

C6636207

MODEL 700™ M24

Model **SWS**™

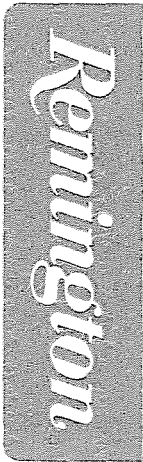
Action

Barrel Length

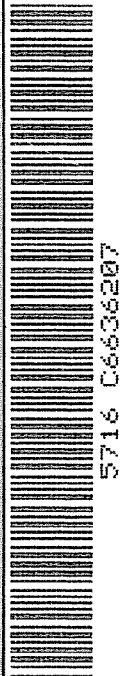
Capacity

Order No. **5715**

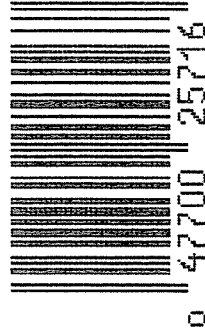
*Includes 1 in chamber.



Remington® REG. U.S. PAT. & TM. OFF. 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6636207	ORDER NO. 5716
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636207

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		6-26-91	KA
	Apply Coating (Bolt)		6-26-91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/91	KA
	C) Inspect Ejector Hole for Chamfer		8/16/91	KA
	D) Oil Firing Pin Ass'y		8/16/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-17-91	D/H

op. #	NAME BARBER - M24 0031739	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-17-91	DH
	G) Safety Off Force	2	2	2			8-17-91	DH
	H) Trigger Pull Test & Retainability						8-17-91	DH
	I) Firing Pin Indent	.020	.020	.021			8-17-91	DH
	J) Assemble Stock						8/17/91	YK
	K) Assemble Swivel Studs						8/22/91	JH
	L) Attach Front and Rear Sight Assemblies						8/17/91	YK
	M) Iron Sight Alignment						8/17/91	YK
	N) Detach Front & Rear Sights & place in numbered container						8/17/91	YK
	O) Attach Scope to Rifle						8/17/91	YK
	P) Detach & Attach Scope 20 Times						8/17/91	YK
640	Gallery Target & Test						8-19-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-19-91	AF
655	Final Inspection							
	A) Headspace						8/22/91	JH
	B) Trigger Pull	242	243	252	250	250	8-21-91	DH
	C) Function						8/22/91	JH
660	Pack						8-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636207

DATE 8-17-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.46	2.42	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.46	2.40	2.43	
PULL #3	2.28	2.50	2.44	2.50	
PULL #4	2.36	2.50	2.48	2.52	
PULL #5	2.49	2.21	2.50	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.15		
PULL #2	3.39	3.17		
PULL #3	3.40	3.27		
PULL #4	3.34	3.03		
PULL #5	3.42	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.40		4.42
PULL #2	4.19	4.37		4.24
PULL #3	3.96	4.32		4.33
PULL #4	4.32	4.32		4.20
PULL #5	4.31	4.40		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636207
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.15203
1 TO	2	.192774
1 TO	3	.374813
1 TO	4	.0930054
1 TO	5	.035805



<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0752
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .139588
THE AMR FOR THIS RIFLE IS: .9636

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636287

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.408

VS= .990

GS= 2.536

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.376	1.291	1.111
MINIMUM X	-1.032	-.879	-.718
MAXIMUM Y	.521	.509	.474
MINIMUM Y	-.469	-.411	-.446
CENTROID X	-.152	-.305	-.466
CENTROID Y	-.003	-.061	-.026
POA TO CENTROID in.	.152	.311	.467
MIN RADIUS	.310	.308	.215
MEAN RADIUS	.810	.704	.597
MAX RADIUS	1.472	1.321	1.178
HORIZONTAL SPREAD	2.408	2.170	1.829
VERTICAL SPREAD	.990	.920	.920
EXTREME SPREAD	2.536	2.247	1.937
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 1.853

VS= 4.357

GS= 4.415

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.189	1.160	1.213
MINIMUM X	:	-1.664	-1.693	-1.640
MAXIMUM Y	:	2.129	1.882	1.157
MINIMUM Y	:	-2.228	-1.990	-1.755
CENTROID X	:	.019	.048	-1.005
CENTROID Y	:	.086	.333	.098
POA TO CENTROID in.	:	.088	.337	.098
MIN RADIUS	:	.391	.473	.402
MEAN RADIUS	:	1.105	.993	.829
MAX RADIUS	:	2.243	1.930	1.242
HORIZONTAL SPREAD	:	1.853	1.853	1.853
VERTICAL SPREAD	:	4.357	2.872	1.912
EXTREME SPREAD	:	4.415	2.975	2.177
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Aug 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.063

VS= 2.214

GS= 3.257

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.924	.844	.728
MINIMUM X	:	-1.139	-.925	-1.014
MAXIMUM Y	:	.934	.681	.499
MINIMUM Y	:	-1.380	-1.453	-.604
CENTROID X	:	-.041	-.255	-.140
CENTROID Y	:	.355	.508	.690
POA TO CENTROID in.	:	.357	.569	.704
MIN RADIUS	:	.374	.172	.121
MEAN RADIUS	:	.985	.781	.588
MAX RADIUS	:	2.368	1.723	1.147
HORIZONTAL SPREAD	:	3.063	1.769	1.742
VERTICAL SPREAD	:	2.214	2.134	1.103
EXTREME SPREAD	:	3.257	2.749	2.012
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 3.257

VS = 2.481

GS = 3.992

CENTROID *

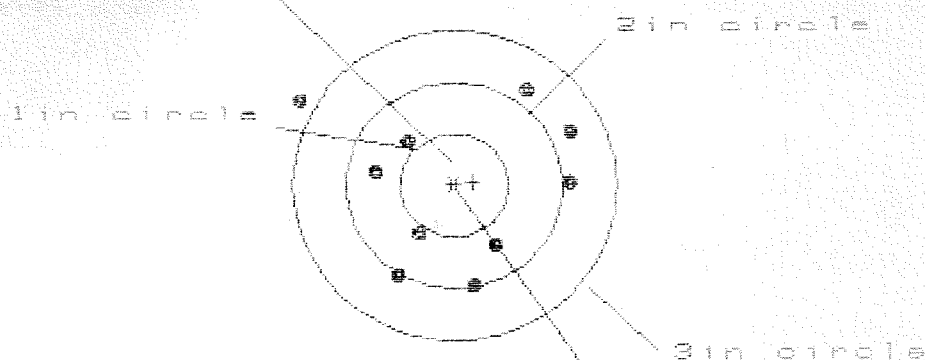
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.929
MINIMUM X	-2.328
MAXIMUM Y	1.543
MINIMUM Y	-.938
CENTROID X	-.241
CENTROID Y	-.030
POA TO CENTROID in.	.243
MIN RADIUS	.309
MEAN RADIUS	.964
MAX RADIUS	2.510
HORIZONTAL SPREAD	3.257
VERTICAL SPREAD	2.481
EXTREME SPREAD	3.992
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

23 Aug 1991

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.504

VS = 1.895

GS = 2.646

CENTROID *

PATTERN #	1	5	9
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.103	.947	1.057
MINIMUM X	-1.401	-.844	-.734
MAXIMUM Y	.948	1.042	1.125
MINIMUM Y	-.947	-.853	-.770
CENTROID X	-.173	-.017	-.127
CENTROID Y	-.032	-.126	-.209
POB TO CENTROID in.	.176	.127	.245
MIN RADIUS	.553	.478	.465
MEAN RADIUS	.954	.868	.812
MAX RADIUS	1.636	1.146	1.270
HORIZONTAL SPREAD	2.504	1.791	1.791
VERTICAL SPREAD	1.895	1.895	1.895
EXTREME SPREAD	2.646	2.197	2.197
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	