

C6649085

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smeal

Remington ®		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6649085	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649085

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		Kcd
	Magnaflux Bolt	5 6 91		Kcd
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	BA
	Apply Coating (Bolt)		5-30-91	BA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/91	84

op. #	BARBER M24 0031478	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/31/91	JA
	G) Safety Off Force	4	4	4			5/31/91	JA
	H) Trigger Pull Test & Retainability						5/31/91	JA
	I) Firing Pin Indent	.021	.021	.0215			5/31/91	JA
	J) Assemble Stock						5/31/91	Rw
	K) Assemble Swivel Studs						6-3-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/31/91	Rw
	M) Iron Sight Alignment						5/31/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/31/91	Rw
	O) Attach Scope to Rifle						5/31/91	Rw
	P) Detach & Attach Scope 20 Times						5/31/91	Rw
640	Gallery Target & Test						6-1-91	D/H
	A) Time						6-1-91	D/H
	B) Malfunctions						6-1-91	D/H
	C) Pierced Primers						6-1-91	D/H
	D) Optical Clarity of Scope						6-1-91	D/H
645	Inspect for Live Ammo						6-1-91	D/H
655	Final Inspection							
	A) Headspace						6-3-91	D/H
	B) Trigger Pull	2.29	2.36	2.34	2.43	2.47	6/3/91	JA
	C) Function						6-3-91	D/H
660	Pack						6-20-91	WF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6649085DATE 5/31/91TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.45	2.35	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.31	2.40	2.36	
PULL #3	2.33	2.34	2.45	2.34	
PULL #4	2.26	2.41	2.38	2.43	
PULL #5	2.40	2.33	2.38	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.18		
PULL #2	3.24	3.35		
PULL #3	3.31	3.42		
PULL #4	3.34	3.37		
PULL #5	3.36	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.28		4.28
PULL #2	4.29	4.28		4.18
PULL #3	4.24	4.22		4.23
PULL #4	4.27	4.21		4.20
PULL #5	4.26	4.23		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649085
1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.147136
1 TO	2	.344693
1 TO	3	.351104
1 TO	4	.350828
1 TO	5	.108467

$\bar{x}_2$ <----POA

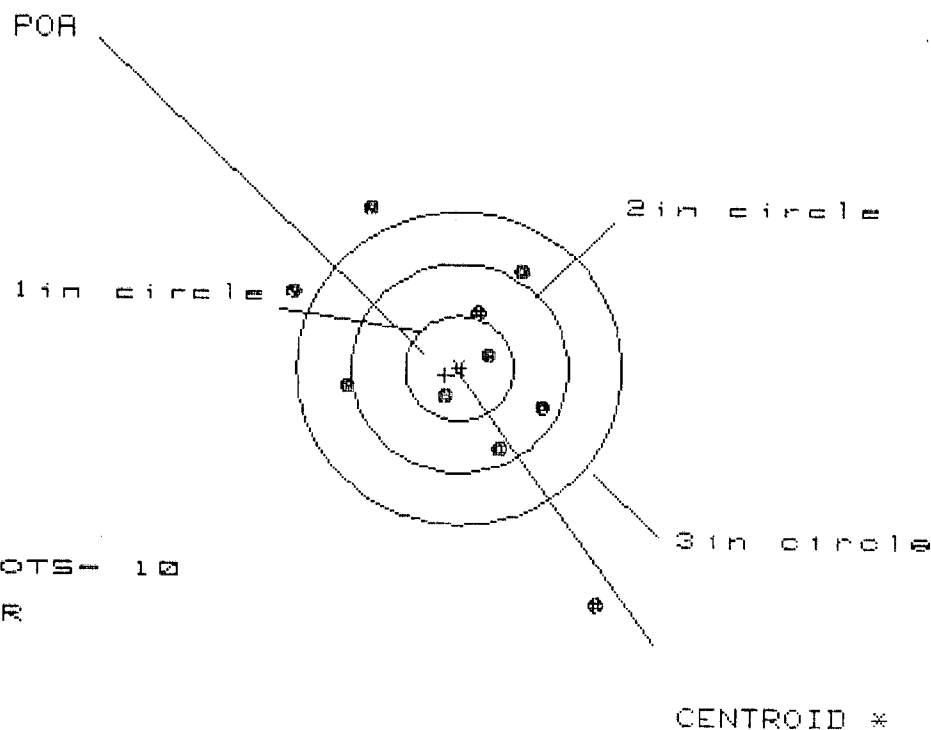
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .039
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0352
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0525361

THE AMR FOR THIS RIFLE IS: .871

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649085

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.872

VS= 3.824

GS= 4.359

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.308	.919	.839
MINIMUM X	-1.564	-1.418	-1.498
MAXIMUM Y	1.569	1.318	.802
MINIMUM Y	-2.256	-.992	-.827
CENTROID X	.132	-.014	.066
CENTROID Y	.065	.315	.150
POA TO CENTROID in.	.147	.315	.164
MIN RADIUS	.316	.424	.355
MEAN RADIUS	1.109	.954	.852
MAX RADIUS	2.608	1.491	1.623
HORIZONTAL SPREAD	2.872	2.337	2.337
VERTICAL SPREAD	3.824	2.310	1.629
EXTREME SPREAD	4.359	2.583	2.567
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649085

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 1.995

VS= 2.649

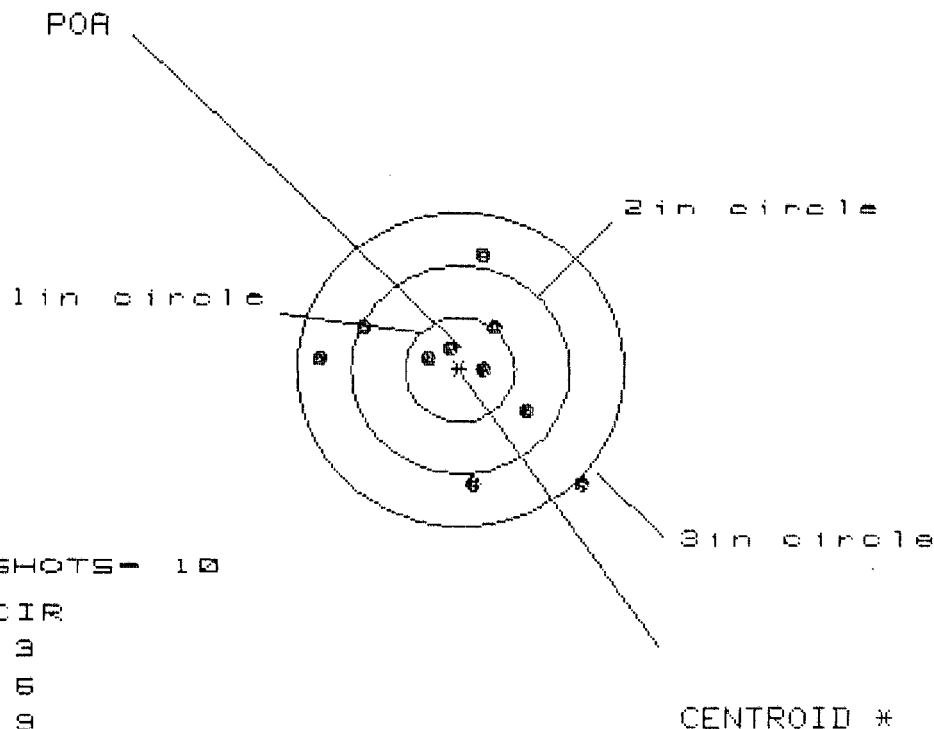
GS= 2.810

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	.993	.985
MINIMUM X	:	-.902	-.702	-.710
MAXIMUM Y	:	1.226	1.067	.627
MINIMUM Y	:	-1.423	-1.081	-.947
CENTROID X	:	.265	.365	.373
CENTROID Y	:	-.253	-.094	-.228
POA TO CENTROID in.	:	.366	.377	.437
MIN RADIUS	:	.059	.176	.146
MEAN RADIUS	:	.803	.697	.654
MAX RADIUS	:	1.685	1.260	1.143
HORIZONTAL SPREAD	:	1.995	1.695	1.695
VERTICAL SPREAD	:	2.649	2.148	1.574
EXTREME SPREAD	:	2.810	2.263	2.037
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.331

VS= 2.199

GS= 2.615

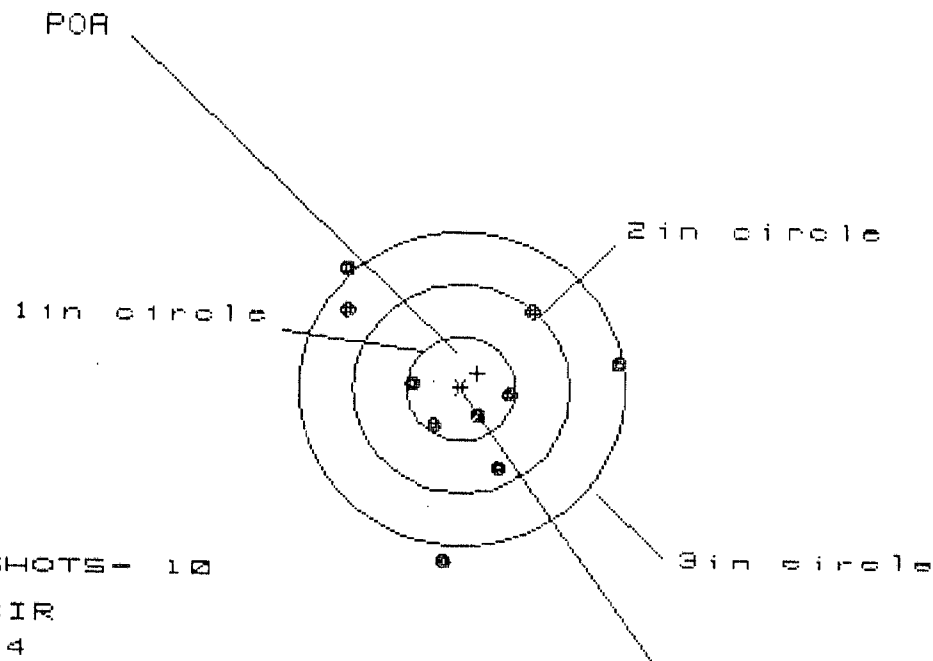
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.089	.741	.601
MINIMUM X	-1.242	-1.121	-.923
MAXIMUM Y	1.150	1.034	1.037
MINIMUM Y	-1.049	-1.165	-1.161
CENTROID X	-.211	-.332	-.192
CENTROID Y	-.010	.106	.102
POA TO CENTROID in.	.212	.349	.218
MIN RADIUS	.215	.149	.176
MEAN RADIUS	.800	.702	.635
MAX RADIUS	1.507	1.190	1.166
HORIZONTAL SPREAD	2.331	1.862	1.524
VERTICAL SPREAD	2.199	2.199	2.199
EXTREME SPREAD	2.615	2.200	2.200
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

1 Jun 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

IS= 2.456

VS= 2.830

GS= 2.968

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.402	1.384	1.250
MINIMUM X	:	-1.054	-1.072	-1.193
MAXIMUM Y	:	1.153	.966	.701
MINIMUM Y	:	-1.677	-.907	-.786
CENTROID X	:	-.146	-.128	.006
CENTROID Y	:	-.149	.038	-.083
POR TO CENTROID in.	:	.208	.134	.083
MIN RADIUS	:	.283	.450	.311
MEAN RADIUS	:	.926	.860	.749
MAX RADIUS	:	1.685	1.443	1.384
HORIZONTAL SPREAD	:	2.456	2.456	2.443
VERTICAL SPREAD	:	2.830	1.873	1.487
EXTREME SPREAD	:	2.968	2.616	2.497
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.844

VS= 1.634

GS= 2.167

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.966	.868	.974
MINIMUM X	-.878	-.944	-.838
MAXIMUM Y	.668	.630	.576
MINIMUM Y	-.966	-.892	-.946
CENTROID X	.155	.253	.147
CENTROID Y	.171	.097	.151
POA TO CENTROID in.	.231	.271	.211
MIN RADIUS	.224	.153	.212
MEAN RADIUS	.717	.669	.625
MAX RADIUS	1.104	.962	1.039
HORIZONTAL SPREAD	1.844	1.812	1.812
VERTICAL SPREAD	1.634	1.522	1.522
EXTREME SPREAD	2.167	1.859	1.844
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	