

C6594567

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ H24

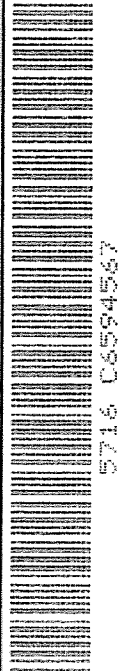
DU PONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
06594567

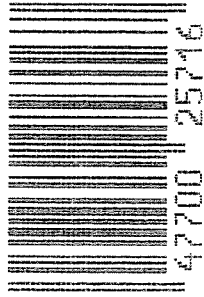
ORDER NO.
5716

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



5716 06594567

UPC



0 47700 25746 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594567

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel <i>AB</i>		11/7/90	WB
620	Apply Coatings (Barrel Action)		11/26/90	<i>PA</i>
	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		1/4/91	<i>JK</i>

op. #	BARBER - M24 0019402 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5.25	5.25	5.50			1/2/91	KT
	G) Safety Off Force	2.75	2.75	2.75			1/2/91	KT
	H) Trigger Pull Test & Retainability						1/4/91	JL
	I) Firing Pin Indent	.021	.020	.020			1/2/92	KT
	J) Assemble Stock						1/14/91	KA
	K) Assemble Swivel Studs						1-15-91	JL
	L) Attach Front and Rear Sight Assemblies						1/4/91	KA
	M) Iron Sight Alignment						1/4/91	KA
	N) Detach Front & Rear Sights & place in numbered container						1/4/91	KA
	O) Attach Scope to Rifle						1/14/91	KA
	P) Detach & Attach Scope 20 Times						1/4/91	
640	Gallery Target & Test						1-14-91	AC
	A) Time						1-14-91	AC
	B) Malfunctions						1-14-91	AC
	C) Pierced Primers						1-14-91	AC
	D) Optical Clarity of Scope						1-14-91	AC
645	Inspect for Live Ammo						1-14-91	AC
655	Final Inspection							
	A) Headspace						1-15-91	JL
	B) Trigger Pull	2.44	2.50	2.52	2.10	2.25	1-15-91	JL
	C) Function						1-15-91	JL
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6594567

DATE 1/4/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.47	2.37	2.44	MIN. SETTING, NO. AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.38	2.44	2.50	
PULL #3	2.45	2.44	2.41	2.52	
PULL #4	2.41	2.48	2.44	2.10	
PULL #5	2.46	2.45	2.46	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.34		
PULL #2	3.20	3.33		
PULL #3	3.35	3.35		
PULL #4	3.33	3.40		
PULL #5	3.37	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.21		4.34
PULL #2	4.22	4.40		4.18
PULL #3	4.23	4.24		4.34
PULL #4	4.16	4.32		4.36
PULL #5	4.25	4.26		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594567
15 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.160078
1 TO	2	.552849
1 TO	3	.383021
1 TO	4	.48841
1 TO	5	.219463

3.4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.057
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149493
THE AMR FOR THIS RIFLE IS: .87

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594567

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.352

VS= 1.721

GS= 2.384

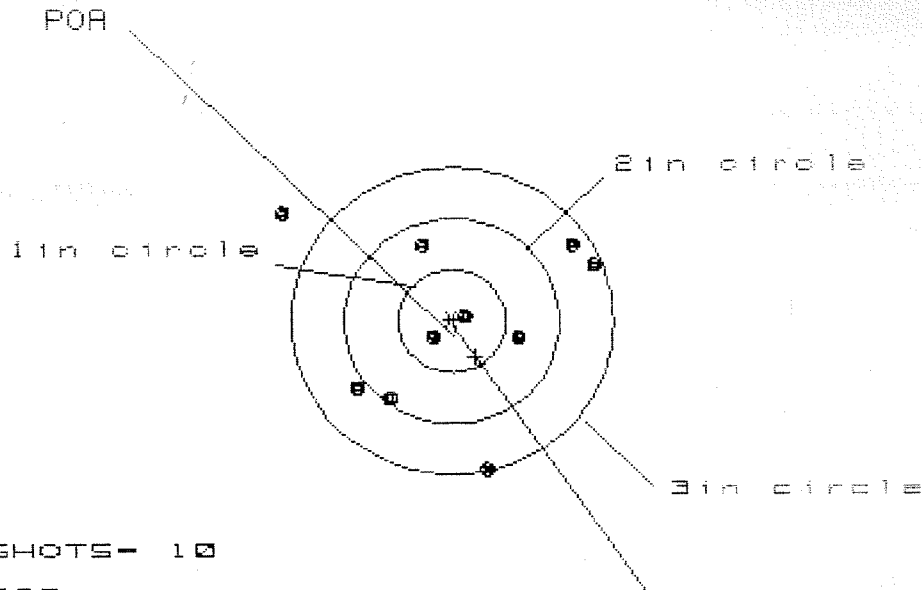
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	1.062	.938
MINIMUM X	:	-1.127	-.991	-.538
MAXIMUM Y	:	.982	.985	.940
MINIMUM Y	:	-.738	-.736	-.781
CENTROID X	:	-.005	-.141	-.017
CENTROID Y	:	-.160	-.162	-.117
POA TO CENTROID in.	:	.160	.215	.118
MIN RADIUS	:	.282	.197	.304
MEAN RADIUS	:	.801	.738	.704
MAX RADIUS	:	1.225	1.069	1.083
HORIZONTAL SPREAD	:	2.352	2.053	1.476
VERTICAL SPREAD	:	1.721	1.721	1.721
EXTREME SPREAD	:	2.384	2.085	1.899
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

13 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in - 9

HS- 2.948

VS= 2.482

GS= 3.150

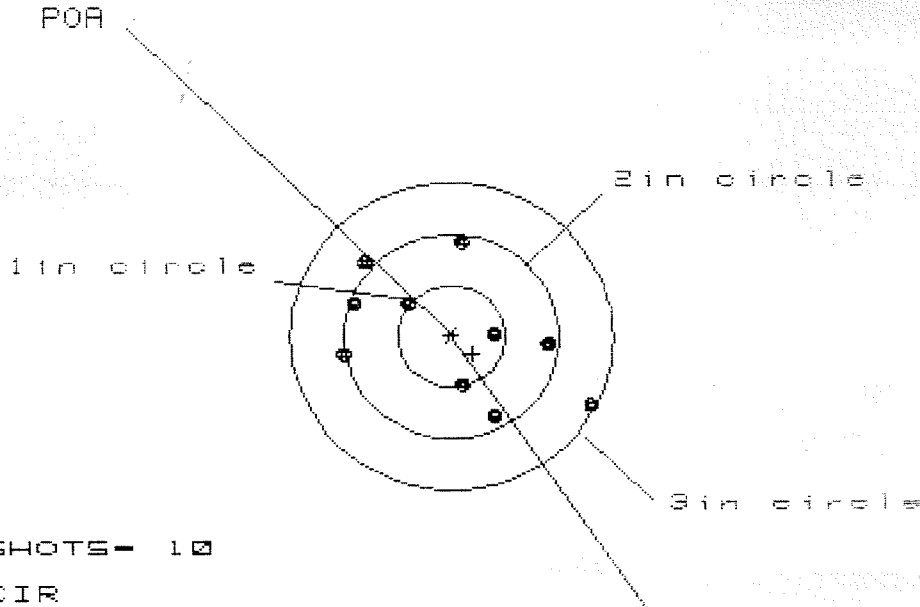
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.341	1.162	1.181
MINIMUM X	-1.607	-1.075	-1.056
MAXIMUM Y	1.028	.864	.697
MINIMUM Y	-1.454	-1.340	-.819
CENTROID X	-.216	-.037	-.056
CENTROID Y	.351	.237	.404
POA TO CENTROID in.	.412	.240	.408
MIN RADIUS	.159	.138	.032
MEAN RADIUS	1.005	.896	.819
MAX RADIUS	1.908	1.350	1.291
HORIZONTAL SPREAD	2.948	2.237	2.237
VERTICAL SPREAD	2.482	2.204	1.515
EXTREME SPREAD	3.150	2.542	2.542
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

15 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in = 10

HS- 2.310

VS= 1.738

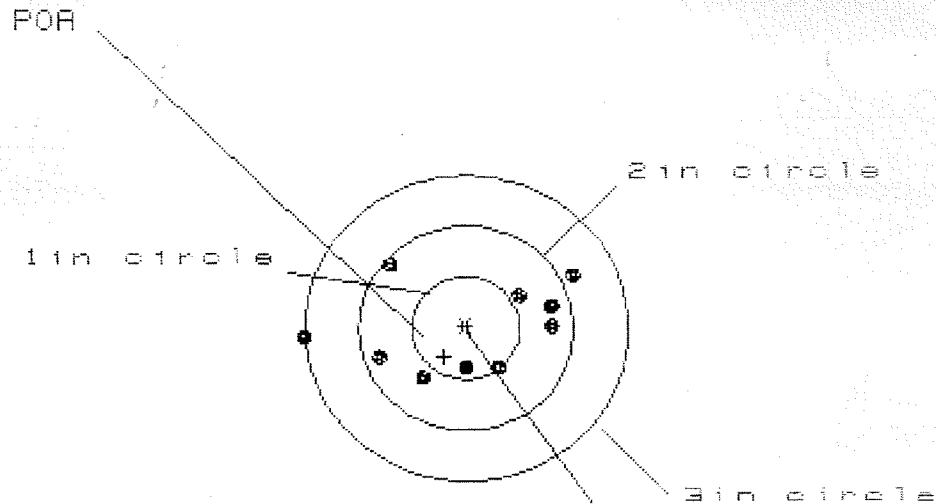
GS= 2.552

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.270
MINIMUM X	-1.040
MAXIMUM Y	.926
MINIMUM Y	-.812
CENTROID X	-.196
CENTROID Y	.172
POA TO CENTROID in.	.260
MIN RADIUS	.427
MEAN RADIUS	.873
MAX RADIUS	1.455
HORIZONTAL SPREAD	2.310
VERTICAL SPREAD	1.738
EXTREME SPREAD	2.552
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	10

15 Jan 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 8

3 in - 9

HS - 2.572

VS - 1.061

GS - 2.627

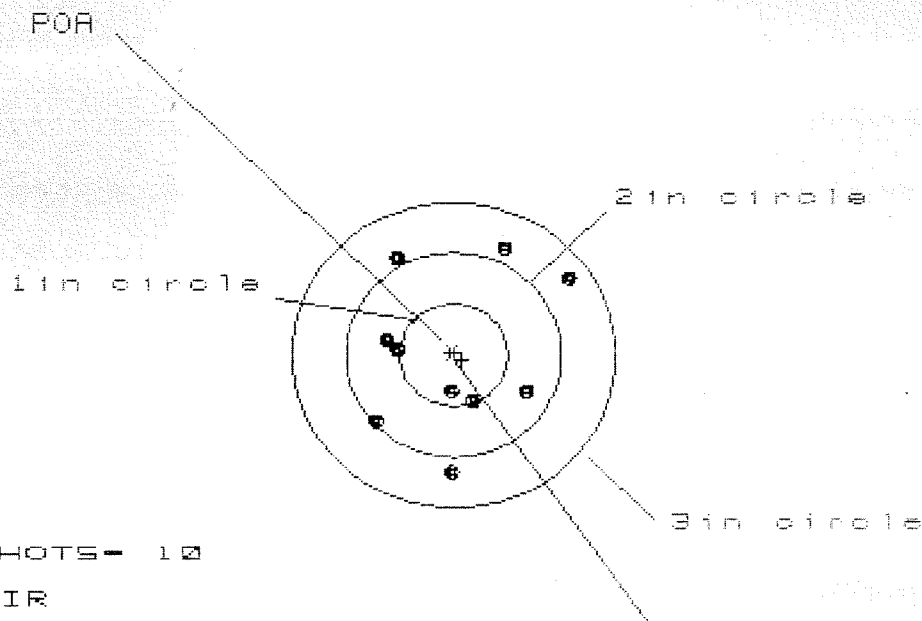
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.025	.853	.764
MINIMUM X	:	-1.547	-1.019	-.912
MAXIMUM Y	:	.573	.568	.629
MINIMUM Y	:	-.488	-.493	-.432
CENTROID X	:	.207	.379	.272
CENTROID Y	:	.280	.285	.224
POA TO CENTROID in.	:	.348	.474	.353
MIN RADIUS	:	.386	.426	.346
MEAN RADIUS	:	.829	.722	.685
MAX RADIUS	:	1.547	1.068	.975
HORIZONTAL SPREAD	:	2.572	1.872	1.676
VERTICAL SPREAD	:	1.061	1.061	1.061
EXTREME SPREAD	:	2.627	2.039	1.756
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in - 2

2in - 5

3in - 10

HS - 1.848

VS - 2.162

GS - 2.309

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.109	.801	.816
MINIMUM X	-.738	-.615	-.600
MAXIMUM Y	1.021	1.101	.968
MINIMUM Y	-1.141	-1.061	-.716
CENTROID X	-.075	-.199	-.214
CENTROID Y	.048	-.032	.101
POA TO CENTROID in.	.090	.201	.236
MIN RADIUS	.318	.251	.345
MEAN RADIUS	.842	.761	.730
MAX RADIUS	1.323	1.231	1.122
HORIZONTAL SPREAD	1.848	1.416	1.416
VERTICAL SPREAD	2.162	2.162	1.684
EXTREME SPREAD	2.309	2.205	2.048
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		