

C6594552

MODEL 700™ M24

Model **SWS**™

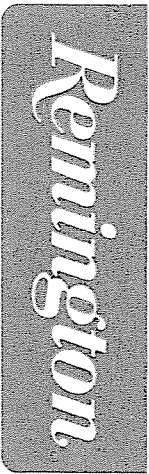
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

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

DU PONT

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

MODEL 700™ H24

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

SERIAL NO.
C6594552

ORDER NO.
5716

20

5716 C6594552

LPC

0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594552

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/26/90	K.S.
600	Proof		12/26/90	K.S.
607	Check Headspace		12/26/90	K.S.
610	Dis-assemble Gun		12/26/90	K.S.
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	LS
617	Drill and Tap Sight Holes	1	10 91	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	Kd
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	Kd
	C) Inspect Ejector Hole for Chamfer		2/11/91	Kd
	D) Oil Firing Pin Ass'y		2/11/91	Kd
	E) Adjust Trigger Pull to Min Setting and Stake		2/12/91	JK

BARBER - M24 0019102

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7/2	7/2	7/2			2/12/91	WB
	G) Safety Off Force	2/2	2/2	2/2			2/12/91	WB
	H) Trigger Pull Test & Retainability						2/12/91	821
	I) Firing Pin Indent	.0213	.021	.021			2/12/91	WB
	J) Assemble Stock						2/2/91	KH
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/12/91	KH
	M) Iron Sight Alignment						2/12/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/12/91	KH
	O) Attach Scope to Rifle						2/12/91	KH
	P) Detach & Attach Scope 20 Times						2/12/91	KH
640	Gallery Target & Test						2/12/91	NF
	A) Time							NF
	B) Malfunctions							NF
	C) Pierced Primers							NF
	D) Optical Clarity of Scope							NF
645	Inspect for Live Ammo						2/12/91	NF
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.35	2.34	2.40	2.43	2.45	2/20/91	WB
	C) Function						2-22-91	A
660	Pack						3-15-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594552

DATE 2/12/91

TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.32	2.30	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.30	2.30	2.34	
PULL #3	2.28	2.29	2.28	2.40	
PULL #4	2.31	2.29	2.30	2.43	
PULL #5	2.27	2.28	2.31	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.39		
PULL #2	3.33	3.23		
PULL #3	3.33	3.19		
PULL #4	3.35	3.26		
PULL #5	3.36	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.46		4.21
PULL #2	4.37	4.33		4.19
PULL #3	4.45	4.18		4.33
PULL #4	4.48	4.41		4.36
PULL #5	4.45	4.19		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594552
13 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.126036
1 TO	2	.20107
1 TO	3	.321734
1 TO	4	.213663
1 TO	5	.142215

4.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0112
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0504
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0516294
THE AMR FOR THIS RIFLE IS: 1.014

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594552

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 2.056

VS= 4.992

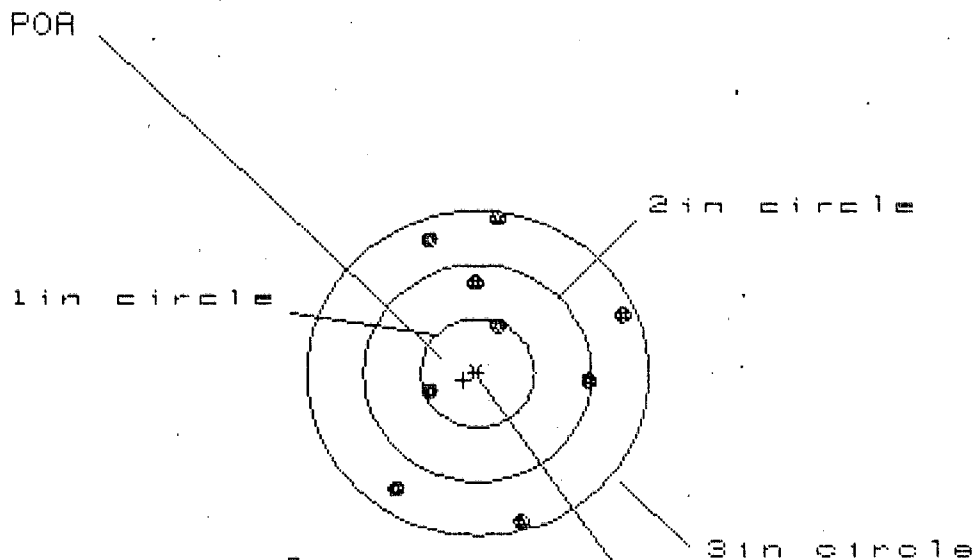
GS= 5.399

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	1.034	.927
MINIMUM X	-.974	-.853	-.677
MAXIMUM Y	2.179	1.867	2.033
MINIMUM Y	-2.813	-1.242	-1.009
CENTROID X	-.078	-.199	-.092
CENTROID Y	.099	.412	.179
POA TO CENTROID in.	.127	.457	.201
MIN RADIUS	.613	.645	.678
MEAN RADIUS	1.315	1.169	.985
MAX RADIUS	3.014	2.053	2.079
HORIZONTAL SPREAD	2.056	1.887	1.604
VERTICAL SPREAD	4.992	3.109	3.042
EXTREME SPREAD	5.399	3.177	3.045
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.953

VS = 3.234

GS = 3.744

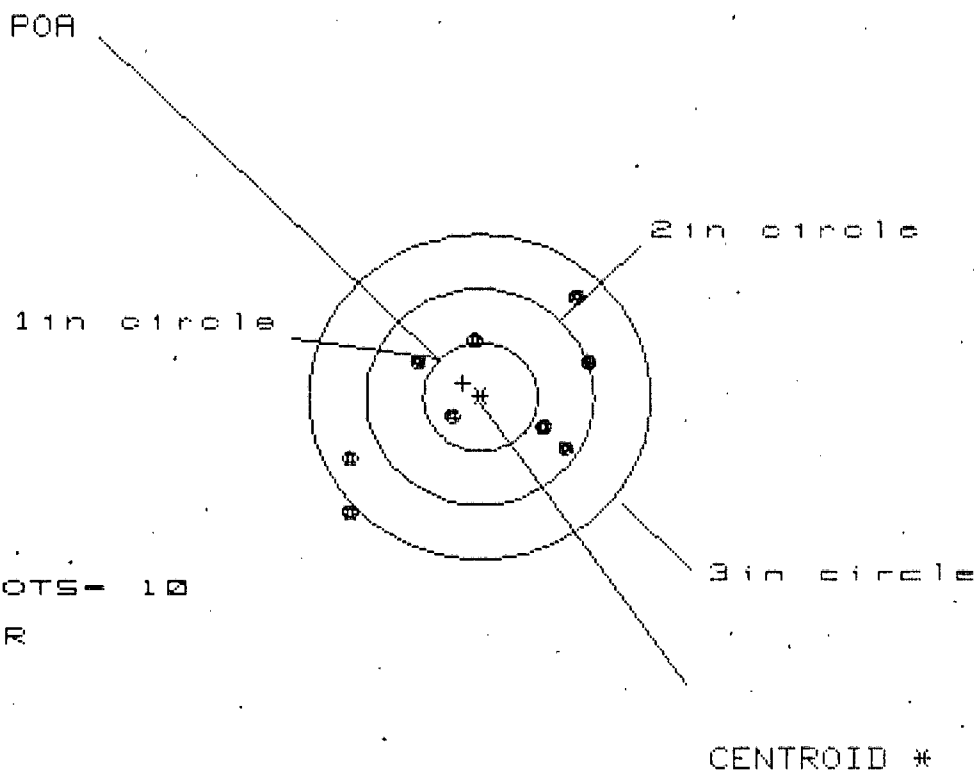
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	1.125	1.128
MINIMUM X	:	-1.645	-0.868	-0.865
MAXIMUM Y	:	1.425	1.224	1.225
MINIMUM Y	:	-1.809	-1.535	-1.382
CENTROID X	:	.120	.303	.300
CENTROID Y	:	.064	.265	.112
POA TO CENTROID in.	:	.136	.402	.320
MIN RADIUS	:	.453	.242	.393
MEAN RADIUS	:	1.202	1.013	1.000
MAX RADIUS	:	2.445	1.551	1.407
HORIZONTAL SPREAD	:	2.953	1.993	1.993
VERTICAL SPREAD	:	3.234	2.759	2.607
EXTREME SPREAD	:	3.744	2.766	2.728
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.054

VS = 2.003

GS = 2.853

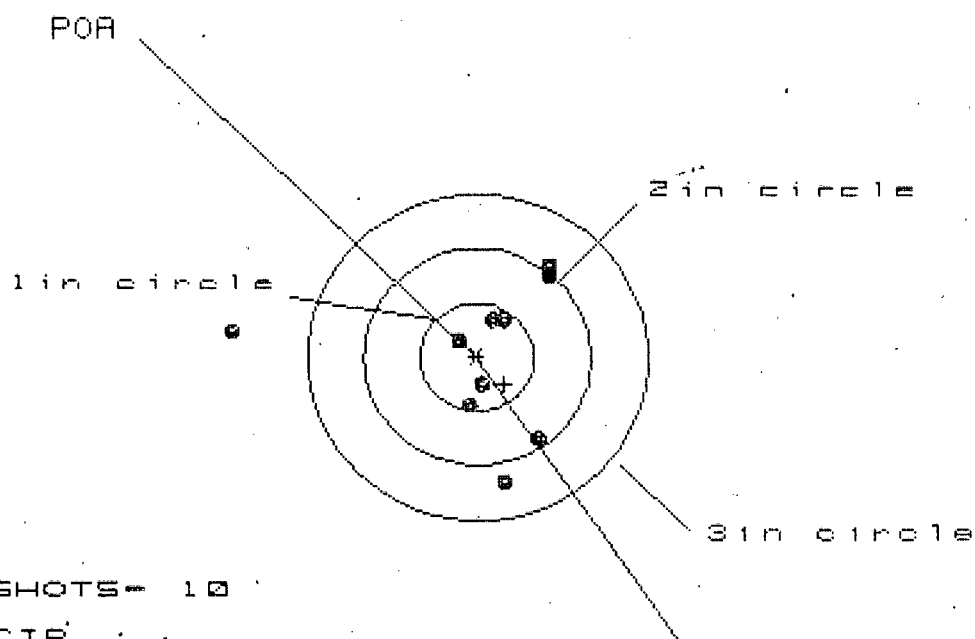
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.927	.801	.897
MINIMUM X	:	-1.137	-1.244	-1.148
MAXIMUM Y	:	.911	.790	.488
MINIMUM Y	:	-1.092	-.698	-.600
CENTROID X	:	.150	.276	.180
CENTROID Y	:	-.128	-.007	-.105
POA TO CENTROID in.	:	.197	.276	.208
MIN RADIUS	:	.323	.406	.361
MEAN RADIUS	:	.852	.754	.707
MAX RADIUS	:	1.576	1.427	1.295
HORIZONTAL SPREAD	:	2.064	2.045	2.045
VERTICAL SPREAD	:	2.003	1.488	1.088
EXTREME SPREAD	:	2.853	2.503	2.248
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in - 5

2 in - 7

3 in - 9

HS= 2.806

VS= 1.987

GS= 2.848

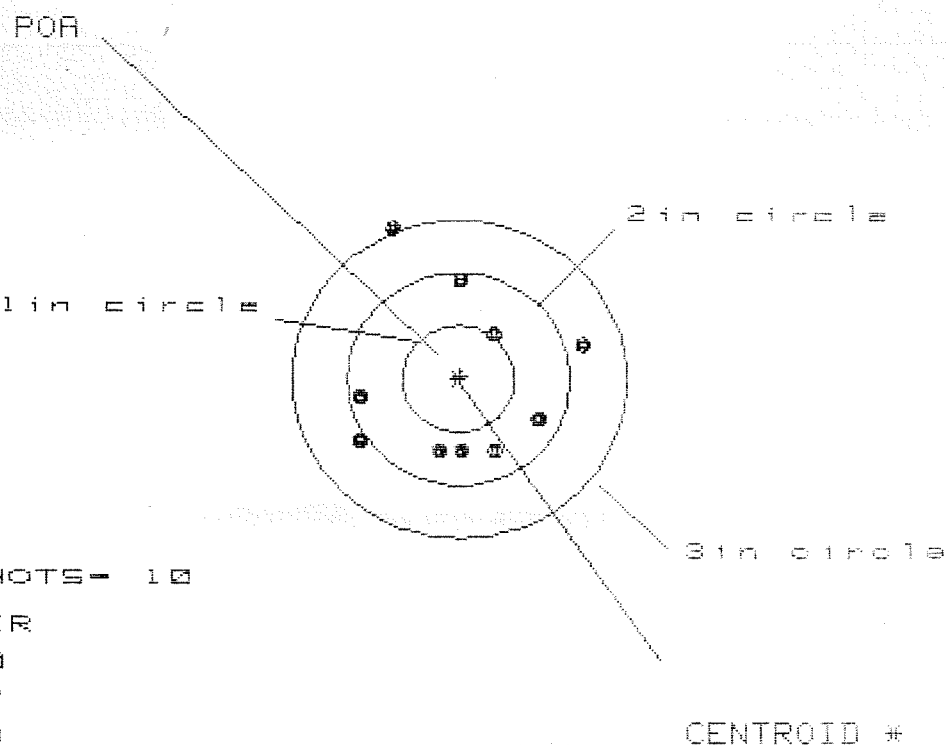
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.683	.447	.442
MINIMUM X	:	-2.123	-.430	-.435
MAXIMUM Y	:	.810	.836	.692
MINIMUM Y	:	-1.177	-1.151	-.866
CENTROID X	:	-.234	.002	.007
CENTROID Y	:	.245	.219	.363
POA TO CENTROID in.	:	.339	.219	.363
MIN RADIUS	:	.254	.341	.214
MEAN RADIUS	:	.796	.640	.554
MAX RADIUS	:	2.136	1.152	.901
HORIZONTAL SPREAD	:	2.806	.877	.877
VERTICAL SPREAD	:	1.987	1.987	1.558
EXTREME SPREAD	:	2.848	2.039	1.566
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 1.988

VS= 2.156

GS= 2.302

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.112	1.052	.784
MINIMUM X	-.876	-.936	-.804
MAXIMUM Y	1.451	1.075	1.140
MINIMUM Y	-.705	-.544	-.479
CENTROID X	-.014	.046	-.086
CENTROID Y	-.028	-.189	-.254
POA TO CENTROID in.	.031	.194	.268
MIN RADIUS	.548	.494	.440
MEAN RADIUS	.904	.801	.737
MAX RADIUS	1.547	1.175	1.147
HORIZONTAL SPREAD	1.988	1.988	1.588
VERTICAL SPREAD	2.156	1.619	1.619
EXTREME SPREAD	2.302	2.191	1.742
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	