

C6648983

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Bolt handle
hits stock

Repaired
9/10/91

KS

MOD.		GA. CAL.	GUN #
			89 83
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
K4	1st	Trigger creep	K5
	9/4/91		
	2nd	Repaired	K5
	9/10/91		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

Remington

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

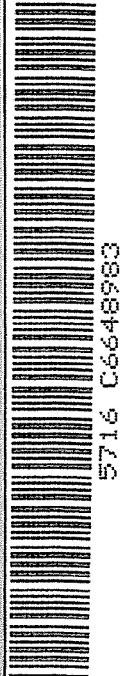
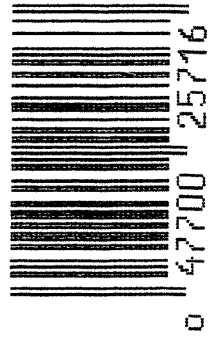
MODEL 700™ M24

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

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

SERIAL NO. C6648983	ORDER NO. 5716
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UPC



CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C 6648983

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KV
600	Proof		7/24/91	KV
607	Check Headspace		7/24/91	KV
610	Dis-assemble Gun		7/24/91	KV
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	LS
617	Drill and Tap Sight Holes		AUG 7 1991	FB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	DA
	Apply Coating (Bolt)		8/27/91	DA
625	Final Assembly		8/29/91	KV
	A) Clean inside of Bolt Assembly		8/29/91	KV
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KV
	C) Inspect Ejector Hole for Chamfer		8/29/91	KV
	D) Oil Firing Pin Ass'y		8/29/91	KV
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/91	94

op. #	BARBER M24 0030284	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-31-91	DH
	G) Safety Off Force	3	3 1/2	3			8-31-91	DH
	H) Trigger Pull Test & Retainability						8/31/91	RU
	I) Firing Pin Indent	.022	.022	.024			8-31-91	DH
	J) Assemble Stock						9/3/91	KL
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/3/91	KL
	M) Iron Sight Alignment						9/3/91	KL
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	KL
	O) Attach Scope to Rifle						9/3/91	KL
	P) Detach & Attach Scope 20 Times						9/3/91	KL
640	Gallery Target & Test						9/4/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/4/91	KT
655	Final Inspection							
	A) Headspace						9-10-91	DH
	B) Trigger Pull	2.26	2.28	2.30	2.32	2.33	9-6-91	RU
	C) Function						9-10-91	DH
660	Pack						9-18-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6648983

DATE 8/31/91

TESTER SM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.23	2.33	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.34	2.30	2.28	
PULL #3	2.37	2.24	2.29	2.30	
PULL #4	2.44	2.28	2.20	2.32	
PULL #5	2.20	2.18	2.22	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.27		
PULL #2	3.41	3.20		
PULL #3	3.34	3.31		
PULL #4	3.27	3.60		
PULL #5	3.18	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.36		4.40
PULL #2	4.35	4.31		4.32
PULL #3	4.28	4.25		4.28
PULL #4	4.34	4.31		4.42
PULL #5	4.33	4.39		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648983
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.167836
1 TO 2	.385565
1 TO 3	.276872
1 TO 4	.213776
1 TO 5	.195359

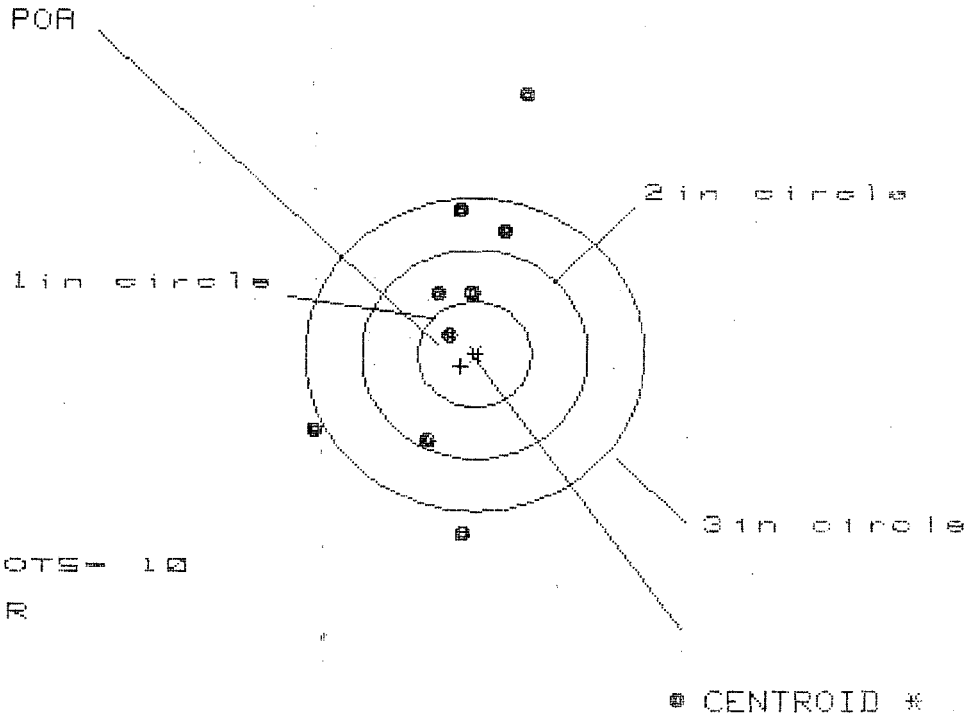
4) <----POR

COORDINATE FOR THIS RIFLE IS: -.0354
COORDINATE FOR THIS RIFLE IS: .0102
STORAGE PO. RADIUS FOR THIS RIFLE IS: .0368402
RIFLE 1: 1.212

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66489B3

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.248

VS= 5.782

GS= 5.924

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.775	.685	.607
MINIMUM X	-1.473	-1.276	-1.190
MAXIMUM Y	2.502	2.137	1.274
MINIMUM Y	-3.280	-2.042	-1.774
CENTROID X	.125	-.072	-.158
CENTROID Y	.112	.477	.210
POA TO CENTROID in.	.168	.482	.262
1 in RADIUS	.293	.173	.114
2 in RADIUS	1.472	1.103	.989
3 in RADIUS	3.730	2.245	1.786
HORIZONTAL SPREAD	3.248	1.961	1.797
VERTICAL SPREAD	5.782	4.179	3.049
EXTREME SPREAD	5.924	4.218	3.049
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	6	6	6

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66469B3

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 1.743

VS= 3.329

GS= 3.546

CENTROID #

PATTERN #

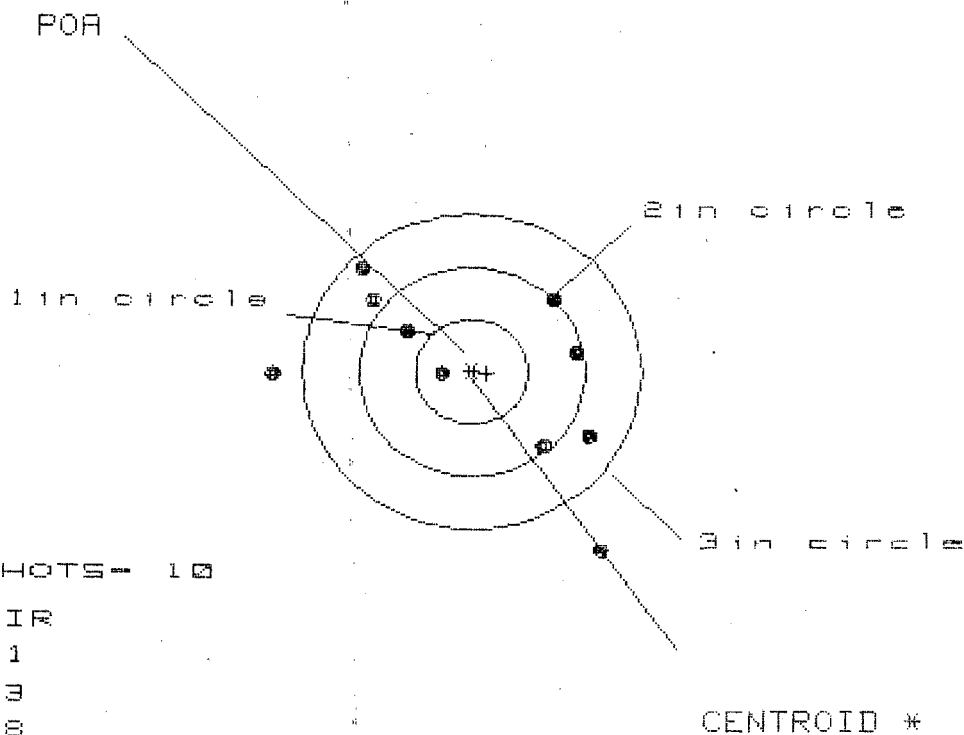
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.102	1.089	1.007
MINIMUM X	-.641	-.654	-.576
MAXIMUM Y	2.067	1.838	1.038
MINIMUM Y	-1.262	-1.032	-.802
CENTROID X	-.041	-.028	.054
CENTROID Y	-.236	-.466	-.696
POA TO CENTROID in.	.240	.467	.698
MIN RADIUS	.203	.366	.578
MEAN RADIUS	1.046	.909	.768
MAX RADIUS	2.071	1.951	1.288
HORIZONTAL SPREAD	1.743	1.743	1.583
VERTICAL SPREAD	3.329	2.870	1.840
EXTREME SPREAD	3.546	3.358	1.899
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

4 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 2.919

VS= 2.688

GS= 3.412

PATTERN #

3

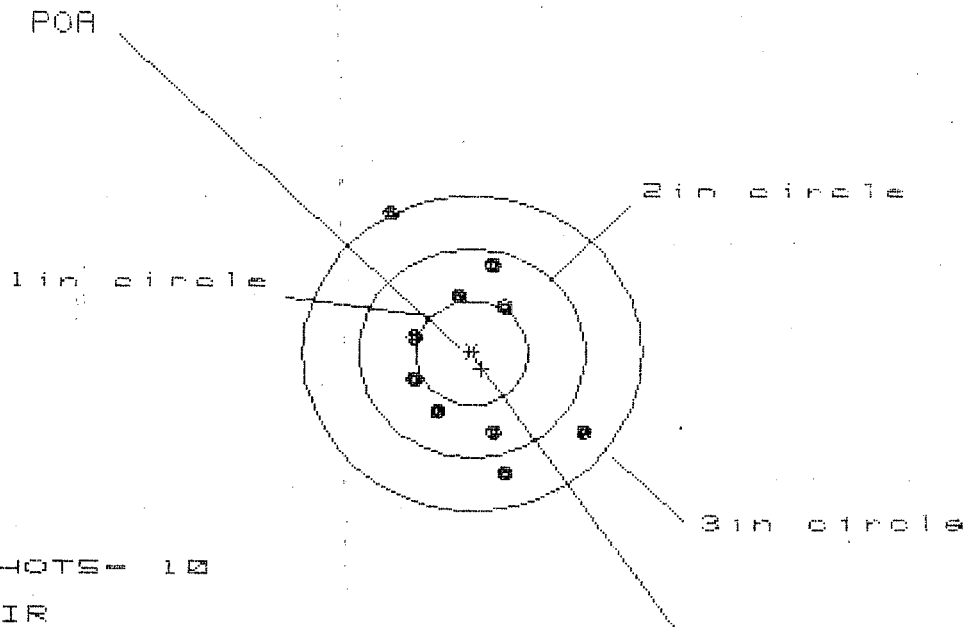
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.126	1.133	.924
MINIMUM X	-1.793	-1.668	-1.060
MAXIMUM Y	1.026	.841	.820
MINIMUM Y	-1.662	-.937	-.958
CENTROID X	-.132	-.257	-.048
CENTROID Y	.009	.194	.215
POA TO CENTROID in.	.132	.322	.221
MIN RADIUS	.287	.257	.431
MEAN RADIUS	1.149	1.025	.946
MAX RADIUS	2.007	1.677	1.340
HORIZONTAL SPREAD	2.919	2.801	1.984
VERTICAL SPREAD	2.688	1.778	1.778
EXTREME SPREAD	3.412	2.877	2.594
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B9B3

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 1.706

VS= 2.535

GS= 2.728

CENTROID *

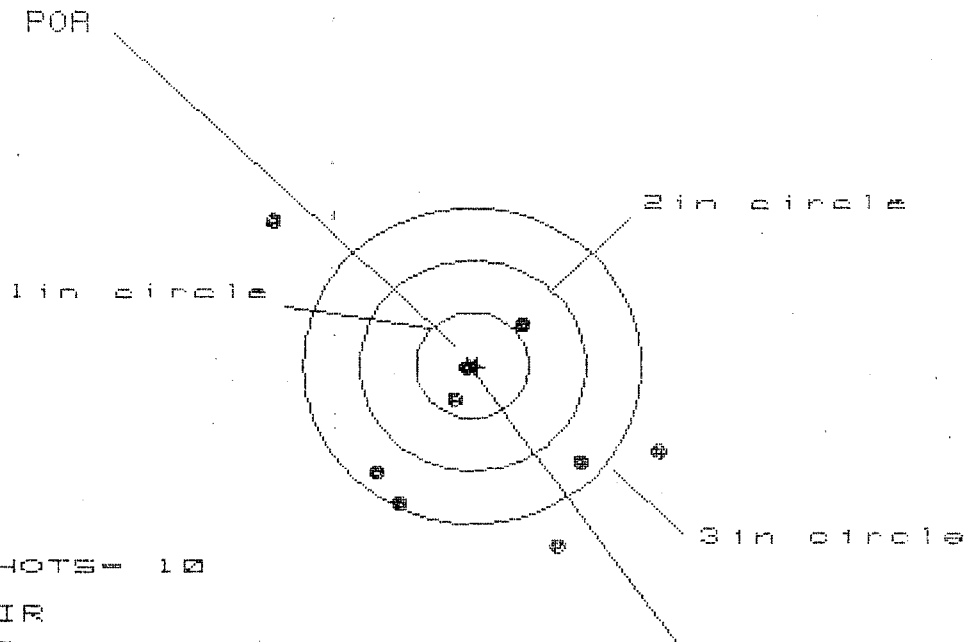
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.017	.941	.360
MINIMUM X	:	-.689	-.606	-.489
MAXIMUM Y	:	1.382	1.012	.939
MINIMUM Y	:	-1.153	-.999	-1.072
CENTROID X	:	-.085	-.009	-.126
CENTROID Y	:	.152	-.002	.072
POA TO CENTROID in.	:	.174	.009	.145
MIN RADIUS	:	.524	.549	.455
MEAN RADIUS	:	.847	.767	.702
MAX RADIUS	:	1.544	1.109	1.131
HORIZONTAL SPREAD	:	1.706	1.547	.849
VERTICAL SPREAD	:	2.535	2.011	2.011
EXTREME SPREAD	:	2.728	2.014	2.014
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Sep 1991

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CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.317

VS= 6.132

GS= 6.198

CENTROID #

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

NUMBER IN ONE

NUMBER IN TWO

NUMBER IN THREE

:

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10

1.603

-1.714

4.369

-1.763

-.044

.014

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.101

1.544

4.372

3.317

6.132

6.198

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=

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9

1.585

-1.732

1.911

-1.278

-.026

-.471

.472

.234

1.162

2.580

3.317

3.189

4.017

=

=

=

8

1.368

-1.103

1.079

-1.039

.191

-.710

.735

.556

.992

1.371

2.471

2.118

2.476

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