C663623 7

MODEL 700™ M24

Model SWS™

Action

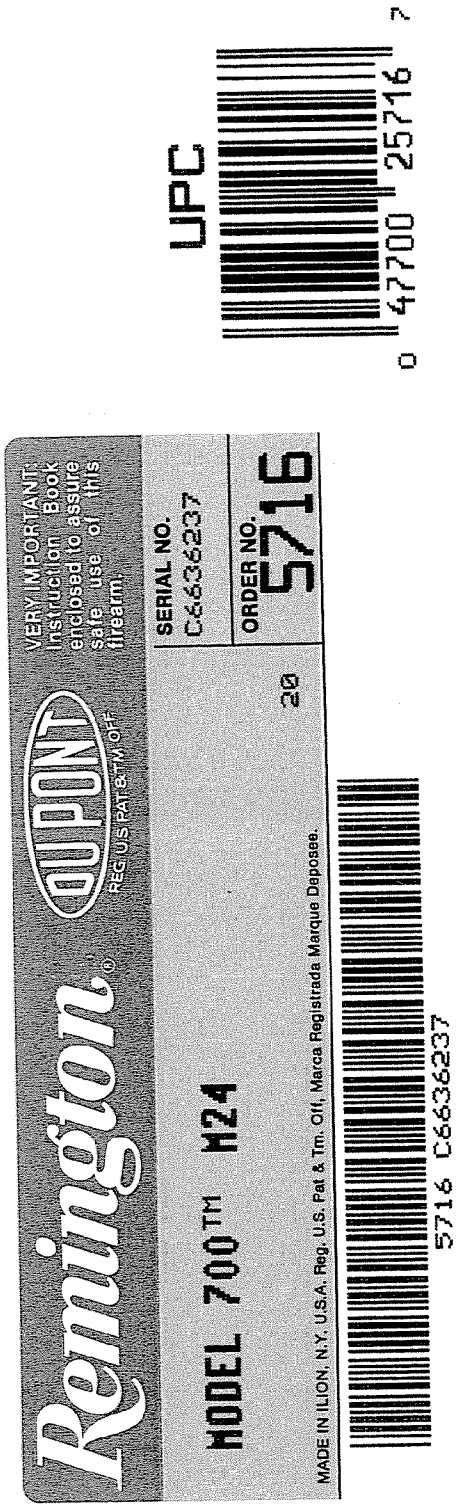
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®


UPC
0 47700 25716 7
Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24
SERIAL NO.
C6636237
ORDER NO.
5716
20
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
5716 C6636237

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636237

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	KcR
	Magnaflux Bolt	5 6	91	KcR
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	
	Apply Coating (Bolt)		5-30-91	
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		6-6-91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-6-91	JH
	G) Safety Off Force	3	3	3			6-6-91	JH.
	H) Trigger Pull Test & Retainability						6-6-91	JH.
	I) Firing Pin Indent	.0205	.0205	.0205			6-6-91	JH.
	J) Assemble Stock						6/6/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/6/91	RW
	M) Iron Sight Alignment						6/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/6/91	RW
	O) Attach Scope to Rifle						6/6/91	RW
	P) Detach & Attach Scope 20 Times						6/6/91	RW
640	Gallery Target & Test						6/7/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clearity of Scope						"	KT
645	Inspect for Live Ammo						6/7/91	KT
655	Final Inspection A) Headspace						6-8-91	DH
	B) Trigger Pull	2.56	2.58	2.60	2.62	2.60	6-8-91	JH.
	C) Function						6-8-91	DH
660	Pack						9-18-91	AE

SWS TRIGGER PULL TEST

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

SERIAL NO. C-66 36237

DATE 6-6-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.60	2.50	2.56	MIN. SETTING,
PULL #2	2.40	2.66	2.55	2.58	NO AVG. OF 5
PULL #3	2.40	2.59	2.60	2.60	READINGS ACCEPT-
PULL #4	2.41	2.64	2.62	2.62	ABLE LESS THAN 2#
PULL #5	2.40	2.42	2.53	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.50		
PULL #2	3.45	3.39		
PULL #3	3.49	3.46		
PULL #4	3.49	3.49		
PULL #5	3.52	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	4.35	4.31		4.30
PULL #2	4.34	4.43		4.49
PULL #3	4.42	4.43		4.46
PULL #4	4.17	4.48		4.22
PULL #5	4.46	4.38		4.34
TOTAL				
AVG.				

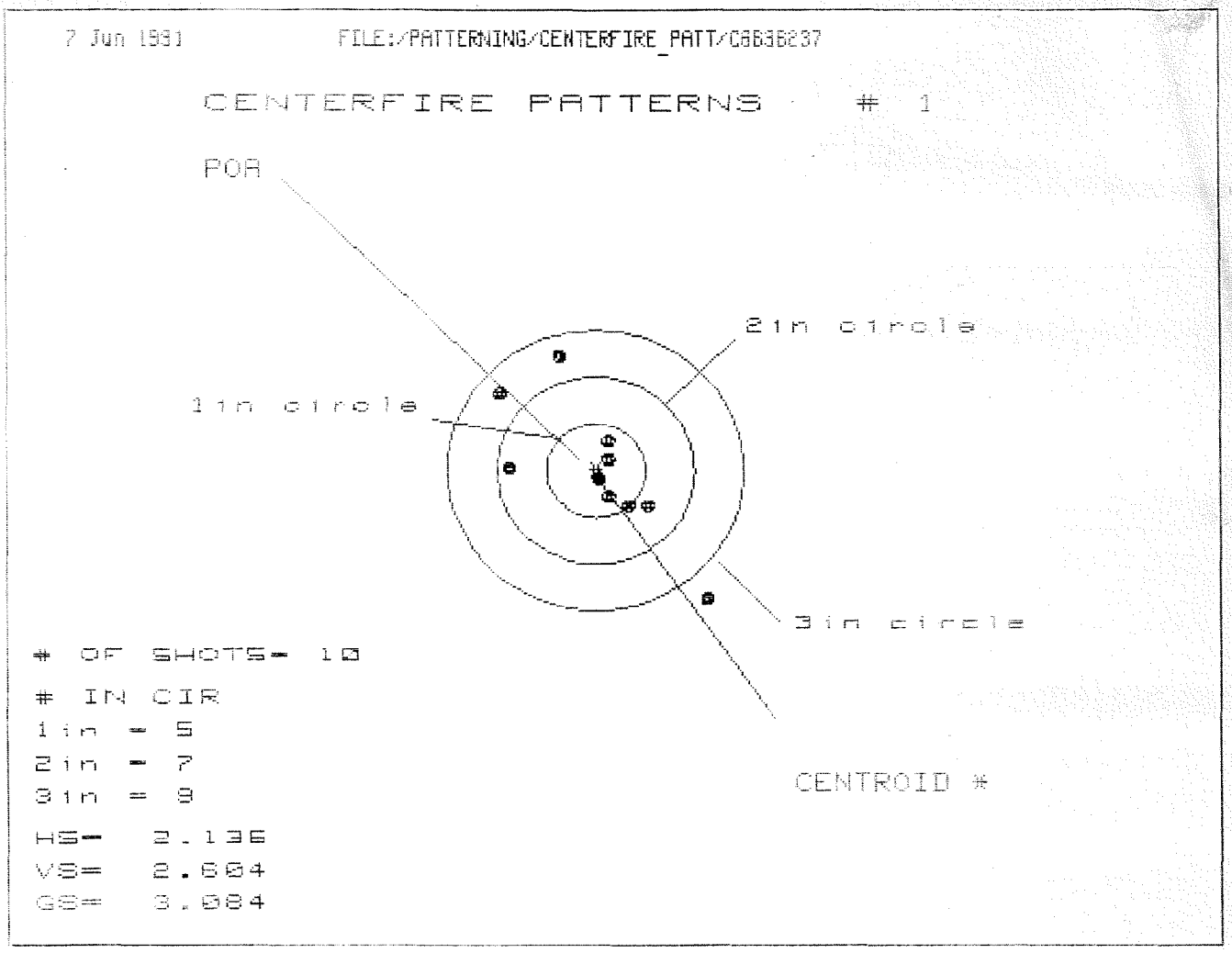
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636237
7 Jun 1991

CENTROIDAL DISTANCES

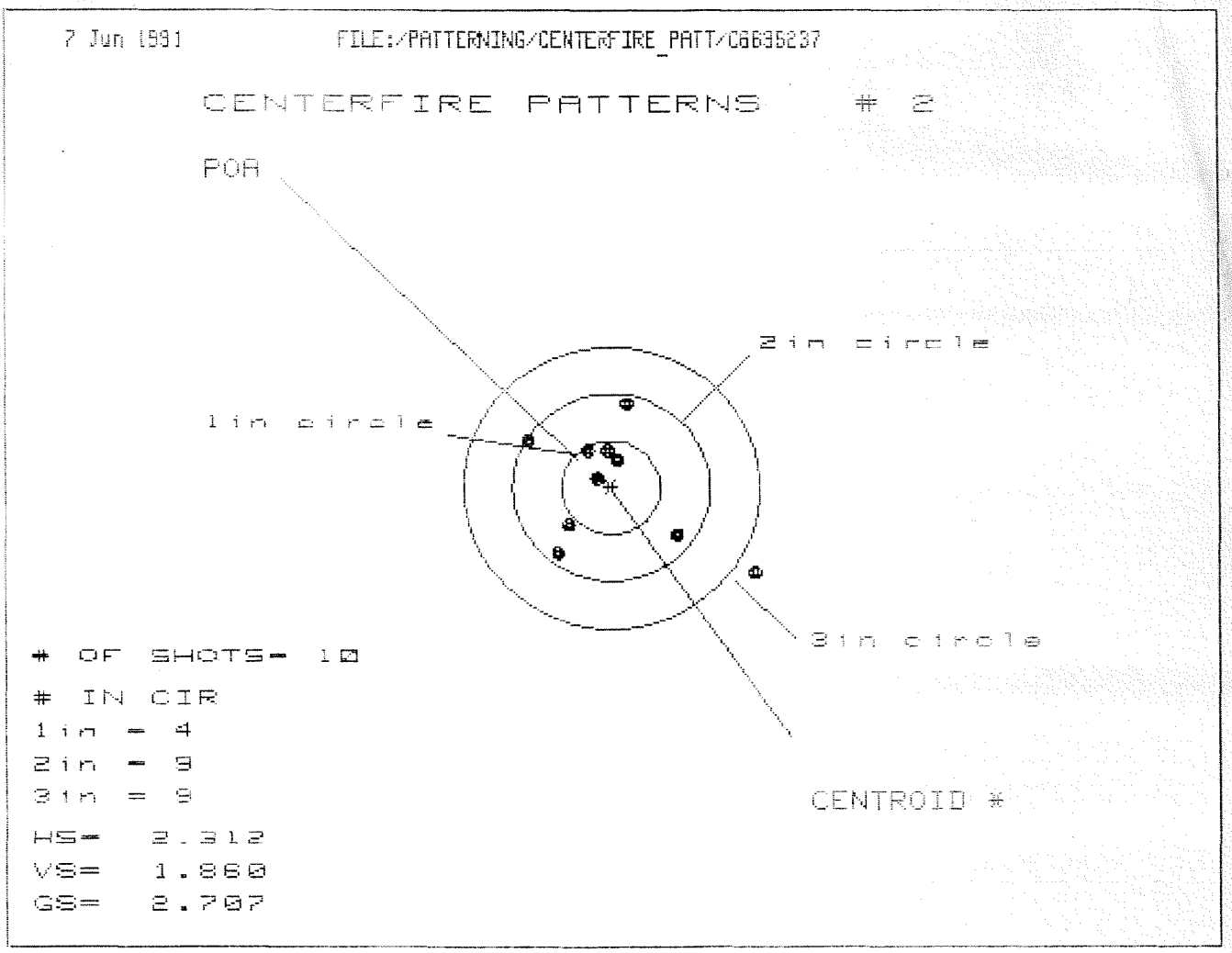
0	TO	1	.0803243
1	TO	2	.241897
1	TO	3	.211154
1	TO	4	.12083
1	TO	5	.0778974

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0404
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0515379

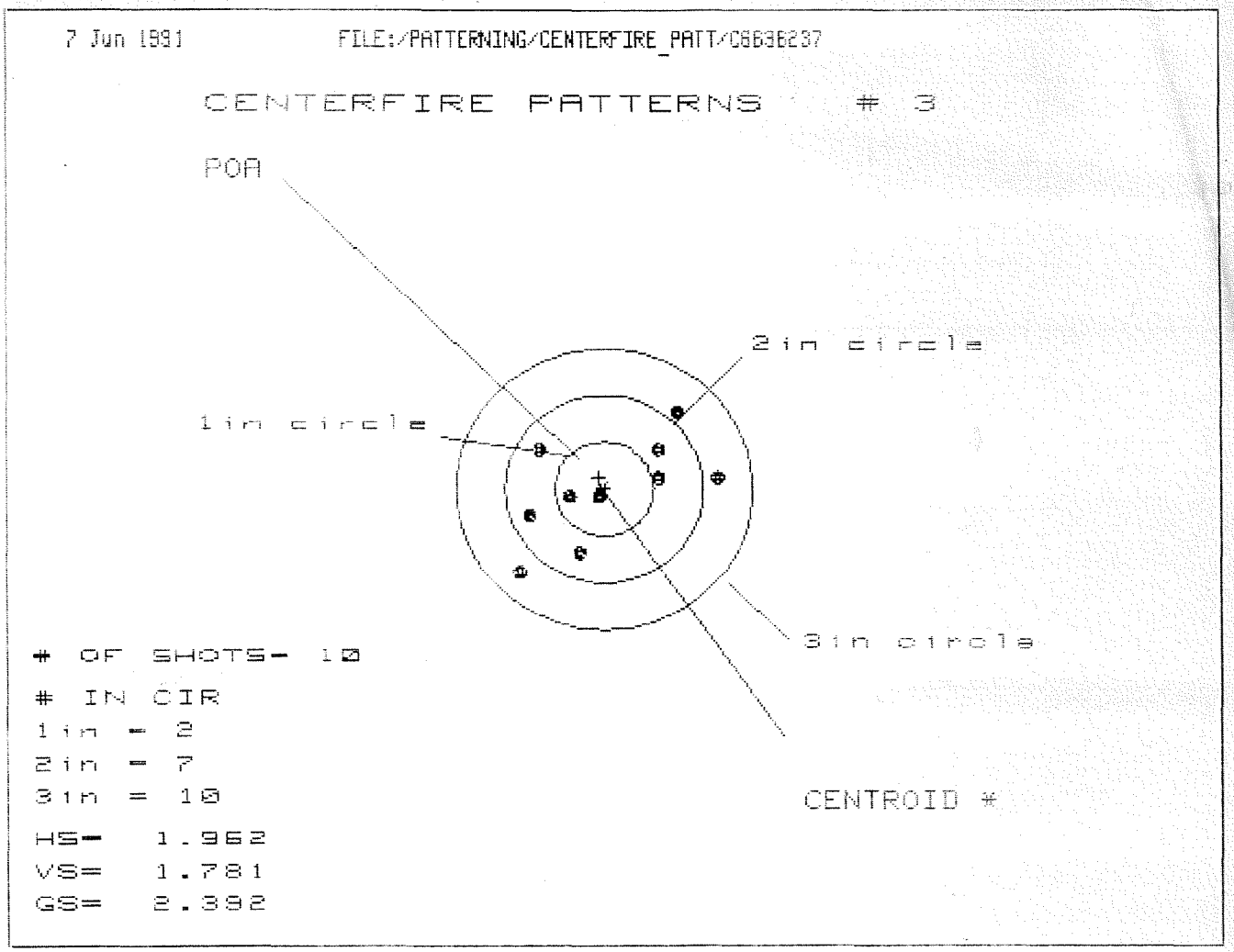
THE AMR FOR THIS RIFLE IS: .7504



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.123	.605	.494
MINIMUM X	:	-1.013	-.889	-.879
MAXIMUM Y	:	1.180	1.022	1.102
MINIMUM Y	:	-1.424	-.536	-.456
CENTROID X	:	-.026	-.150	-.039
CENTROID Y	:	.076	.234	.154
POA TO CENTROID in.	:	.080	.278	.159
MIN RADIUS	:	.104	.229	.136
MEAN RADIUS	:	.721	.632	.524
MAX RADIUS	:	1.813	1.097	1.154
HORIZONTAL SPREAD	:	2.136	1.494	1.373
VERTICAL SPREAD	:	2.604	1.558	1.558
EXTREME SPREAD	:	3.084	1.890	1.750
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



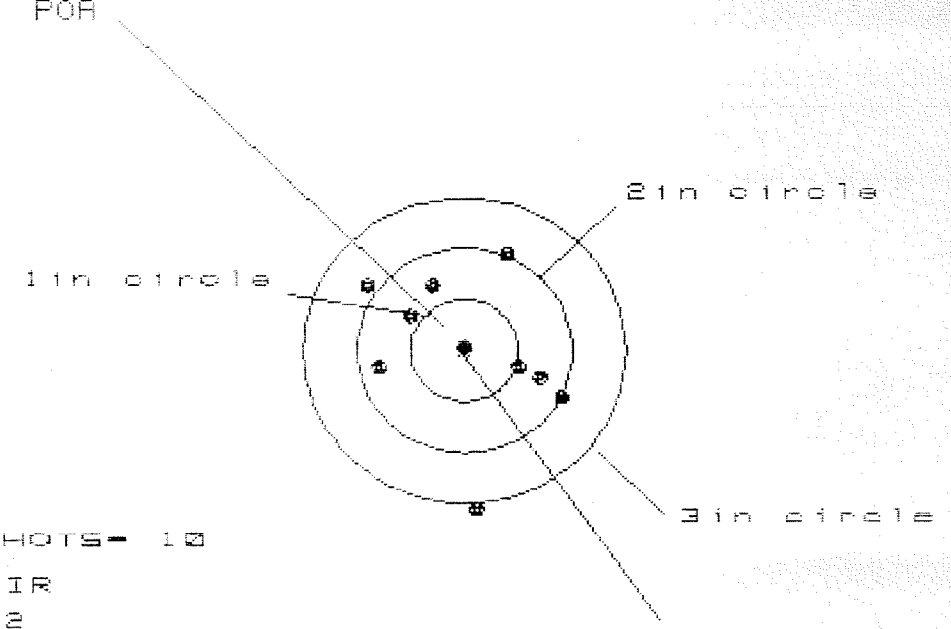
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.476	.778	.694
MINIMUM X	:	-.836	-.672	-.441
MAXIMUM Y	:	.929	.826	.972
MINIMUM Y	:	-.931	-.836	-.789
CENTROID X	:	.141	-.023	.061
CENTROID Y	:	-.099	.004	-.042
POA TO CENTROID in.	:	.172	.024	.074
MIN RADIUS	:	.216	.024	.119
MEAN RADIUS	:	.727	.557	.543
MAX RADIUS	:	1.745	1.003	.908
HORIZONTAL SPREAD	:	2.312	1.450	1.135
VERTICAL SPREAD	:	1.860	1.662	1.662
EXTREME SPREAD	:	2.707	1.787	1.787
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.127	1.035	1.118
MINIMUM X	:	-.835	-.886	-.803
MAXIMUM Y	:	.852	.748	.447
MINIMUM Y	:	-.929	-.751	-.657
CENTROID X	:	.055	.147	.064
CENTROID Y	:	-.119	-.015	-.109
POA TO CENTROID in.	:	.131	.148	.126
MIN RADIUS	:	.125	.263	.138
MEAN RADIUS	:	.777	.731	.674
MAX RADIUS	:	1.249	1.035	1.126
HORIZONTAL SPREAD	:	1.962	1.921	1.921
VERTICAL SPREAD	:	1.781	1.499	1.104
EXTREME SPREAD	:	2.392	1.963	1.963
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Jun 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6636237

CENTERFIRE PATTERNS # 4

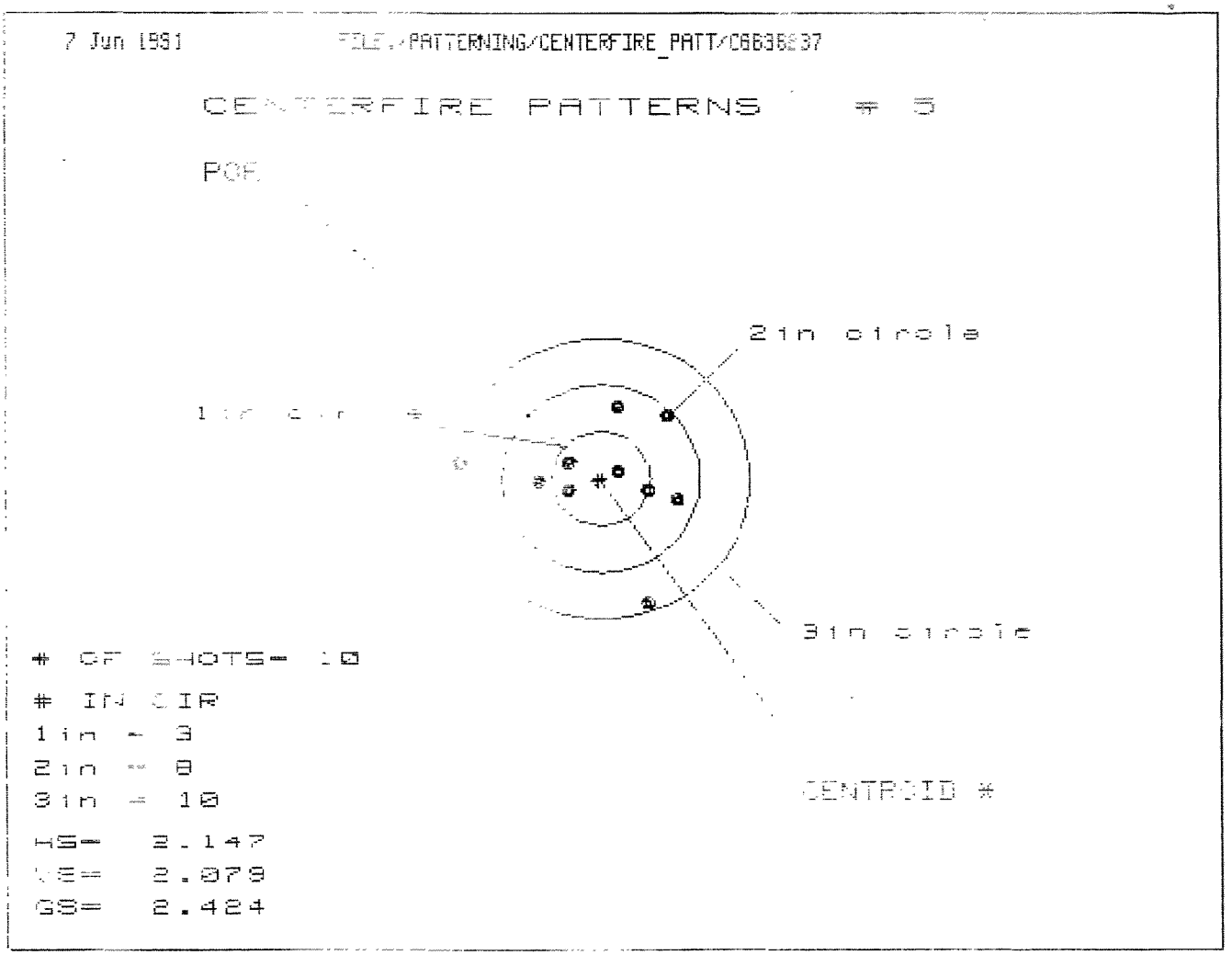


OF SHOTS= 10

# IN CIR
1in = 2
2in = 7
3in = 9

HS= 1.817
VS= 2.447
GS= 2.475

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.878	.883	.767
MINIMUM X	:	-.939	-.934	-.867
MAXIMUM Y	:	.908	.737	.797
MINIMUM Y	:	-1.539	-.582	-.522
CENTROID X	:	.000	-.005	.111
CENTROID Y	:	-.042	.129	.069
POA TO CENTROID in.	:	.042	.129	.131
MIN RADIUS	:	.074	.097	.114
MEAN RADIUS	:	.798	.700	.651
MAX RADIUS	:	1.540	1.058	.928
HORIZONTAL SPREAD	:	1.817	1.817	1.634
VERTICAL SPREAD	:	2.447	1.319	1.319
EXTREME SPREAD	:	2.475	2.104	1.650
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.734	.576	.615
MINIMUM X	:	-1.413	-.756	-.717
MAXIMUM Y	:	.742	.743	.598
MINIMUM Y	:	-1.337	-1.316	-.414
CENTROID X	:	.032	.189	.150
CENTROID Y	:	.024	.003	.168
POA TO CENTROID in.	:	.040	.199	.225
MIN RADIUS	:	.144	.049	.120
MEAN RADIUS	:	.729	.640	.541
MAX RADIUS	:	1.426	1.352	.741
HORIZONTAL SPREAD	:	2.147	1.332	1.152
VERTICAL SPREAD	:	2.079	2.079	1.012
EXTREME SPREAD	:	2.424	2.100	1.432
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	