

06587667

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

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

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

SERIAL NO.
C6587667

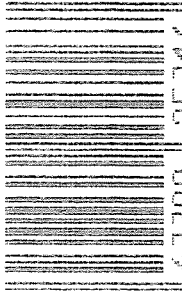
ORDER NO.
5716

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



5716 C6587667

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587667

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
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		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2-4-91	JM

BARBER - M24 0024846

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/4/91	WB
	G) Safety Off Force	2	2	2			2/4/91	WB
	H) Trigger Pull Test & Retainability						2/4/91	HL
	I) Firing Pin Indent	.021	.021	.021			2/4/91	WB
	J) Assemble Stock						2/5/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/5/91	RW
	M) Iron Sight Alignment						2/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	RW
	O) Attach Scope to Rifle						2/5/91	RW
	P) Detach & Attach Scope 20 Times						2/5/91	RW
640	Gallery Target & Test						2-6-91	AC
	A) Time						2-6-91	AC
	B) Malfunctions						2-6-91	AC
	C) Pierced Primers						2-6-91	AC
	D) Optical Clarity of Scope						2-6-91	AC
645	Inspect for Live Ammo						2-6-91	AC
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.20	2.37	2.25	2.40	2.21	2/18/91	WB
	C) Function						2-19-91	AC
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. CC587667

DATE 2-4-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.24	2.39	2.20	MIN. SETTING,
PULL #2	2.43	2.13	2.32	2.37	NO AVG. OF 5
PULL #3	2.44	2.36	2.25	2.25	READINGS ACCEPT-
PULL #4	2.29	2.35	2.34	2.40	ABLE LESS THAN 2#
PULL #5	2.40	2.32	2.21	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.17		
PULL #2	3.40	3.28		
PULL #3	3.37	3.18		
PULL #4	3.32	3.49		
PULL #5	3.27	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.39		4.20
PULL #2	4.33	4.31		4.49
PULL #3	4.15	4.25		4.38
PULL #4	4.14	4.22		4.29
PULL #5	4.20	4.35		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587667
7 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.356396
1 TO	2	.46494
1 TO	3	.342301
1 TO	4	.317855
1 TO	5	.0738241

35
9 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .13073

THE AMR FOR THIS RIFLE IS: .8802

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587667

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 1.830

VS= 3.163

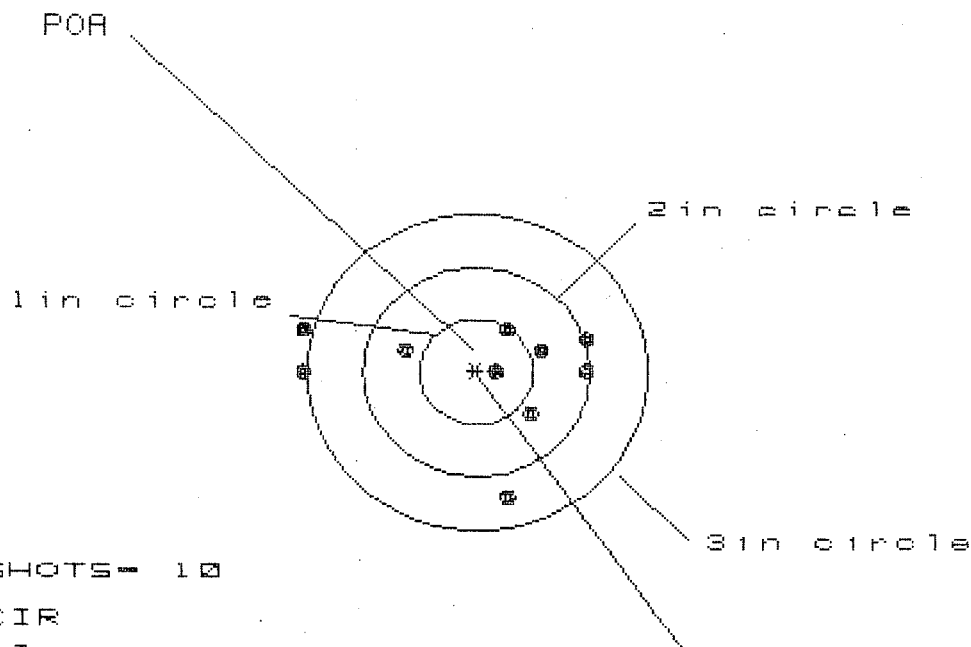
GS= 3.163

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	1.086	1.127
MINIMUM X	-.780	-.744	-.703
MAXIMUM Y	1.737	1.283	1.129
MINIMUM Y	-1.426	-1.233	-.849
CENTROID X	.197	.161	.120
CENTROID Y	-.297	-.490	-.336
POA TO CENTROID in.	.356	.516	.357
MIN RADIUS	.535	.454	.612
MEAN RADIUS	1.050	.953	.908
MAX RADIUS	1.767	1.483	1.363
HORIZONTAL SPREAD	1.830	1.830	1.830
VERTICAL SPREAD	3.163	2.516	1.978
EXTREME SPREAD	3.163	2.733	2.636
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.507

VS = 1.607

GS = 2.508

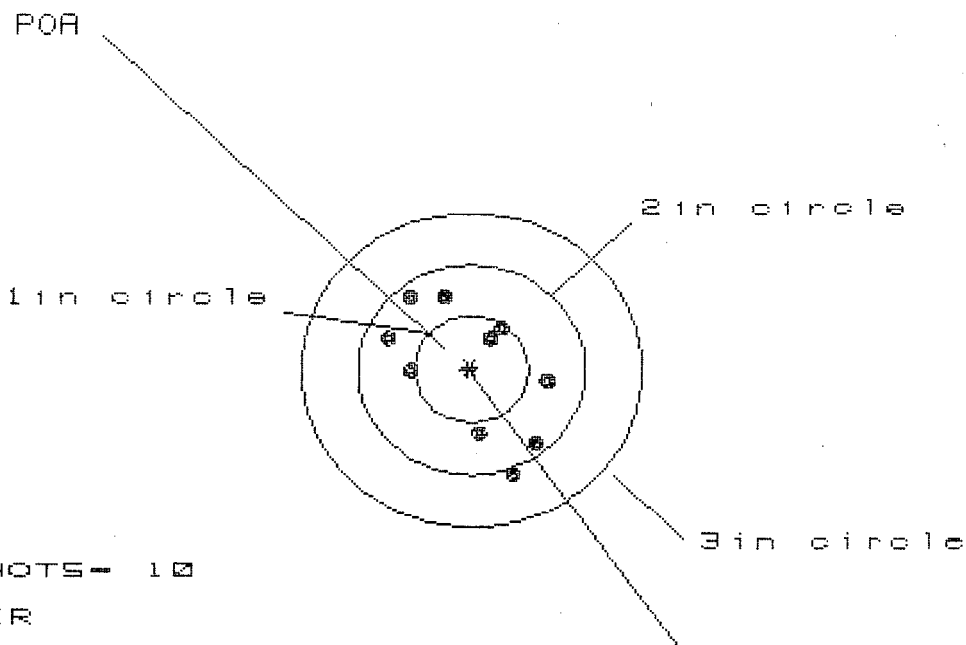
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.788	.576
MINIMUM X	:	-1.547	-1.698	-1.049
MAXIMUM Y	:	.392	.410	.422
MINIMUM Y	:	-1.215	-1.171	-1.159
CENTROID X	:	-.168	.004	.216
CENTROID Y	:	-.009	-.053	-.065
POA TO CENTROID in.	:	.168	.053	.226
MIN RADIUS	:	.146	.033	.243
MEAN RADIUS	:	.890	.757	.606
MAX RADIUS	:	1.596	1.701	1.162
HORIZONTAL SPREAD	:	2.507	2.486	1.625
VERTICAL SPREAD	:	1.607	1.581	1.581
EXTREME SPREAD	:	2.508	2.502	1.720
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.315

VS = 1.691

GS = 1.916

CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.618	.655	.736
MINIMUM X	:	-.698	-.660	-.580
MAXIMUM Y	:	.734	.628	.523
MINIMUM Y	:	-.957	-.840	-.818
CENTROID X	:	.034	-.003	-.084
CENTROID Y	:	.004	.110	.215
POA TO CENTROID in.	:	.035	.110	.231
MIN RADIUS	:	.284	.224	.255
MEAN RADIUS	:	.687	.632	.561
MAX RADIUS	:	1.014	1.058	.836
HORIZONTAL SPREAD	:	1.315	1.315	1.315
VERTICAL SPREAD	:	1.691	1.468	1.341
EXTREME SPREAD	:	1.916	1.877	1.477
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.470

VS= 2.603

GS= 2.821

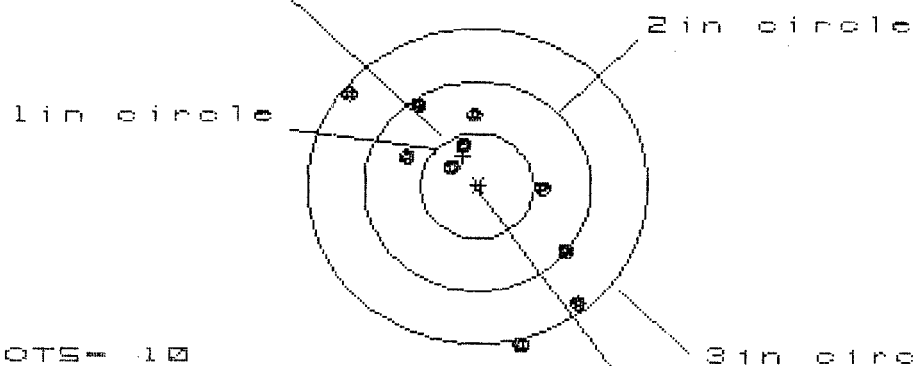
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.110	1.165	1.001
MINIMUM X	:	-1.360	-1.305	-.705
MAXIMUM Y	:	1.901	.483	.511
MINIMUM Y	:	-.702	-.491	-.463
CENTROID X	:	.023	-.032	.132
CENTROID Y	:	-.031	-.242	-.270
POA TO CENTROID in.	:	.038	.244	.300
MIN RADIUS	:	.315	.098	.184
MEAN RADIUS	:	.864	.674	.597
MAX RADIUS	:	1.963	1.324	1.124
HORIZONTAL SPREAD	:	2.470	2.470	1.706
VERTICAL SPREAD	:	2.603	.974	.974
EXTREME SPREAD	:	2.821	2.484	1.964
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.027

VS= 2.439

GS= 2.898

CENTROID #

PATTERN #	5	6	7
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.880	.927	.789
MINIMUM X	-1.147	-1.100	-.710
MAXIMUM Y	.925	.757	.723
MINIMUM Y	-1.514	-1.258	-1.164
CENTROID X	.124	.077	.215
CENTROID Y	-.286	-.118	-.212
POA TO CENTROID in.	.312	.141	.302
MIN RADIUS	.307	.183	.344
MEAN RADIUS	.910	.784	.746
MAX RADIUS	1.571	1.563	1.406
HORIZONTAL SPREAD	2.027	2.027	1.499
VERTICAL SPREAD	2.439	2.015	1.887
EXTREME SPREAD	2.898	2.858	2.368
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		