS	.635	.603	.563
MAX RADIUS	.866	.791	.764
HORIZONTAL SPREAD	1.376	1.376	1.195
VERTICAL SPREAD	1.510	1.254	1.254
EXTREME SPREAD	1.609	1.427	1.427
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522289

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 8

HS= 2.676

VS= 2.338

GS= 2.739

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.675	.960	.910
MINIMUM X	-1.001	-.814	-.864
MAXIMUM Y	.875	.821	.632
MINIMUM Y	-1.463	-1.517	-.502
CENTROID X	.809	.622	.672
CENTROID Y	-.298	-.244	-.055
POA TO CENTROID in.	.862	.669	.674
MIN RADIUS	.594	.419	.355
MEAN RADIUS	.984	.863	.742
MAX RADIUS	1.744	1.567	1.026
HORIZONTAL SPREAD	2.676	1.774	1.774
VERTICAL SPREAD	2.338	2.338	1.134
EXTREME SPREAD	2.739	2.552	1.794
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

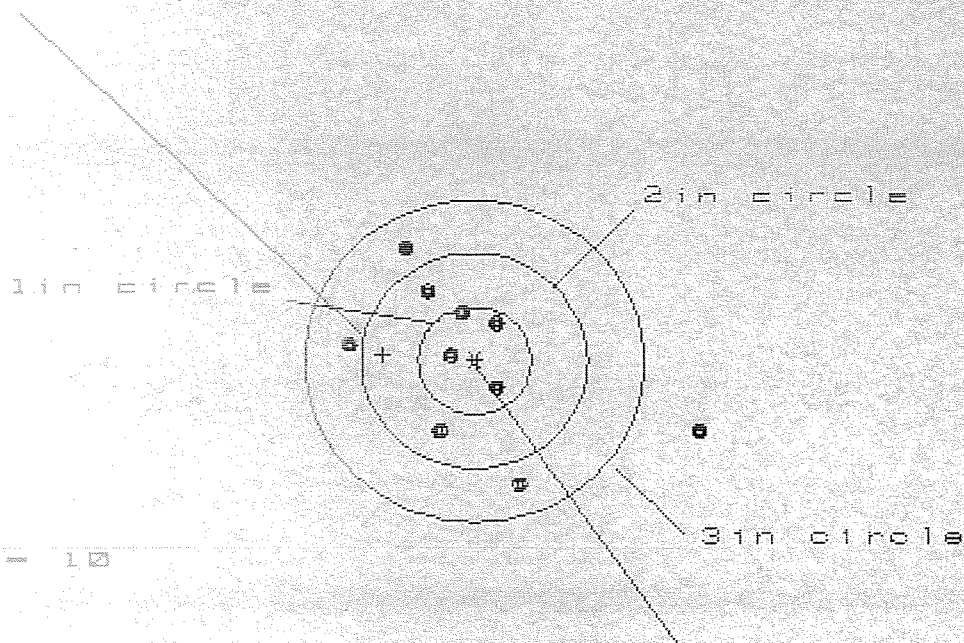
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FILE: PATTERNING/CENTERFIRE_PATT/C65222B9

CENTERFIRE PATTERNS

3

POA



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 3.046

VS= 2.133

GS= 3.133

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.978	.620	.567
MINIMUM X	-1.068	-.848	-.901
MAXIMUM Y	1.023	.954	.702
MINIMUM Y	-1.110	-1.179	-1.060
CENTROID X	.809	.589	.642
CENTROID Y	-.051	.018	-.101
POA TO CENTROID in.	.811	.590	.650
MIN RADIUS	.206	.059	.073
MEAN RADIUS	.849	.678	.634
MAX RADIUS	2.072	1.332	1.202
HORIZONTAL SPREAD	3.046	1.468	1.468
VERTICAL SPREAD	2.133	2.133	1.762
EXTREME SPREAD	3.133	2.373	1.951
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

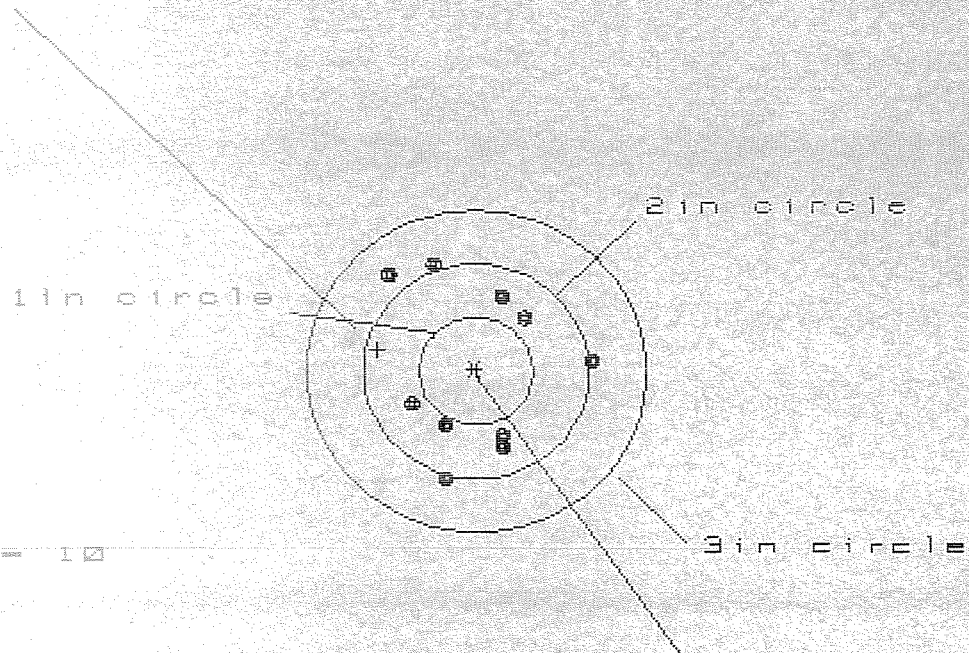
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FILE: /PATTERNING/CENTERFIRE_PATT/C6522289

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 1.807

VS= 1.951

GS= 1.988

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.063	.980	.471
MINIMUM X	:	-.744	-.634	-.511
MAXIMUM Y	:	.970	1.069	1.039
MINIMUM Y	:	-.981	-.882	-.862
CENTROID X	:	.871	.954	.831
CENTROID Y	:	-.197	-.296	-.316
POA TO CENTROID in.	:	.893	.998	.889
MIN RADIUS	:	.594	.519	.468
MEAN RADIUS	:	.823	.768	.727
MAX RADIUS	:	1.161	1.155	1.134
HORIZONTAL SPREAD	:	1.807	1.614	.982
VERTICAL SPREAD	:	1.951	1.951	1.951
EXTREME SPREAD	:	1.988	1.952	1.952
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522289

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 10

3in = 10

HS= 1.624

VS= 1.667

GS= 1.730

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.929

.876

.821

MINIMUM X

-.695

-.748

-.803

MAXIMUM Y

.846

.755

.586

MINIMUM Y

-.821

-.829

-.735

CENTROID X

.470

.523

.578

CENTROID Y

-.505

-.414

-.508

POA TO CENTROID in.

.690

.667

.770

MIN RADIUS

.257

.188

.148

MEAN RADIUS

.703

.659

.611

MAX RADIUS

.952

1.003

.994

HORIZONTAL SPREAD

1.624

1.624

1.624

VERTICAL SPREAD

1.667

1.584

1.321

EXTREME SPREAD

1.730

1.730

1.730

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

10

NUMBER IN THREE INCH CIRCLE =

10

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

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

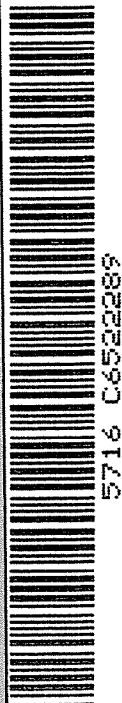
MODEL 700TM H24

SERIAL NO. C6522289

ORDER NO. 5716

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

Q1



LPC

