

C6594546

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.

MODEL 700™ H24

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

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

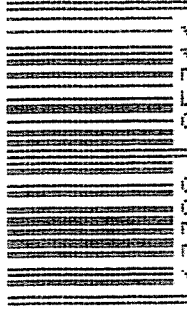
SERIAL NO.
 C8594546

ORDER NO.
 5715



5715 C8594546

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594544

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY ASS'T	10/30/90	Kel
600	Proof		10/30/90	Kel
607	Check Headspace		10/30/90	Kel
610	Dis-assemble Gun		10/30/90	Kel
612	Magnaflux Barrel Action		11/1/90	KCK
	Magnaflux Bolt		11/1/90	KCK
615	Rollmark Caliber		11/1/90	ES.
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel <i>PB</i>		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-20-90	JB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	JU

op. #	BARBER M24 0018969	READINGS					DATE	INIT.
625 cont.	F) Safety On Force	5.0	5.25	5.0			1/2/91	KJ
	G) Safety Off Force	3.0	3.0	3.0			1/2/91	KJ
	H) Trigger Pull Test & Retainability						1-3-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/2/91	KJ
	J) Assemble Stock						1/3/91	KS
	K) Assemble Swivel Studs						1-11-91	JH
	L) Attach Front and Rear Sight Assemblies						1/3/91	KS
	M) Iron Sight Alignment						1/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/3/91	KS
	O) Attach Scope to Rifle						1/3/91	KS
	P) Detach & Attach Scope 20 Times						1/3/91	KS
640	Gallery Target & Test						1-9-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-9-91	NF
655	Final Inspection							
	A) Headspace						1-11-91	JH
	B) Trigger Pull	2.24	2.11	2.10	2.20	2.19	1-11-91	JH
	C) Function						1-11-91	JH
660	Pack						3-10-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6594546DATE 1-3-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.40	2.38	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.45	2.42	2.11	
PULL #3	2.40	2.47	2.48	2.10	
PULL #4	2.42	2.49	2.42	2.20	
PULL #5	2.46	2.42	2.42	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.23		
PULL #2	3.24	3.30		
PULL #3	3.13	3.31		
PULL #4	3.20	3.30		
PULL #5	3.29	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.47		4.16
PULL #2	4.26	4.46		4.28
PULL #3	4.26	4.48		4.27
PULL #4	4.29	4.32		4.32
PULL #5	4.29	4.32		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594546
10 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.218589
1 TO	2	.328897
1 TO	3	.293552
1 TO	4	.214441
1 TO	5	.0235372

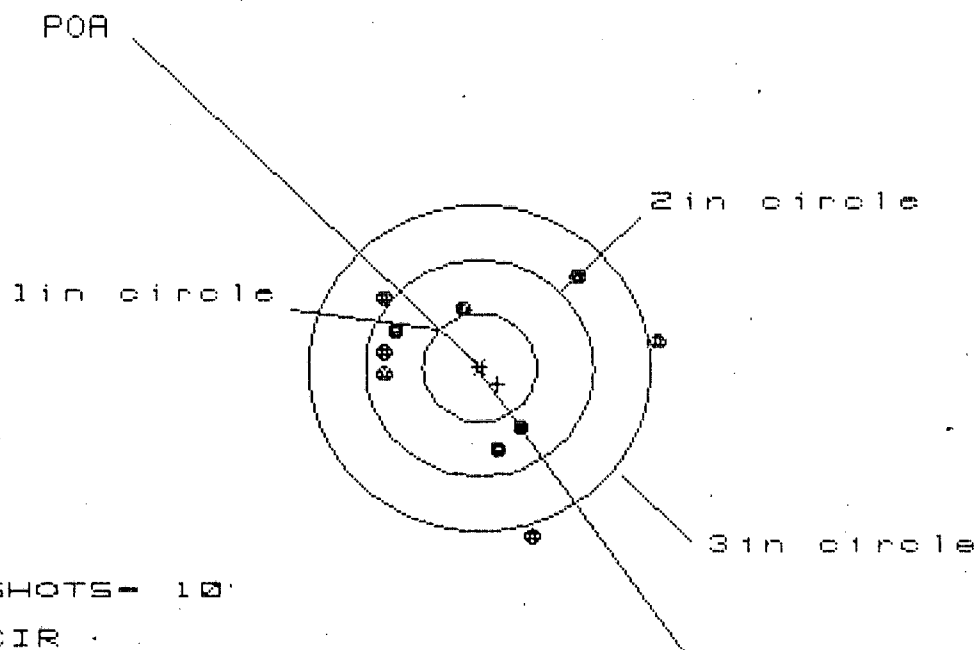
Sp <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0386
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0546
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0668664
THE AMR FOR THIS RIFLE IS: .9518

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594546

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 0

HS = 2.413

VS = 2.401

GS = 2.565

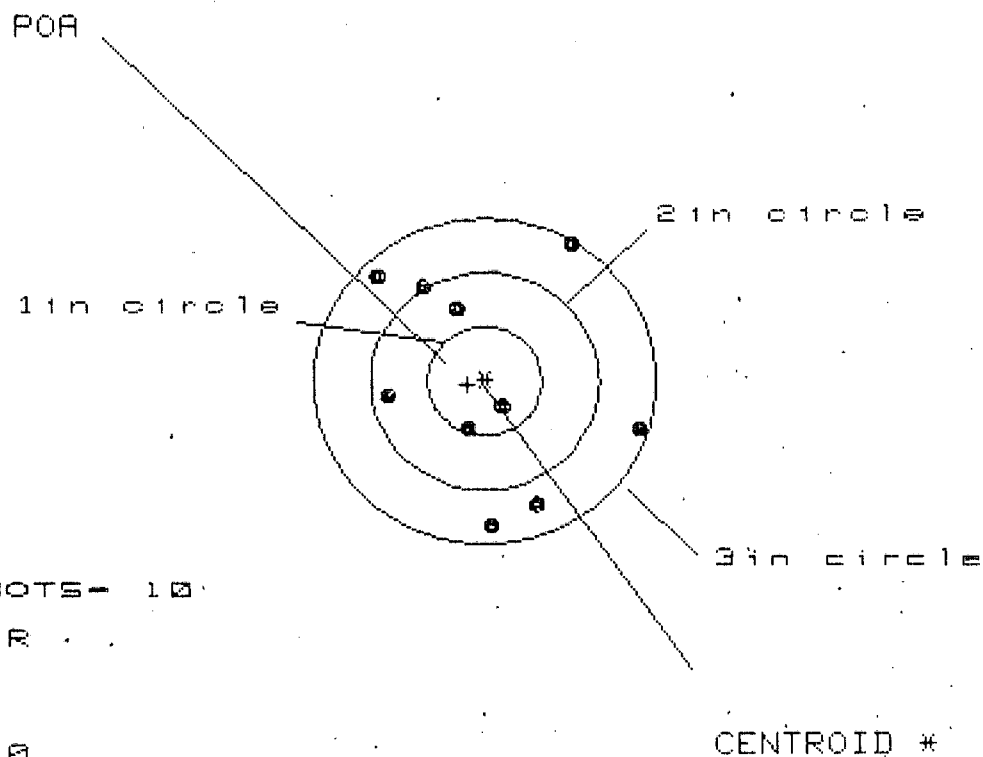
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.556	1.607	1.088
MINIMUM X	-.857	-.806	-.606
MAXIMUM Y	.873	.703	.709
MINIMUM Y	-1.528	-.880	-.874
CENTROID X	-.159	-.210	-.410
CENTROID Y	.150	.320	.314
POA TO CENTROID in.	.219	.382	.516
MIN RADIUS	.617	.440	.431
MEAN RADIUS	.998	.909	.772
MAX RADIUS	1.593	1.607	1.299
HORIZONTAL SPREAD	2.413	2.413	1.694
VERTICAL SPREAD	2.401	1.583	1.583
EXTREME SPREAD	2.565	2.457	1.931
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR . . .

1in - 2

2in - 4

3in = 10

HS= 2.358

VS= 2.550

GS= 2.737

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.392	.872	.749
MINIMUM X	-.966	-.811	-.702
MAXIMUM Y	1.262	1.210	1.019
MINIMUM Y	-1.288	-1.340	-1.189
CENTROID X	.148	-.007	-.116
CENTROID Y	.032	.084	-.067
POA TO CENTROID in.	.151	.084	.134
MIN RADIUS	.222	.361	.386
MEAN RADIUS	1.008	.946	.860
MAX RADIUS	1.469	1.491	1.270
HORIZONTAL SPREAD	2.358	1.683	1.451
VERTICAL SPREAD	2.550	2.550	2.208
EXTREME SPREAD	2.737	2.633	2.507
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6594546

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 9

HS = 2.412

VS = 2.620

GS = 2.953

CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.309	1.190	.935
MINIMUM X	-1.103	-1.222	-1.074
MAXIMUM Y	1.147	.984	.919
MINIMUM Y	-1.473	-1.142	-1.207
CENTROID X	-.037	.082	-.066
CENTROID Y	-.117	.046	.111
POA TO CENTROID in.	.123	.095	.129
MIN RADIUS	.399	.596	.592
MEAN RADIUS	1.120	1.029	.969
MAX RADIUS	1.823	1.296	1.418
HORIZONTAL SPREAD	2.412	2.412	2.009
VERTICAL SPREAD	2.620	2.126	2.126
EXTREME SPREAD	2.953	2.434	2.262
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8594546

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10.

IN CIR .

1 in = 4

2 in = 8

3 in = 10

HS= 2.088

VS= 2.223

GS= 2.311

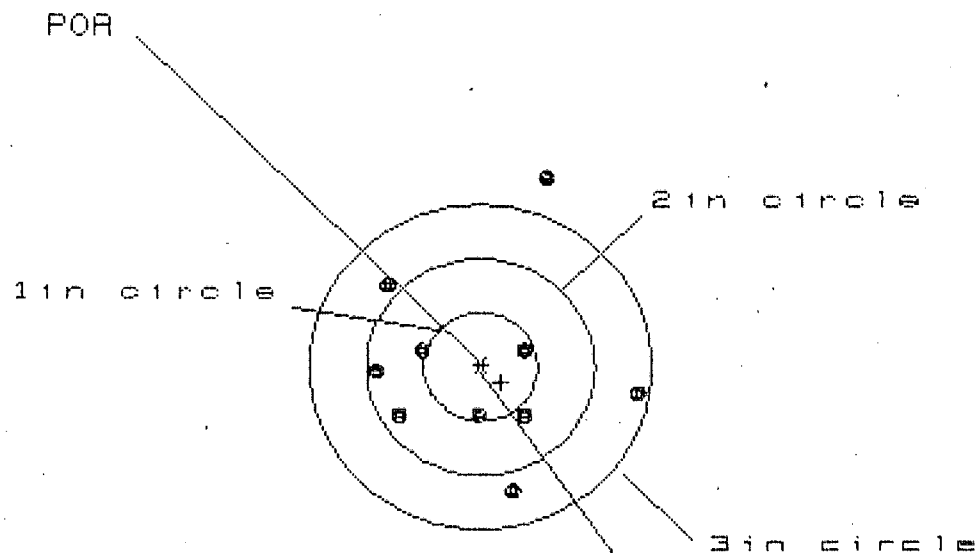
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.725	.573	.608
MINIMUM X	-1.363	-.427	-.392
MAXIMUM Y	.935	.954	.795
MINIMUM Y	-1.288	-1.269	-.704
CENTROID X	.037	.189	.154
CENTROID Y	.063	.044	.203
POA TO CENTROID in.	.073	.194	.254
MIN RADIUS	.247	.323	.233
MEAN RADIUS	.712	.643	.546
MAX RADIUS	1.374	1.299	.807
HORIZONTAL SPREAD	2.088	1.000	1.000
VERTICAL SPREAD	2.223	2.223	1.499
EXTREME SPREAD	2.311	2.268	1.499
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in = 9

HS- 2.247

VS= 2.936

GS= 2.957

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.334	1.404	.632
MINIMUM X	-.913	-.843	-.668
MAXIMUM Y	1.751	.924	.914
MINIMUM Y	-1.185	-.990	-1.000
CENTROID X	-.182	-.252	-.427
CENTROID Y	.145	-.050	-.040
POA TO CENTROID in.	.233	.257	.429
MIN RADIUS	.404	.204	.279
MEAN RADIUS	.921	.780	.688
MAX RADIUS	1.859	1.406	1.125
HORIZONTAL SPREAD	2.247	2.247	1.300
VERTICAL SPREAD	2.936	1.914	1.914
EXTREME SPREAD	2.957	2.371	2.200
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	