C6636287

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

Remington®

DUPONT
REG. U.S. PAT. & T.M. OFF.

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

MODEL 700™ M24

SERIAL NO.
C6636287

ORDER NO.
5716

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

20

5716 C6636287

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636287

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS.
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		GS
617	Drill and Tap Sight Holes	5 15 9 1		FS
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-9-91	
	Apply Coating (Bolt)		5-	
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/3/91	

op. #	OPERATION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6/3/91	
	G) Safety Off Force	4	4	4			6/3/91	
	H) Trigger Pull Test & Retainability	5					6/3/91	
	I) Firing Pin Indent	.023	.0225	.0225			6/3/91	
	J) Assemble Stock						6/4/91	KS
	K) Assemble Swivel Studs						6-13-91	
	L) Attach Front and Rear Sight Assemblies						6/4/91	KS
	M) Iron Sight Alignment						6/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	KS
	O) Attach Scope to Rifle						6/4/91	KS
	P) Detach & Attach Scope 20 Times						6/4/91	KS
640	Gallery Target & Test						6/5/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clearity of Scope						"	KT
645	Inspect for Live Ammo						6/5/91	KT
655	Final Inspection A) Headspace						6-13-91	
	B) Trigger Pull	2-72	2-65	2-64	2-72	2-72	6-13-91	
	C) Function						6-13-91	
660	Pack						6-20-91	

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Ejector stick	KS
	2nd	6/7/91 Polished Ejector	KS
	3rd	100 Rd test June 13 1991	OK
	4th		

FUNCTION RD 6654 Rev 1

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF		100 rd test	
TEST	AC	June 12, 1991	KS
TGT			
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

SWS TRIGGER PULL TEST

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

SERIAL NO. C-663628?
DATE 6-3-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.49	2.42	2.72	MIN. SETTING,
PULL #2	2.57	2.34	2.38	2.65	NO AVG. OF 5
PULL #3	2.35	2.31	2.30	2.64	READINGS ACCEPT-
PULL #4	2.48	2.34	2.26	2.72	ABLE LESS THAN 2#
PULL #5	2.42	2.31	2.25	2.72	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.33		
PULL #2	3.34	3.31		
PULL #3	3.33	3.32		
PULL #4	3.34	3.33		
PULL #5	3.32	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.54		4.54
PULL #2	4.15	4.50		4.51
PULL #3	4.18	4.54		4.56
PULL #4	4.54	4.55		4.23
PULL #5	4.52	4.53		4.59
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636287
6 Jun 1991

CENTROIDAL DISTANCES

0	TO	1	.232691
1	TO	2	.43666
1	TO	3	.0383275
1	TO	4	.236409
1	TO	5	.340918

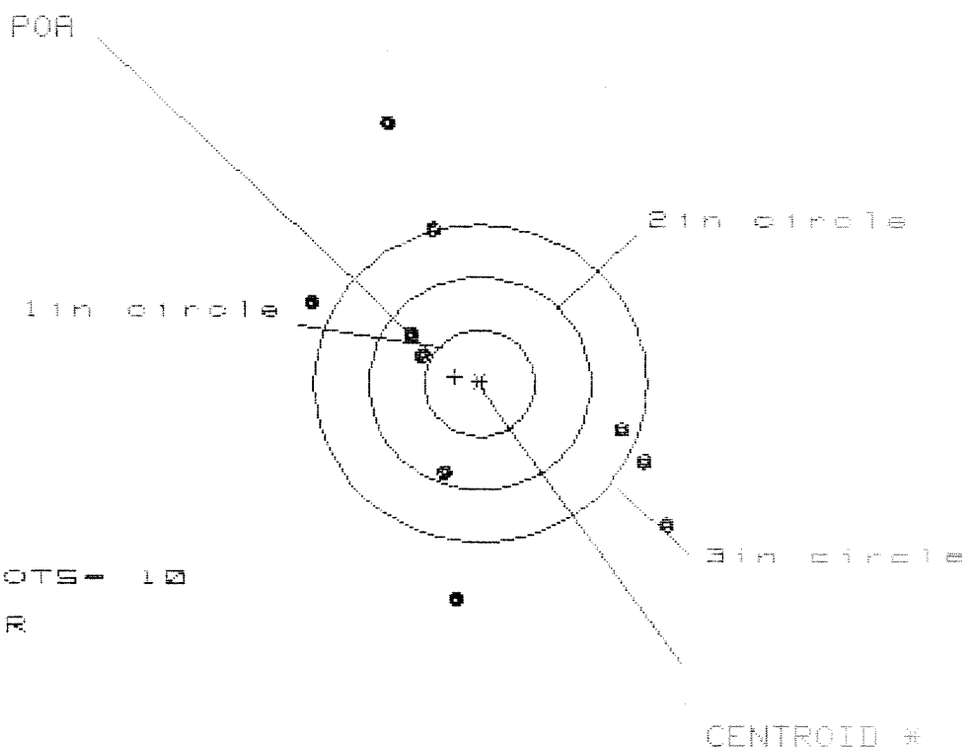
<---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0228
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0848
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0878116

THE AMR FOR THIS RIFLE IS: 1.112

5 Jun 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C8636287

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 3
3in = 5
HS= 3.249
VS= 4.558
GS= 4.621

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.709	1.617	1.605
MINIMUM X	:	-1.540	-1.632	-1.429
MAXIMUM Y	:	2.506	1.700	1.565
MINIMUM Y	:	-2.053	-1.774	-1.909
CENTROID X	:	.224	.316	.113
CENTROID Y	:	-.063	-.341	-.206
POA TO CENTROID in.	:	.232	.465	.235
MIN RADIUS	:	.601	.717	.602
MEAN RADIUS	:	1.537	1.411	1.306
MAX RADIUS	:	2.638	1.945	1.912
HORIZONTAL SPREAD	:	3.249	3.249	3.034
VERTICAL SPREAD	:	4.558	3.474	3.474
EXTREME SPREAD	:	4.621	3.854	3.483
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

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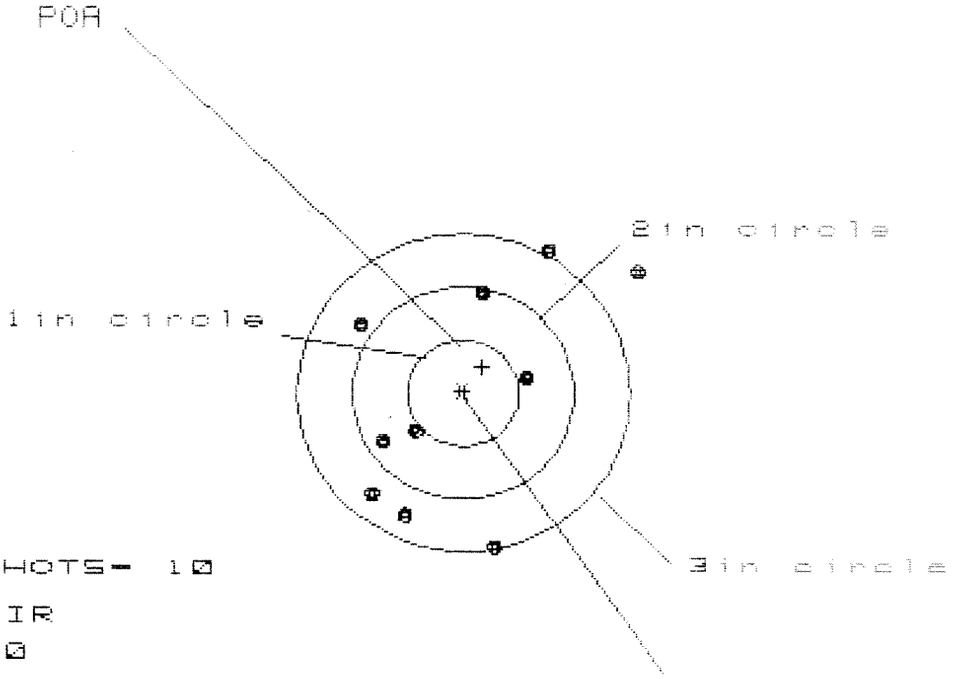
CENTERFIRE PATTERNS # 2



OF SHOTS= 10

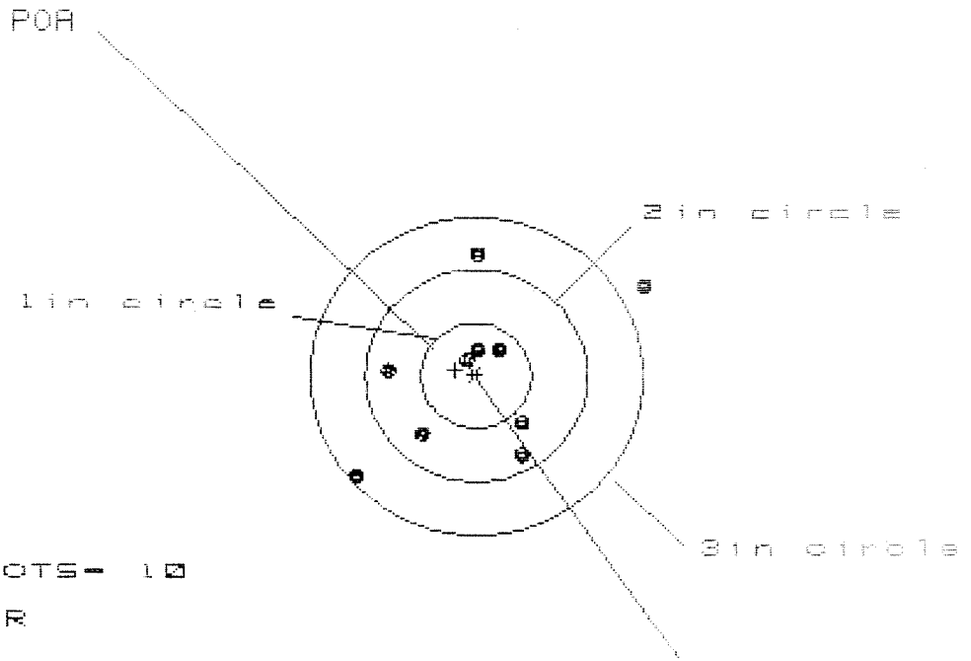
# IN CIR
1in = 0
2in = 4
3in = 8

HS= 2.531
VS= 2.840
GS= 3.189

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.620	.934	.870
MINIMUM X	:	-.911	-.731	-.614
MAXIMUM Y	:	1.395	1.523	1.251
MINIMUM Y	:	-1.445	-1.317	-1.127
CENTROID X	:	-.172	-.352	-.469
CENTROID Y	:	-.247	-.375	-.565
POA TO CENTROID in.	:	.301	.514	.734
MIN RADIUS	:	.564	.343	.168
MEAN RADIUS	:	1.159	1.024	.873
MAX RADIUS	:	1.985	1.786	1.352
HORIZONTAL SPREAD	:	2.531	1.665	1.484
VERTICAL SPREAD	:	2.840	2.840	2.378
EXTREME SPREAD	:	3.189	2.887	2.409
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Jun 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6B3B2B7

CENTERFIRE PATTERNS # 3



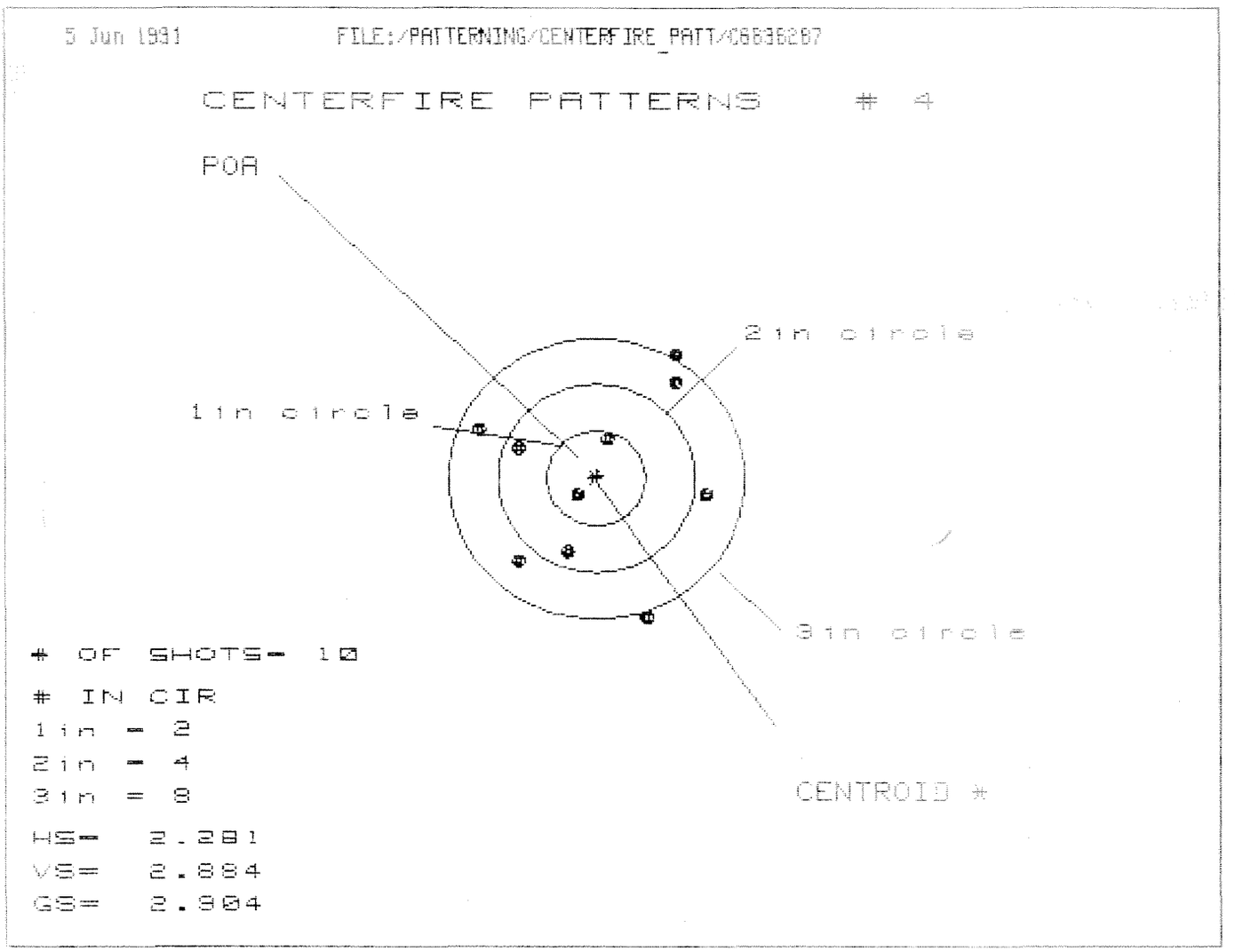
OF SHOTS= 10

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

HS= 2.578
VS= 2.053
GS= 3.129

PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.483	.585	.468
MINIMUM X :	-1.095	-.930	-.784
MAXIMUM Y :	1.155	1.253	1.153
MINIMUM Y :	-.897	-.800	-.719
CENTROID X :	.187	.022	.139
CENTROID Y :	-.053	-.151	-.051
POA TO CENTROID in.:	.195	.152	.148
MIN RADIUS :	.153	.211	.121
MEAN RADIUS :	.809	.715	.618
MAX RADIUS :	1.722	1.261	1.153
HORIZONTAL SPREAD :	2.578	1.515	1.253
VERTICAL SPREAD :	2.053	2.053	1.872
EXTREME SPREAD :	3.129	2.317	1.921
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.080	1.174	1.249
MINIMUM X	:	-1.201	-1.107	-1.032
MAXIMUM Y	:	1.369	1.172	1.001
MINIMUM Y	:	-1.515	-1.363	-.875
CENTROID X	:	-.009	-.103	-.178
CENTROID Y	:	-.023	-.175	-.004
POA TO CENTROID in.	:	.024	.203	.178
MIN RADIUS	:	.299	.131	.286
MEAN RADIUS	:	1.040	.951	.875
MAX RADIUS	:	1.609	1.490	1.368
HORIZONTAL SPREAD	:	2.281	2.281	2.281
VERTICAL SPREAD	:	2.884	2.535	1.876
EXTREME SPREAD	:	2.904	2.622	2.453
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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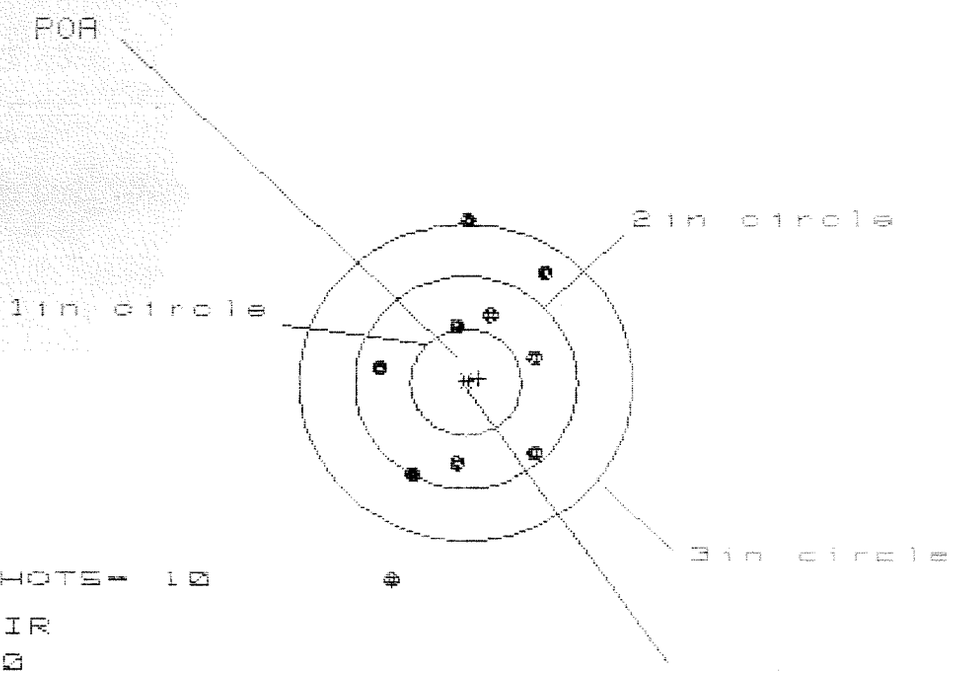
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 0
2in = 7
3in = 8

HS= 1.548
VS= 3.378
GS= 3.443

PATTERN # : 5

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	.731	.658	.651
MINIMUM X :	-.817	-.890	-.897
MAXIMUM Y :	1.522	1.316	1.043
MINIMUM Y :	-1.856	-1.048	-.864
CENTROID X :	-.116	-.043	-.036
CENTROID Y :	-.038	.168	.004
POA TO CENTROID in.:	.122	.174	.036
MIN RADIUS :	.552	.363	.524
MEAN RADIUS :	1.015	.872	.824
MAX RADIUS :	1.968	1.317	1.230
HORIZONTAL SPREAD :	1.548	1.548	1.548
VERTICAL SPREAD :	3.378	2.364	1.927
EXTREME SPREAD :	3.443	2.421	2.292

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8