

C6648965

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

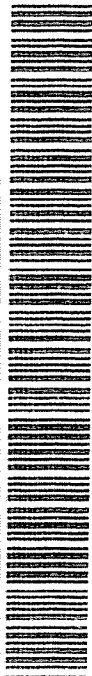
MODEL 700™ H24

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

SERIAL NO.
C6648965

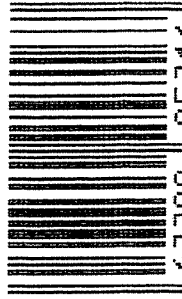
ORDER NO.
5716

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



5716 C6648965

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6648965

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action	AUG 7 1991		KR
	Magnaflux Bolt	AUG 7 1991		KR
615	Rollmark Caliber	AUG 7 1991		JS
617	Drill and Tap Sight Holes	AUG 7 1991		FB
618	Polish Barrel	AUG 13 1991		WB
620	Apply Coatings (Barrel Action)		8-7-91	TS
	Apply Coating (Bolt)		8-7-91	TS
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KL
	C) Inspect Ejector Hole for Chamfer		9/4/91	KL
	D) Oil Firing Pin Ass'y		9/4/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/91	KL

op. #	BARBER M24 0030072	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/10/91	JK
	G) Safety Off Force	3	3	3			9/10/91	JK
	H) Trigger Pull Test & Retainability						9/10/91	JK
	I) Firing Pin Indent	.020	.021	.021			9/10/91	JK
	J) Assemble Stock						9/12/91	JK
	K) Assemble Swivel Studs						9-14-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/12/91	JK
	M) Iron Sight Alignment						9/12/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	JK
	O) Attach Scope to Rifle						9/12/91	JK
	P) Detach & Attach Scope 20 Times						9/12/91	JK
640	Gallery Target & Test						9/13/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/13/91	KT
655	Final Inspection						9-14-91	D/H
	A) Headspace							
	B) Trigger Pull	2.63	2.51	2.69	2.66	2.47	9/14/91	JK
	C) Function						9-14-91	D/H
660	Pack						9-18-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648905

DATE 9-10-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.40	2.30	2.63	MIN. SETTING
PULL #2	2.41	2.36	2.28	2.51	NO AVG. OF 5
PULL #3	2.29	2.38	2.40	2.69	READINGS ACCEPT-
PULL #4	2.46	2.57	2.45	2.66	ABLE LESS THAN 2#
PULL #5	2.30	2.27	2.50	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.25		
PULL #2	3.34	3.26		
PULL #3	3.34	3.50		
PULL #4	3.35	3.34		
PULL #5	3.45	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.35		4.48
PULL #2	4.28	4.33		4.52
PULL #3	4.43	4.58		4.37
PULL #4	4.45	4.64		4.53
PULL #5	4.39	4.34		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6648965
 13 Sep 1991

CENTROIDAL DISTANCES

Ø TO	1	.284176
1 TO	2	.320702
1 TO	3	.172256
1 TO	4	.886019
1 TO	5	.330776

4
 58 <----FOR
 13

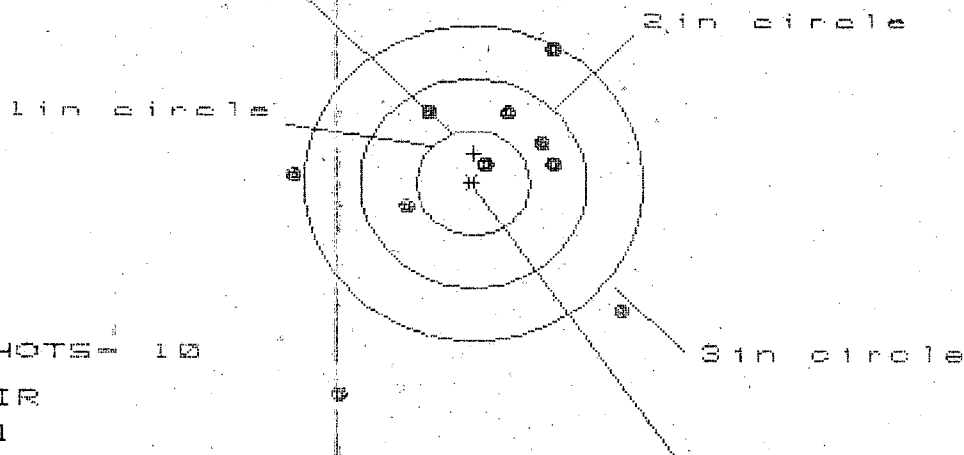
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0816
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0188
 THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .0837377
 THE AGE FOR THIS RIFLE IS: 1.195

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648965

CENTERFIRE PATTERNS

POA



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 6

3 in - 6

HS - 2.929

VS - 3.291

GS - 3.835

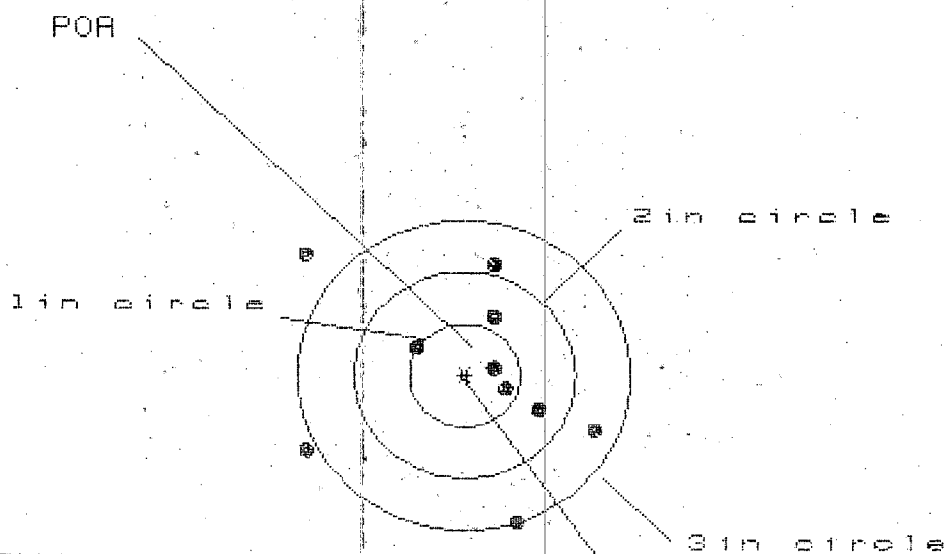
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.337	1.201	.761
MINIMUM X	:	-1.593	-1.728	-1.578
MAXIMUM Y	:	1.302	1.081	.986
MINIMUM Y	:	-1.989	-1.398	-.610
CENTROID X	:	-.010	.126	-.024
CENTROID Y	:	-.284	-.063	.112
POA TO CENTROID in.	:	.284	.141	.115
MIN RADIUS	:	.173	.088	.258
MEAN RADIUS	:	1.088	.879	.758
MAX RADIUS	:	2.335	1.843	1.605
HORIZONTAL SPREAD	:	2.929	2.929	2.339
VERTICAL SPREAD	:	3.291	2.479	1.516
EXTREME SPREAD	:	3.835	3.198	2.627
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.507

VS= 2.564

GS= 3.188

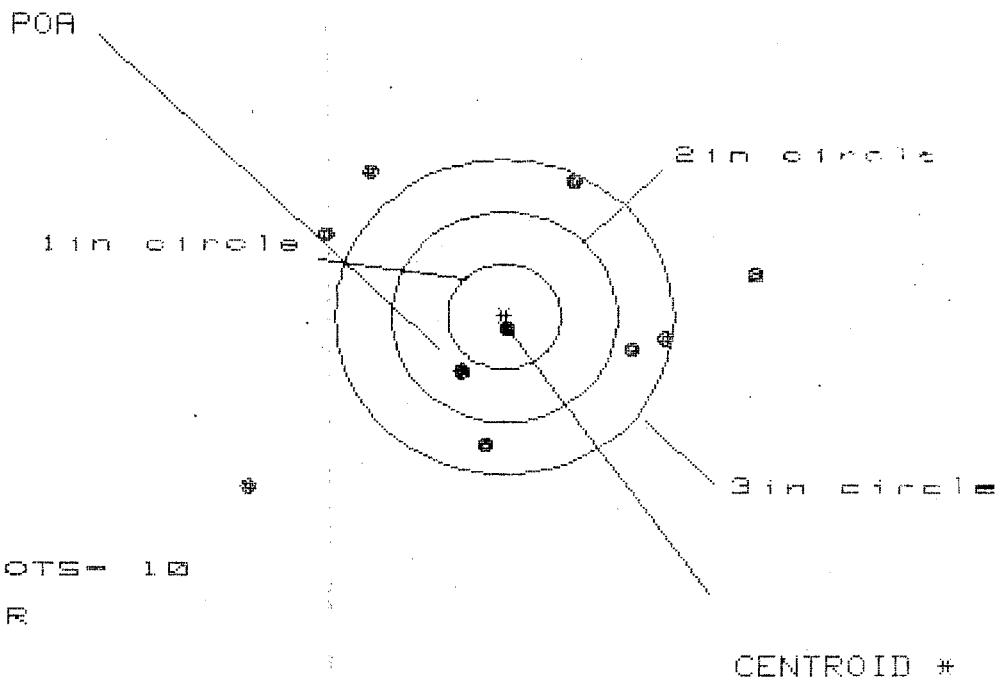
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.150	1.000	.801
MINIMUM X	-1.447	-1.590	-.840
MAXIMUM Y	1.131	1.175	1.102
MINIMUM Y	-1.433	-1.308	-1.381
CENTROID X	-.268	-.108	.091
CENTROID Y	-.077	-.202	-.129
POA TO CENTROID in.	.279	.229	.158
MIN RADIUS	.261	.190	.041
MEAN RADIUS	.982	.855	.698
MAX RADIUS	1.836	1.695	1.384
HORIZONTAL SPREAD	2.687	2.590	1.641
VERTICAL SPREAD	2.564	2.483	2.483
EXTREME SPREAD	3.188	2.598	2.491
NUMBER IN ONE INCH CIRCLE =	2	5	7
NUMBER IN TWO INCH CIRCLE =	5	7	7
NUMBER IN THREE INCH CIRCLE =	7	7	7

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS = 4.484

VS = 3.005

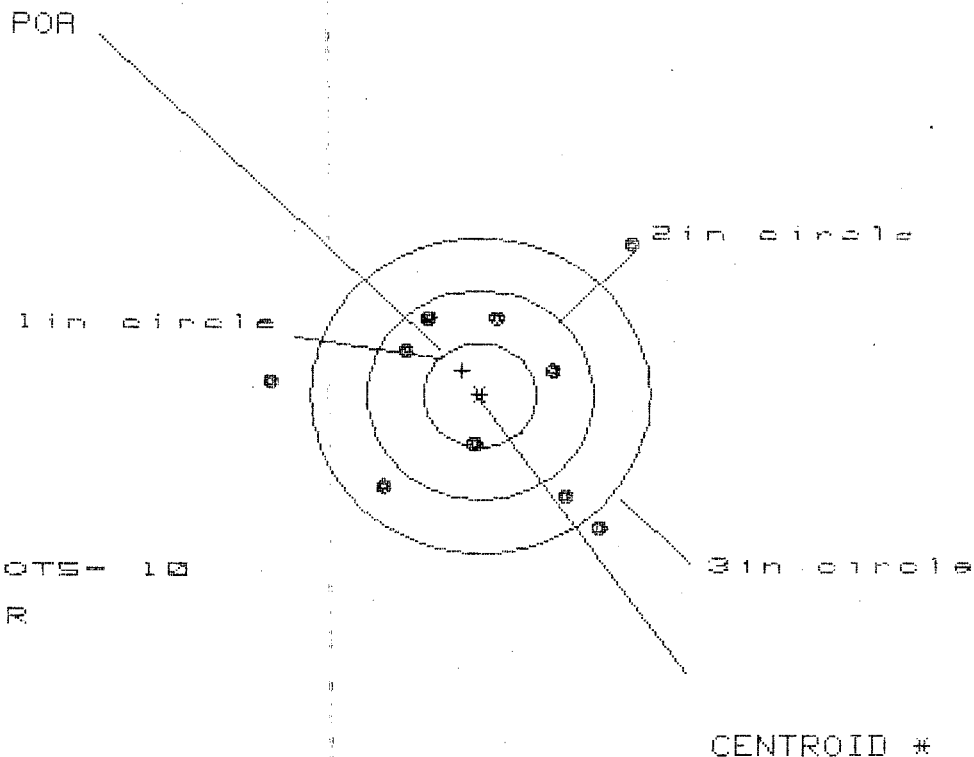
GS = 4.896

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.240	1.991	1.449
MINIMUM X	:	-2.244	-1.819	-1.570
MAXIMUM Y	:	1.428	1.252	1.279
MINIMUM Y	:	-1.577	-1.351	-1.324
CENTROID X	:	.375	.624	.375
CENTROID Y	:	.514	.690	.663
POA TO CENTROID in.	:	.636	.930	.762
MIN RADIUS	:	.082	.362	.231
MEAN RADIUS	:	1.462	1.329	1.224
MAX RADIUS	:	2.743	2.002	1.717
HORIZONTAL SPREAD	:	4.484	3.810	3.019
VERTICAL SPREAD	:	3.005	2.603	2.603
EXTREME SPREAD	:	4.896	3.835	3.205
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.179

VS= 2.772

GS= 3.460

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.327	1.156	.942
MINIMUM X	-1.852	-1.704	-.905
MAXIMUM Y	1.463	.903	.936
MINIMUM Y	-1.309	-1.147	-1.114
CENTROID X	.156	.008	.221
CENTROID Y	-.238	-.400	-.433
POA TO CENTROID in.	.284	.401	.486
MIN RADIUS	.476	.328	.300
MEAN RADIUS	1.151	1.050	.952
MAX RADIUS	1.975	1.724	1.459
HORIZONTAL SPREAD	3.179	2.860	1.848
VERTICAL SPREAD	2.772	2.050	2.050
EXTREME SPREAD	3.460	3.186	2.505
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 4.216

VS= 2.333

GS= 4.240

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.009	1.764	1.385
MINIMUM X	-2.207	-1.561	-1.341
MAXIMUM Y	1.139	1.142	1.201
MINIMUM Y	-1.194	-1.191	-1.132
CENTROID X	.155	.400	.180
CENTROID Y	-.009	-.012	-.071
POA TO CENTROID in.	.155	.401	.193
MIN RADIUS	.115	.358	.162
MEAN RADIUS	1.292	1.207	1.085
MAX RADIUS	2.207	1.826	1.712
HORIZONTAL SPREAD	4.216	3.325	2.726
VERTICAL SPREAD	2.333	2.333	2.333
EXTREME SPREAD	4.240	3.616	3.319
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	