

C6649097

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

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

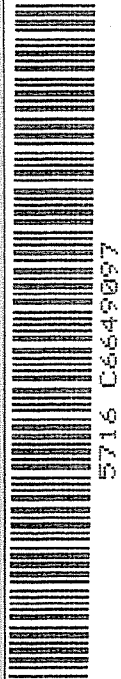
DU PONT
 REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

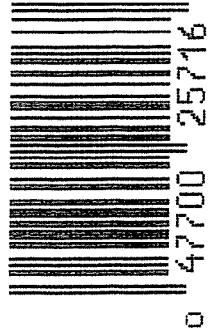
SERIAL NO. C6649097

ORDER NO. 5716

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



UPC



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 RDs	
TEST		
TGT		
PROOF	TEST	
TEST		
TGT		
PROOF	2-13-91	
TEST		
TGT		
	DH	
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 9097

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
<i>NF</i>	<i>9/11</i>	<i>Ejector Sticks</i>	<i>KS</i>
	2nd		
<i>KS</i>	<i>9/12</i>	<i>Repaired</i>	<i>KS</i>
	3rd		
	4th		

FUNCTION

RD 6654

Rev 1

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649097

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KA
600	Proof		7/24/91	KA
607	Check Headspace		7/24/91	KA
610	Dis-assemble Gun		7/24/91	KA
612	Magnaflux Barrel Action	AUG 7 1991		KR
	Magnaflux Bolt	AUG 7 1991		KR
615	Rollmark Caliber	AUG 7 1991		GB
617	Drill and Tap Sight Holes	AUG 7 1991		LB
618	Polish Barrel	AUG 13 1991		WB
620	Apply Coatings (Barrel Action)		8/27/91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KA
	C) Inspect Ejector Hole for Chamfer		9/4/91	KA
	D) Oil Firing Pin Ass'y		9/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9/7/91	KA

op. #	BARBER - M24 0031627	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/7/91	QU
	G) Safety Off Force	3	3	3			9/7/91	QU
	H) Trigger Pull Test & Retainability						9/7/91	QU
	I) Firing Pin Indent	1022	1022	1022			9/7/91	QU
	J) Assemble Stock						9/10/91	QU
	K) Assemble Swivel Studs						9/13/91	QU
	L) Attach Front and Rear Sight Assemblies						9/10/91	QU
	M) Iron Sight Alignment						9/10/91	QU
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	QU
	O) Attach Scope to Rifle						9/10/91	QU
	P) Detach & Attach Scope 20 Times						9/10/91	QU
640	Gallery Target & Test						9-11-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-11-91	NF
655	Final Inspection							
	A) Headspace						9-13/91	QU
	B) Trigger Pull	2.50	2.69	2.65	2.65	2.65	9-12-91	QU
	C) Function						9/13/91	QU
660	Pack						9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649097DATE 9-7-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.40	2.45	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.43	2.49	2.69	
PULL #3	2.25	2.43	2.40	2.65	
PULL #4	2.47	2.33	2.43	2.65	
PULL #5	2.31	2.42	2.40	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.46		
PULL #2	3.39	3.31		
PULL #3	3.29	3.44		
PULL #4	3.34	3.45		
PULL #5	3.42	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.40		4.29
PULL #2	4.34	4.34		4.15
PULL #3	4.29	4.37		4.35
PULL #4	4.25	4.34		4.44
PULL #5	4.44	4.37		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649097
12 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.24067
1 TO 2	.329371
1 TO 3	.257498
1 TO 4	.246483
1 TO 5	.218826

✕ <----POA

AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.139
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0084
AVERAGE AVERAGE POI RADIUS FOR THIS RIFLE IS: .139254
AVERAGE FOR THIS RIFLE IS: 1.051

FILE:/PATTERNING/CENTERFIRE_PATT/C6649097

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS = 3.708

VS = 2.873

GS = 4.008

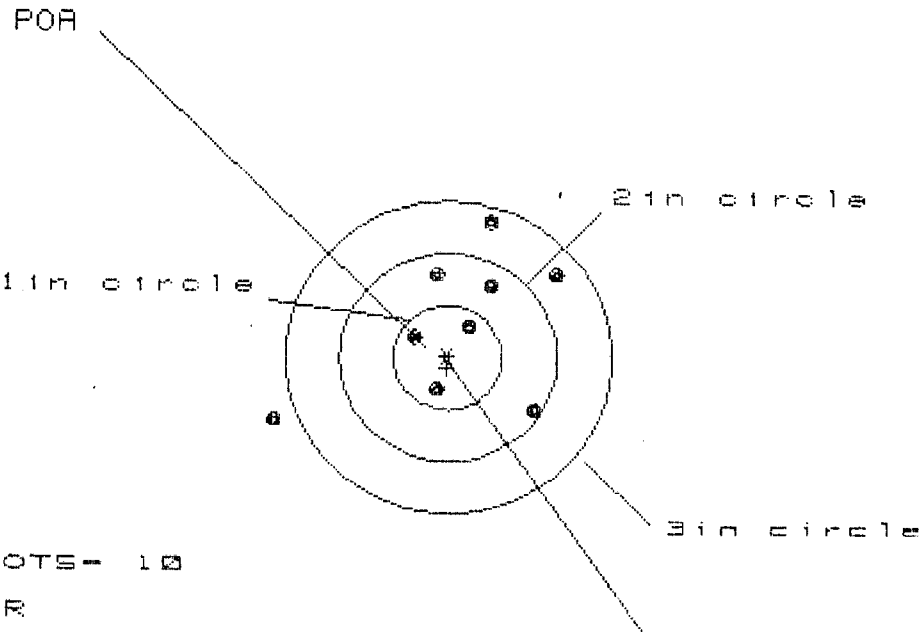
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.183	1.334	1.282
MINIMUM X	-1.525	-1.283	-1.335
MAXIMUM Y	.813	.898	.652
MINIMUM Y	-2.060	-1.975	-1.786
CENTROID X	-.149	-.391	-.339
CENTROID Y	-.189	-.274	-.028
POR TO CENTROID in.	.240	.478	.340
1 IN RADIUS	.357	.504	.502
MEAN RADIUS	1.319	1.226	1.103
MAX RADIUS	2.315	2.018	1.438
HORIZONTAL SPREAD	3.708	2.617	2.617
VERTICAL SPREAD	2.873	2.873	1.438
EXTREME SPREAD	4.009	3.363	2.752
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

1 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649097

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.505

VS= 3.938

GS= 4.060

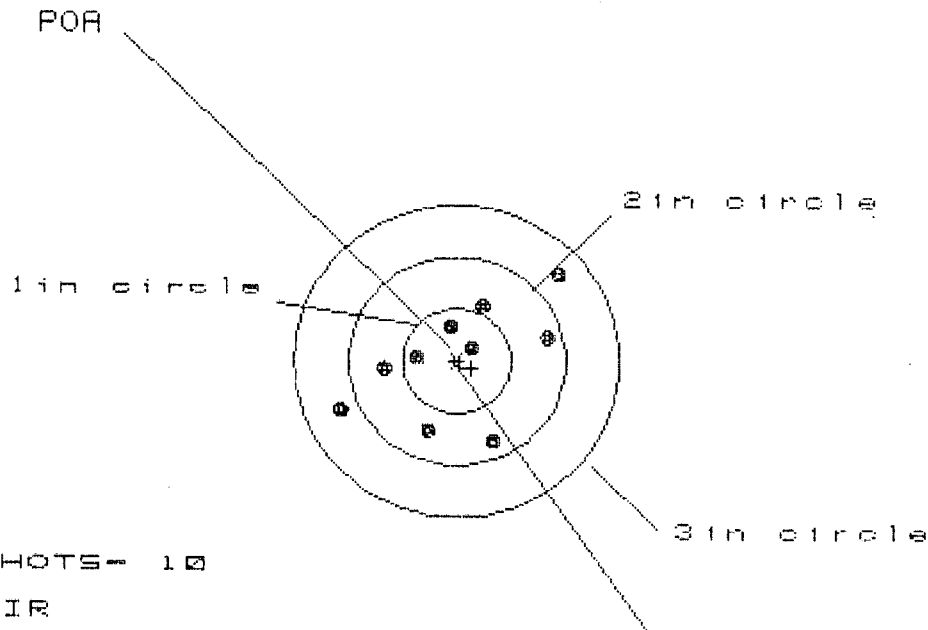
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.943	.879	.675
MINIMUM X	-1.562	-1.626	-.541
MAXIMUM Y	1.271	.974	.859
MINIMUM Y	-2.667	-.921	-.904
CENTROID X	.009	.073	.277
CENTROID Y	.100	.396	.511
POA TO CENTROID in.	.100	.403	.581
MIN RADIUS	.340	.080	.162
MEAN RADIUS	1.058	.791	.642
MAX RADIUS	2.730	1.869	1.055
HORIZONTAL SPREAD	2.505	2.505	1.216
VERTICAL SPREAD	3.938	1.895	1.763
EXTREME SPREAD	4.060	2.891	1.809
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 2.055

VS = 1.629

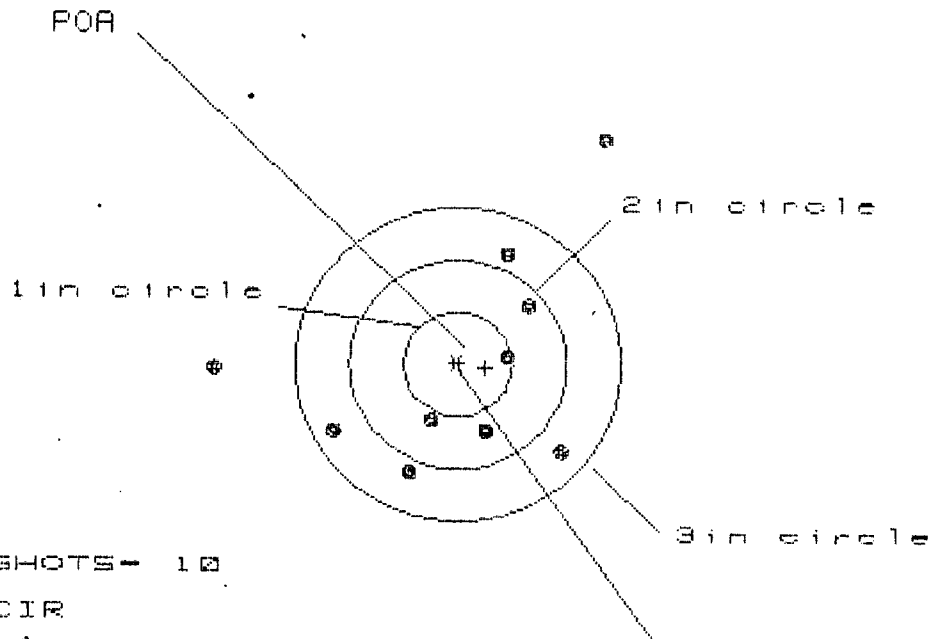
GS = 2.436

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.940	.929	.803
MINIMUM X	-1.115	-1.011	-.657
MAXIMUM Y	.821	.649	.600
MINIMUM Y	-.808	-.717	-.766
CENTROID X	-.133	-.237	-.111
CENTROID Y	.068	-.023	.026
POA TO CENTROID in.	.149	.238	.114
MIN RADIUS	.201	.326	.209
MEAN RADIUS	.705	.645	.578
MAX RADIUS	1.248	1.086	.846
HORIZONTAL SPREAD	2.055	1.940	1.460
VERTICAL SPREAD	1.629	1.366	1.366
EXTREME SPREAD	2.436	2.067	1.494
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.635

VS = 3.119

GS = 4.229

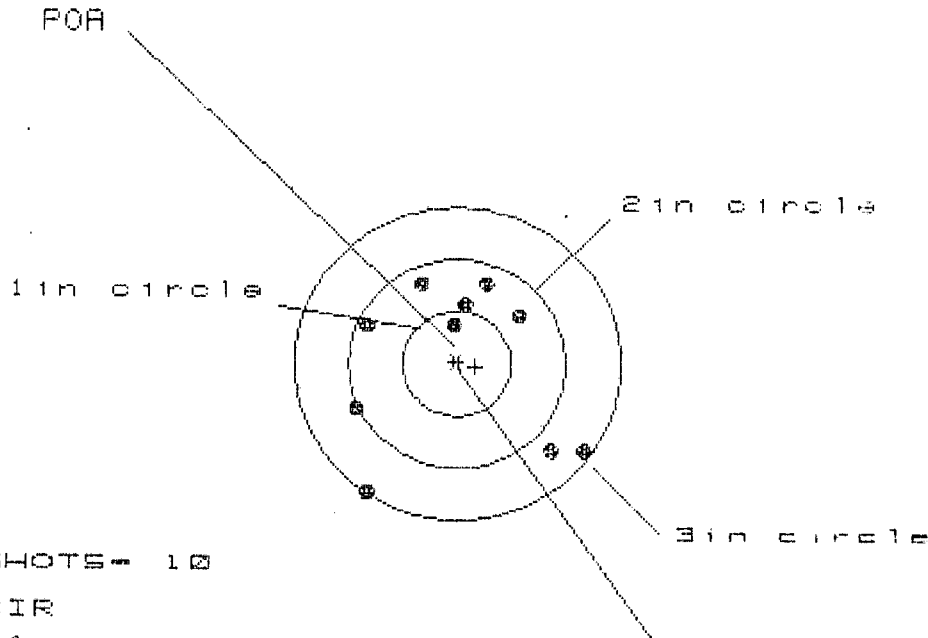
CENTROID *

PATTERN #	:	247	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.350	1.137	.870
MINIMUM X	:	-2.285	-2.135	-1.293
MAXIMUM Y	:	2.119	1.351	1.375
MINIMUM Y	:	-1.000	-.764	-.740
CENTROID X	:	-.254	-.404	-.137
CENTROID Y	:	.034	-.202	-.226
POA TO CENTROID in.	:	.256	.451	.264
MIN RADIUS	:	.456	.354	.430
MEAN RADIUS	:	1.238	1.061	.881
MAX RADIUS	:	2.513	2.144	1.418
HORIZONTAL SPREAD	:	3.635	3.272	2.163
VERTICAL SPREAD	:	3.119	2.115	2.115
EXTREME SPREAD	:	4.229	3.375	2.391
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 2.102

VS = 1.983

GS = 2.330

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.213	1.119	.875
MINIMUM X	-.889	-.983	-.843
MAXIMUM Y	.775	.640	.522
MINIMUM Y	-1.208	-.986	-1.104
CENTROID X	-.168	-.074	-.214
CENTROID Y	.029	.164	.282
POA TO CENTROID in.	.170	.180	.354
MIN RADIUS	.407	.295	.156
MEAN RADIUS	.934	.832	.699
MAX RADIUS	1.473	1.466	1.409
HORIZONTAL SPREAD	2.102	2.102	1.718
VERTICAL SPREAD	1.983	1.626	1.626
EXTREME SPREAD	2.330	2.330	2.027
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		