

C6636275

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

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

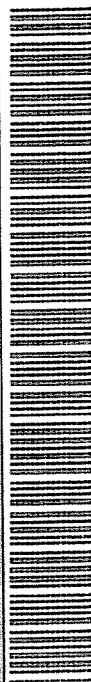
MODEL 700™ M24

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

SERIAL NO.
C6636275

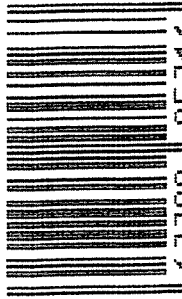
ORDER NO.
5716

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



5716 C6636275

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636275

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	8 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	LS
617	Drill and Tap Sight Holes		JUL 1 1991	FB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8/7/91	FB
	Apply Coating (Bolt)		8/7/91	FB
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/5/91	JK

op. #	BARBER - M24 0032502 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/5/91	JK
	G) Safety Off Force	3	3	3			9/5/91	JK
	H) Trigger Pull Test & Retainability						9/5/91	JK
	I) Firing Pin Indent	.021	.022	.022			9/5/91	JK
	J) Assemble Stock						9/9/91	RW
	K) Assemble Swivel Studs						9-12-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/9/91	RW
	M) Iron Sight Alignment						9/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	RW
	O) Attach Scope to Rifle						9/9/91	RW
	P) Detach & Attach Scope 20 Times						9/9/91	RW
640	Gallery Target & Test						9-9-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-9-91	AF
655	Final Inspection							
	A) Headspace						9-12-91	D/H
	B) Trigger Pull	239	225	211	208	203	9-11-91	D/H
	C) Function						9-12-91	D/H
660	Pack						9-11-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636275DATE 9-6-91TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.30	2.48	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.17	2.30	2.25	
PULL #3	2.37	2.27	2.33	2.11	
PULL #4	2.25	2.49	2.45	2.08	
PULL #5	2.24	2.46	2.49	2.03	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.40		
PULL #2	3.34	3.35		
PULL #3	3.33	3.38		
PULL #4	3.41	3.38		
PULL #5	3.37	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	4.43	4.23		4.25
PULL #2	4.23	4.34		4.20
PULL #3	4.36	4.31		4.44
PULL #4	4.38	4.18		4.51
PULL #5	4.20	4.31		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06646275
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0667083
1 TO	2	.270254
1 TO	3	.348528
1 TO	4	.177553
1 TO	5	.242992

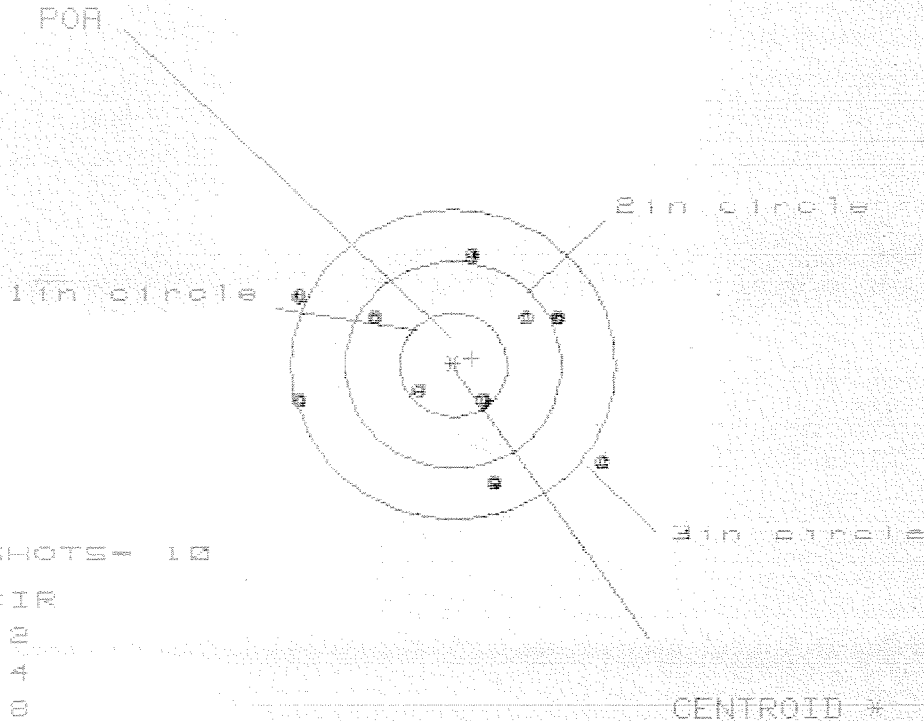
MI <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1384
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0538
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148489
THE AMR FOR THIS RIFLE IS: 1.012

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646275

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.776

VS= 2.208

GS= 3.218

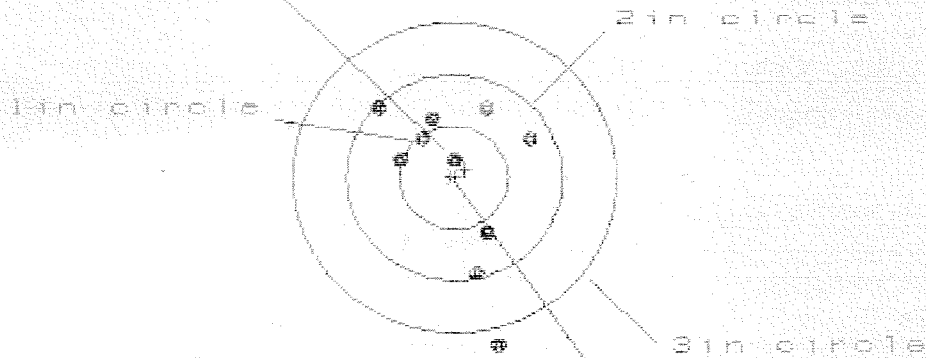
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.374	1.170	1.014
MINIMUM X	-1.402	-1.249	-1.393
MAXIMUM Y	1.051	.948	1.022
MINIMUM Y	-1.157	-1.260	-1.186
CENTROID X	-.173	-.326	-.170
CENTROID Y	-.064	.039	-.035
POR TO CENTROID in.	.184	.328	.173
MIN RADIUS	.385	.385	.407
MEAN RADIUS	1.048	.977	.988
MAX RADIUS	1.658	1.384	1.442
HORIZONTAL SPREAD	2.776	2.419	2.406
VERTICAL SPREAD	2.208	2.208	2.208
EXTREME SPREAD	3.218	2.541	2.525
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646275

CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 9

HS= 1.362

VS= 2.338

GS= 2.551

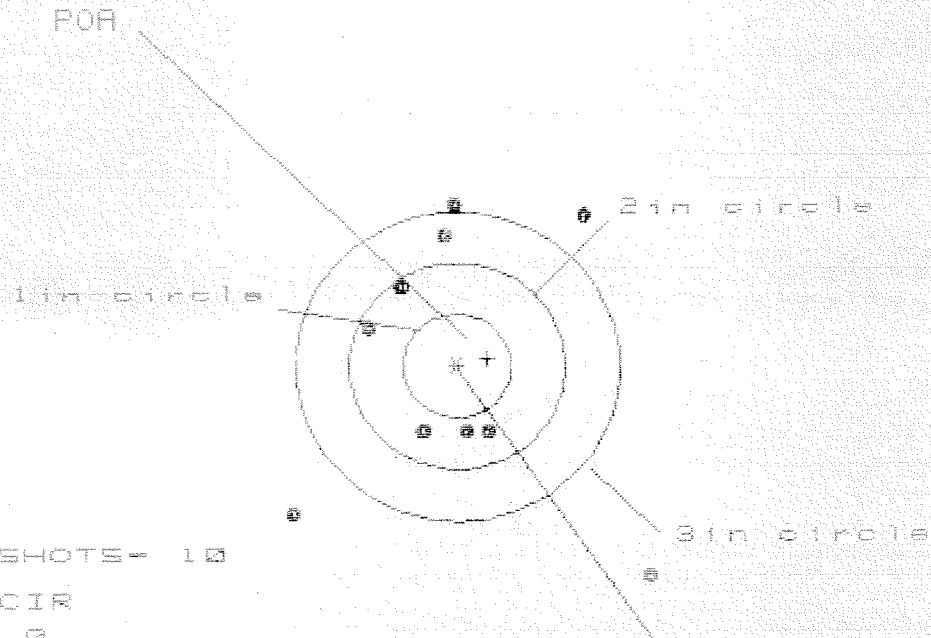
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.671	.711	.739
MINIMUM X	-.691	-.651	-.623
MAXIMUM Y	.688	.504	.361
MINIMUM Y	-1.650	-1.145	-.835
CENTROID X	-.101	-.141	-.169
CENTROID Y	-.078	.106	.249
POR TO CENTROID in.	.128	.176	.301
MIN RADIUS	.196	.065	.161
MEAN RADIUS	.768	.611	.519
MAX RADIUS	1.688	1.168	.902
HORIZONTAL SPREAD	1.362	1.362	1.362
VERTICAL SPREAD	2.338	1.649	1.196
EXTREME SPREAD	2.551	1.860	1.528
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	9	

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B46275

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 6

HS= 3.320

VS= 3.578

GS= 4.019

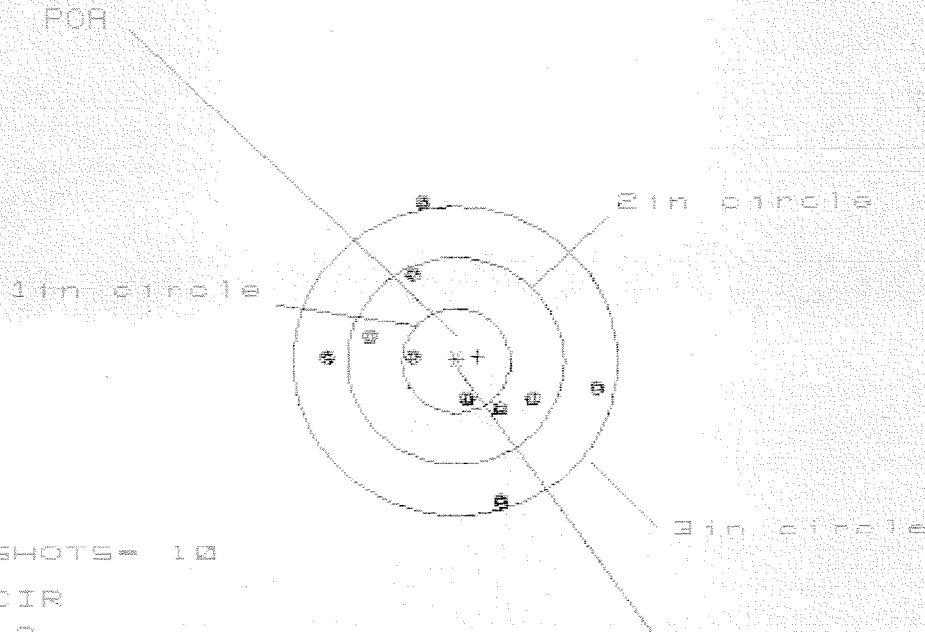
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.923	1.406	1.244
MINIMUM X	-1.497	-1.294	-1.774
MAXIMUM Y	1.560	1.336	1.133
MINIMUM Y	-2.018	-1.623	-1.087
CENTROID X	-1.279	-1.482	-1.320
CENTROID Y	-1.071	1.153	1.356
POA TO CENTROID in.	1.288	1.586	1.479
MIN RADIUS	1.649	1.622	1.618
MEAN RADIUS	1.333	1.148	1.030
MAX RADIUS	2.720	2.076	1.597
HORIZONTAL SPREAD	3.320	2.700	2.018
VERTICAL SPREAD	3.578	2.959	2.220
EXTREME SPREAD	4.019	3.909	2.604
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6846275

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.417

VS= 2.894

GS= 2.980

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.266	1.236	1.288
MINIMUM X	-1.151	-1.181	-1.129
MAXIMUM Y	1.507	1.020	.868
MINIMUM Y	-1.387	-1.220	-.422
CENTROID X	-.204	-.174	-.226
CENTROID Y	-.041	-.208	-.056
POA TO CENTROID in.	.208	.271	.232
MIN RADIUS	.358	.194	.353
MEAN RADIUS	.929	.839	.785
MAX RADIUS	1.530	1.288	1.305
HORIZONTAL SPREAD	2.417	2.417	2.417
VERTICAL SPREAD	2.894	2.240	1.290
EXTREME SPREAD	2.980	2.436	2.436
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

9 Sep 1993

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CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.304

VS= 3.203

GS= 3.339

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.083
MINIMUM X	-1.222
MAXIMUM Y	1.582
MINIMUM Y	-1.621
CENTROID X	.065
CENTROID Y	-.015
POB TO CENTROID in.	.066
MIN RADIUS	.151
MEAN RADIUS	.983
MAX RADIUS	1.695
HORIZONTAL SPREAD	2.304
VERTICAL SPREAD	3.203
EXTREME SPREAD	3.339
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8