

4

C6498842

Fig 178

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



BARBER - M24 0008756

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

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

MODEL 700TM M24

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

SERIAL NO. C6498842

ORDER NO. 5716

01

5716 C6498842

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498842

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9 90		RW
600	Proof	5 9 90		RW
607	Check Headspace	5 9 90		RW
610	Dis-assemble Gun	5 9 90		RW
612	Magnaflux Barrel Action	5-15-90		KE R
	Magnaflux Bolt	5-15-90		KE R
615	Rollmark Caliber	5-15-90		GS
617	Drill and Tap Sight Holes		5/17/90	LB
618	Polish Barrel RLB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/90	JH

BARBER - M24 0008758

BARBER - M24 0008758								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	5/31/90	WB		
	G) Safety Off Force	2	2	2	5/31/90	WB		
	H) Trigger Pull Test & Retainability				5/31/90	JH		
	I) Firing Pin Indent	.025	.0245	.0245	5/31/90	WB		
	J) Assemble Stock				6/1/90	RW		
	K) Assemble Swivel Studs				6/13/90	JH		
	L) Attach Front and Rear Sight Assemblies				6/1/90	RW		
	M) Iron Sight Alignment				6/1/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				6/1/90	RW		
	O) Attach Scope to Rifle				6/1/90	WB		
	P) Detach & Attach Scope 20 Times				6/1/90	WB		
640	Gallery Target & Test				6-4-90	JH		
	A) Time				"	JH		
	B) Malfunctions				"	JH		
	C) Pierced Primers				"	JH		
	D) Optical Clarity of Scope				"	JH		
645	Inspect for Live Ammo				6-4-90	JH		
655	Final Inspection							
	A) Headspace				6/13/90	JH		
	B) Trigger Pull	2.73	2.74	2.80	2.83	2.77	6/13/90	JGS
	C) Function						6/13/90	JH
660	Pack						6-19-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 06498842

DATE 5/31/90

TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.39	2.40	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.34	2.41	2.74	
PULL #3	2.41	2.33	2.30	2.80	
PULL #4	2.36	2.42	2.33	2.83	
PULL #5	2.35	2.41	2.41	2.77	
TOTAL	12.07	11.89	11.85		
AVG.	2.414	2.378	2.37		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.17		
PULL #2	3.24	3.21		
PULL #3	3.23	3.22		
PULL #4	3.21	3.46		
PULL #5	3.18	3.11		
TOTAL	16.11	15.87		
AVG.	3.222	3.174		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.27		4.56
PULL #2	4.24	4.27		4.28
PULL #3	4.15	4.29		4.26
PULL #4	4.28	4.26		4.23
PULL #5	4.27	4.25		4.26
TOTAL	21.24	21.34		21.29
AVG.	4.248	4.268		4.258

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498842
6 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.389955
1 TO	2	.643469
1 TO	3	.0490408
1 TO	4	.475299
1 TO	5	.0461736

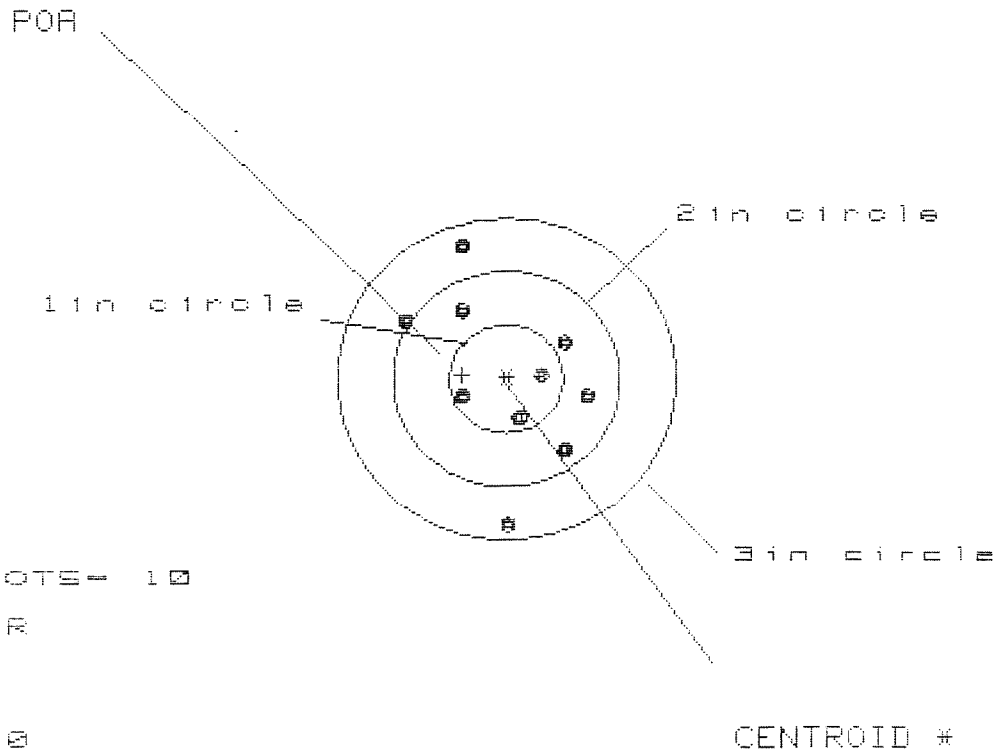
2 1/2 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1648
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0398
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169588
THE AMR FOR THIS RIFLE IS: .7346

5 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498842

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.628

VS = 2.533

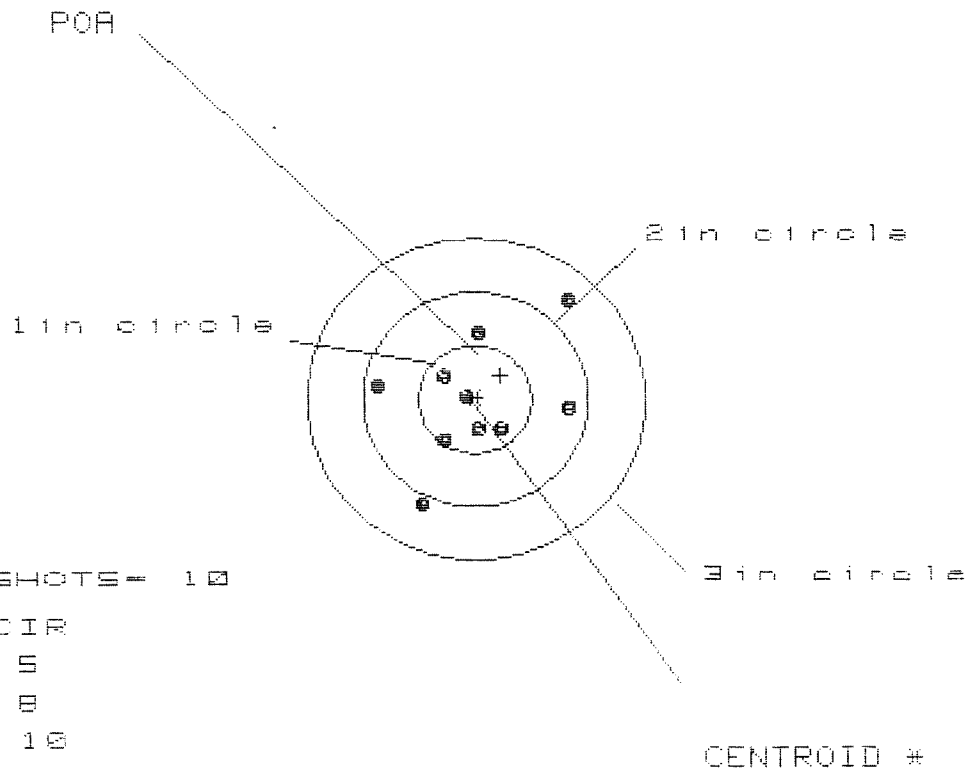
GS = 2.563

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.708	.708	.658
MINIMUM X	:	-.920	-.920	-.970
MAXIMUM Y	:	1.202	1.054	.601
MINIMUM Y	:	-1.331	-.820	-.688
CENTROID X	:	.388	.388	.438
CENTROID Y	:	-.039	.109	-.023
POA TO CENTROID in.	:	.390	.403	.439
MIN RADIUS	:	.304	.308	.252
MEAN RADIUS	:	.773	.711	.635
MAX RADIUS	:	1.331	1.127	1.101
HORIZONTAL SPREAD	:	1.628	1.628	1.628
VERTICAL SPREAD	:	2.533	1.874	1.289
EXTREME SPREAD	:	2.563	2.071	1.852
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

5 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498842

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.692

VS= 1.813

GS= 2.234

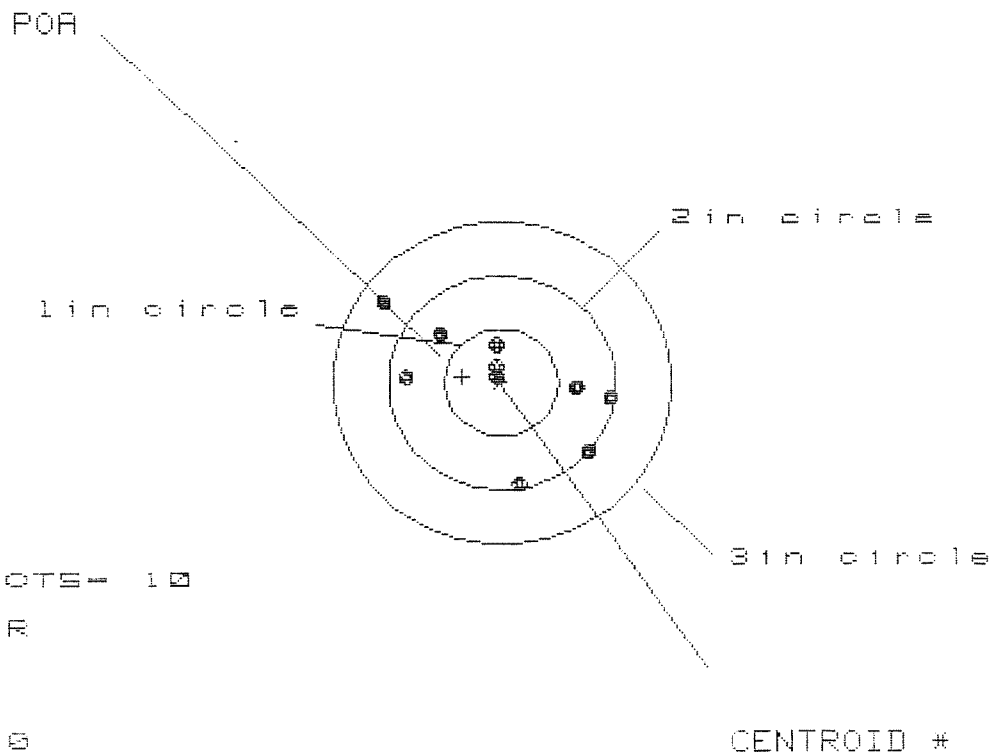
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.802	.891	.838
MINIMUM X	:	-.890	-.801	-.854
MAXIMUM Y	:	.885	.728	.624
MINIMUM Y	:	-.928	-.830	-.935
CENTROID X	:	-.228	-.317	-.264
CENTROID Y	:	-.225	-.323	-.219
POA TO CENTROID in.	:	.320	.452	.343
MIN RADIUS	:	.040	.093	.029
MEAN RADIUS	:	.605	.530	.473
MAX RADIUS	:	1.189	.931	.868
HORIZONTAL SPREAD	:	1.692	1.692	1.692
VERTICAL SPREAD	:	1.813	1.558	.959
EXTREME SPREAD	:	2.234	1.715	1.715
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Jun 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.288

VS= 1.709

GS= 2.204

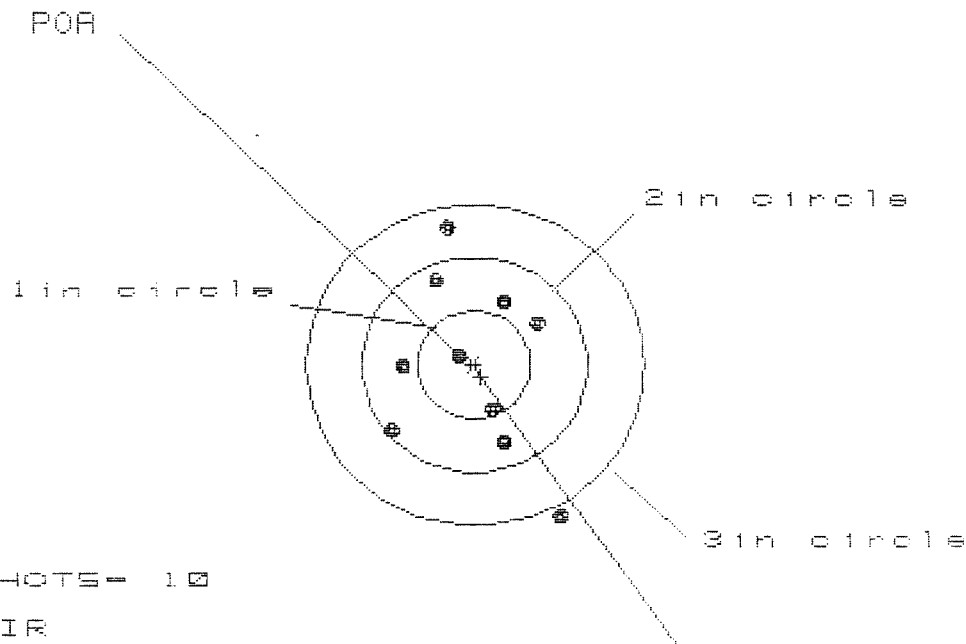
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.868	.713
MINIMUM X	:	-1.008	-.978	-.869
MAXIMUM Y	:	.744	.569	.562
MINIMUM Y	:	-.965	-.883	-.890
CENTROID X	:	.342	.454	.345
CENTROID Y	:	-.056	-.138	-.131
POA TO CENTROID in.	:	.346	.474	.369
MIN RADIUS	:	.069	.208	.134
MEAN RADIUS	:	.698	.654	.611
MAX RADIUS	:	1.253	.989	.907
HORIZONTAL SPREAD	:	1.988	1.846	1.582
VERTICAL SPREAD	:	1.709	1.452	1.452
EXTREME SPREAD	:	2.204	1.857	1.727
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Jun 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.468

VS= 2.732

GS= 2.889

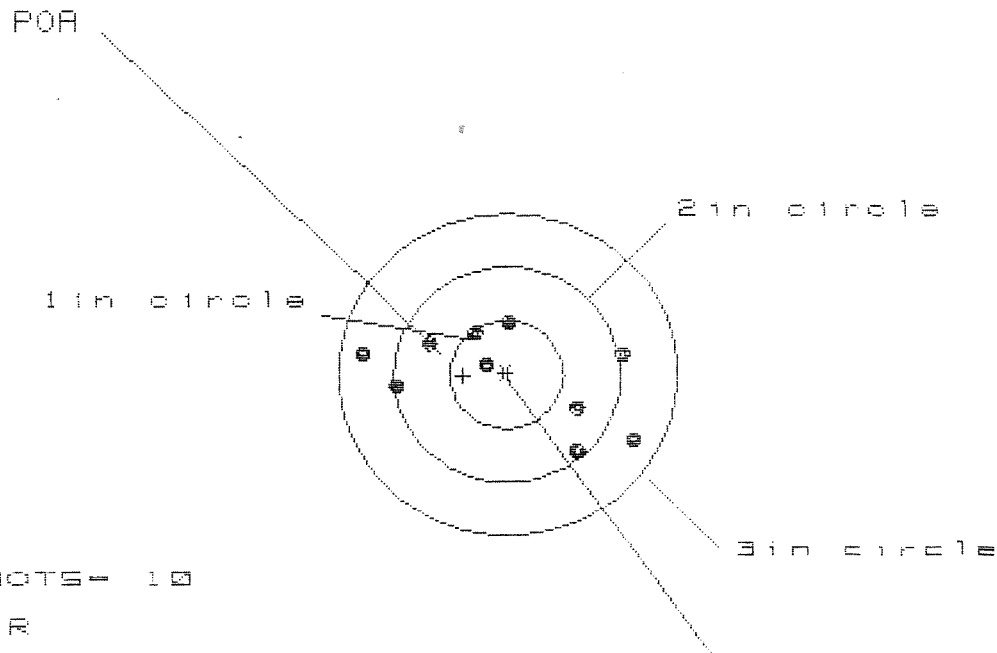
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.749	.629	.616
MINIMUM X	:	-.719	-.636	-.649
MAXIMUM Y	:	1.303	1.144	.731
MINIMUM Y	:	-1.429	-.830	-.687
CENTROID X	:	-.062	-.145	-.132
CENTROID Y	:	.114	.273	.130
POA TO CENTROID in.	:	.130	.309	.185
MIN RADIUS	:	.188	.137	.117
MEAN RADIUS	:	.790	.684	.613
MAX RADIUS	:	1.613	1.149	.885
HORIZONTAL SPREAD	:	1.468	1.265	1.265
VERTICAL SPREAD	:	2.732	1.974	1.418
EXTREME SPREAD	:	2.889	2.027	1.626
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Jun 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.364

VS= 1.233

GS= 2.518

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.097	.956	.967
MINIMUM X	:	-1.267	-1.128	-1.008
MAXIMUM Y	:	.521	.546	.469
MINIMUM Y	:	-.712	-.687	-.764
CENTROID X	:	.384	.525	.405
CENTROID Y	:	.007	-.018	.059
POA TO CENTROID in.	:	.384	.525	.409
MIN RADIUS	:	.168	.306	.169
MEAN RADIUS	:	.807	.759	.682
MAX RADIUS *	:	1.287	1.138	1.017
HORIZONTAL SPREAD	:	2.364	2.084	1.975
VERTICAL SPREAD	:	1.233	1.233	1.233
EXTREME SPREAD	:	2.518	2.157	1.992
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	