

C6587727

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

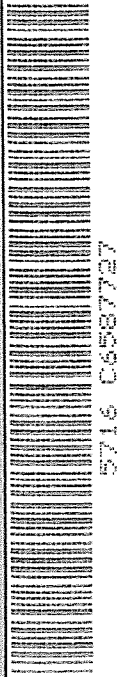
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6587727

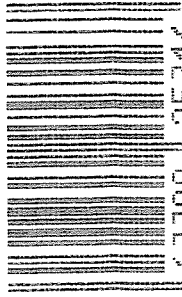
ORDER NO.
5716

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



5716 C6587727

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587727

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		"	KR
615	Rollmark Caliber		"	GL
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	TH
	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	GL

BARBER - M24 0025939								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	2 1/4	4 1/4	4 1/4			2/4/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/4/91	WB
	H) Trigger Pull Test & Retainability						2/4/91	RF
	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
640	Gallery Target & Test						2/6/91	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clarity of Scope						"	KJ
645	Inspect for Live Ammo						2/6/91	KJ
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.57	2.63	2.67	2.66	2.69	2/18/91	WB
	C) Function						2-19-91	A
660	Pack						3-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6587727

DATE 2-4-91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.31	2.15	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.40	2.33	2.63	
PULL #3	2.20	2.44	2.32	2.67	
PULL #4	2.19	2.41	2.33	2.66	
PULL #5	2.34	2.36	2.29	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.33	3.21		
PULL #3	3.42	3.29		
PULL #4	3.41	3.28		
PULL #5	3.47	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	4.37	4.32		4.25
PULL #2	4.30	4.30		4.48
PULL #3	4.35	4.28		4.47
PULL #4	4.26	4.31		4.49
PULL #5	4.28	4.36		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587727
7 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.418814
1 TO 2	.384832
1 TO 3	.216086
1 TO 4	.330905
1 TO 5	.219112

←----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197921
THE AMR FOR THIS RIFLE IS: 1.001

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587727

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.166

VS = 3.988

GS = 4.140

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

UNITS IN ONE INCH CIRCLE

10

9

8

.786

.756

.579

-1.380

-1.410

-.866

2.586

1.320

1.170

-1.482

-1.204

-1.055

.333

.363

.540

.254

-.024

.126

.419

.364

.554

.268

.420

.188

1.089

.909

.745

2.520

1.854

1.277

2.166

2.166

1.445

3.988

2.524

2.225

4.140

3.283

2.372

7 Feb 1991

FILE: PATTERNING/CENTERFIRE_PATT/06587727

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.210

VS = 1.852

GS = 2.828

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.822	.667	.599
MINIMUM X	:	-1.388	-.552	-.620
MAXIMUM Y	:	.709	.592	.434
MINIMUM Y	:	-1.143	-1.260	-.575
CENTROID X	:	.053	.208	.276
CENTROID Y	:	-.010	.107	.265
POA TO CENTROID in.	:	.054	.234	.383
MIN RADIUS	:	.071	.247	.209
MEAN RADIUS	:	.724	.607	.506

MAX RADIUS :	1.744	1.374	.740
HORIZONTAL SPREAD :	2.210	1.219	1.219
VERTICAL SPREAD :	1.852	1.852	1.009
EXTREME SPREAD :	2.828	2.214	1.288
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

7 Feb 1991

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.824

VS = 3.448

GS = 4.668

CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.407	1.181	1.122
MINIMUM X	-1.417	-1.158	-1.209
MAXIMUM Y	1.700	1.095	.968
MINIMUM Y	-1.748	-1.559	-.841
CENTROID X	.126	-.141	-.082
CENTROID Y	.192	.003	.198
POA TO CENTROID in.	.238	.141	.214
MIN RADIUS	.126	.440	.384
MEAN RADIUS	1.163	.947	.842
MAX RADIUS	2.946	1.629	1.438
HORIZONTAL SPREAD	3.824	2.331	2.331
VERTICAL SPREAD	3.448	2.654	1.741
EXTREME SPREAD	4.668	3.127	2.415
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.726

VS= 2.386

GS= 2.897

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.880	.896
MINIMUM X	:	-1.733	-1.234	-1.139
MAXIMUM Y	:	1.082	1.081	1.173
MINIMUM Y	:	-1.304	-1.305	-1.170
CENTROID X	:	.146	.339	.243
CENTROID Y	:	-.019	-.018	-.153
POA TO CENTROID in.	:	.147	.339	.288
MIN RADIUS	:	.256	.220	.090
MEAN RADIUS	:	1.036	.926	.868
MAX RADIUS	:	1.733	1.322	1.184
HORIZONTAL SPREAD	:	2.726	2.034	2.034
VERTICAL SPREAD	:	2.386	2.386	2.343
EXTREME SPREAD	:	2.897	2.533	2.349
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Feb 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.019

VS = 3.264

GS = 3.656

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.521
MINIMUM X	-.498
MAXIMUM Y	1.928
MINIMUM Y	-1.336
CENTROID X	.196
CENTROID Y	.083
POA TO CENTROID in.	.212
MIN RADIUS	.464
MEAN RADIUS	.995
MAX RADIUS	2.456
HORIZONTAL SPREAD	2.019
VERTICAL SPREAD	3.264
EXTREME SPREAD	3.656
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8