

C6636292

MODEL 700™ M24

Model **SWS**

Action _____™

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

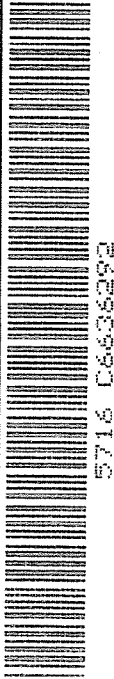
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6636292

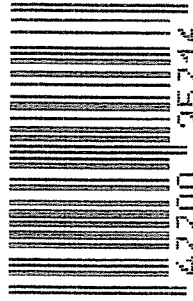
ORDER NO.
5716

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



5716 C6636292

UPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636292

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	K.S.
600	Proof		5/3/91	K.S.
607	Check Headspace		5/3/91	K.S.
610	Dis-assemble Gun		5/3/91	K.S.
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)		8-6-91	JA
	Apply Coating (Bolt)		8-6-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KR
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KR
	C) Inspect Ejector Hole for Chamfer		8/22/91	KR
	D) Oil Firing Pin Ass'y		8/22/91	KR
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	JA

op. #	BARBER M24 0032694	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5½	6			8-23-91	DH
	G) Safety Off Force	2½	2½	2½			8-23-91	DH
	H) Trigger Pull Test & Retainability						8/23/91	RL
	I) Firing Pin Indent	1022	1022	020			8-23-91	DH
	J) Assemble Stock						8/28/91	KS
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	KS
	M) Iron Sight Alignment						8/28/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	KS
	O) Attach Scope to Rifle						8/28/91	KS
	P) Detach & Attach Scope 20 Times						8/28/91	KS
640	Gallery Target & Test						8-29-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-29-91	AF
655	Final Inspection							
	A) Headspace						8-31-91	DH
	B) Trigger Pull	243	243	244	250	254	8-31-91	DH
	C) Function						8-31-91	DH
660	Pack						9-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636292DATE 8/23/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.27	2.44	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.50	2.40	2.43	
PULL #3	2.29	2.40	2.48	2.44	
PULL #4	2.23	2.34	2.42	2.50	
PULL #5	2.32	2.46	2.42	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.49		
PULL #2	3.60	3.45		
PULL #3	3.56	3.50		
PULL #4	3.62	3.44		
PULL #5	3.60	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.23		4.33
PULL #2	4.32	4.33		4.42
PULL #3	4.40	4.45		4.60
PULL #4	4.38	4.51		4.34
PULL #5	4.39	4.56		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636292
29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.191943
1 TO	2	.494628
1 TO	3	.268911
1 TO	4	.0839345
1 TO	5	.719184

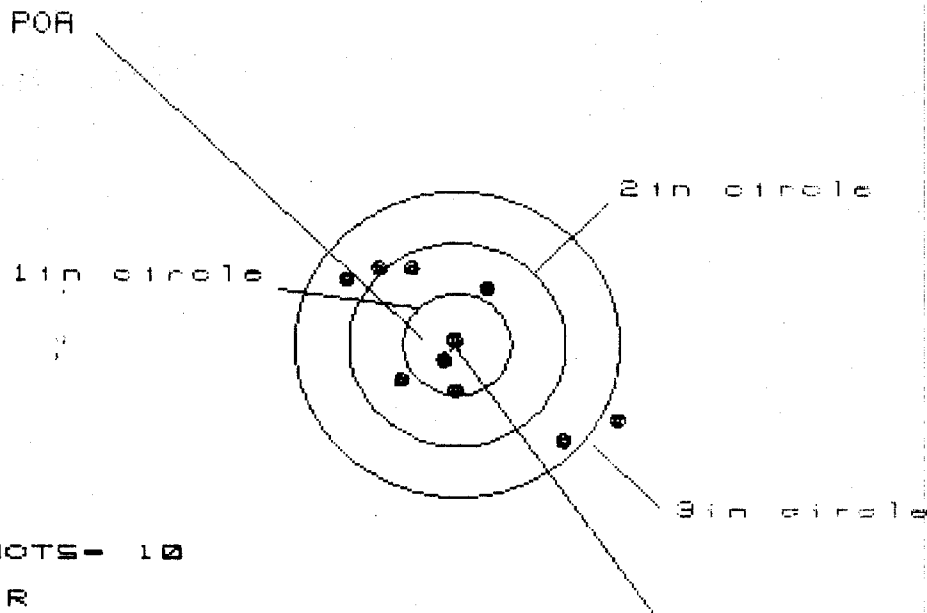
$\frac{2}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1328
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2044
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243752
THE AMR FOR THIS RIFLE IS: .908

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636292

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.501

VS= 1.743

GS= 2.874

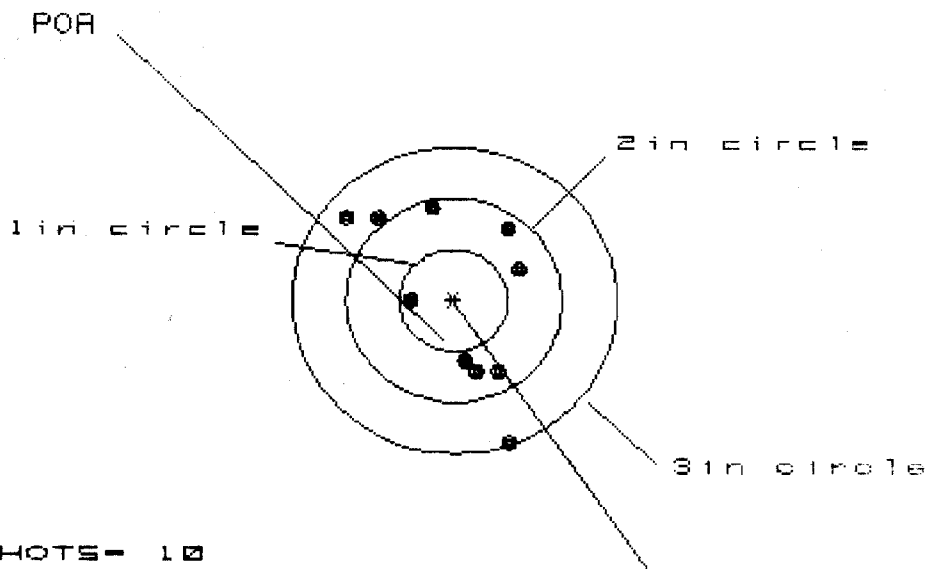
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.520	1.165	.640
MINIMUM X	:	-.981	-.813	-.667
MAXIMUM Y	:	.789	.703	.573
MINIMUM Y	:	-.954	-1.040	-.690
CENTROID X	:	.121	-.047	-.193
CENTROID Y	:	.149	.235	.365
POA TO CENTROID in.	:	.192	.240	.413
MIN RADIUS	:	.048	.192	.375
MEAN RADIUS	:	.828	.726	.629
MAX RADIUS	:	1.706	1.562	.790
HORIZONTAL SPREAD	:	2.501	1.978	1.307
VERTICAL SPREAD	:	1.743	1.743	1.263
EXTREME SPREAD	:	2.874	2.540	1.443
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.588

VS= 2.316

GS= 2.633

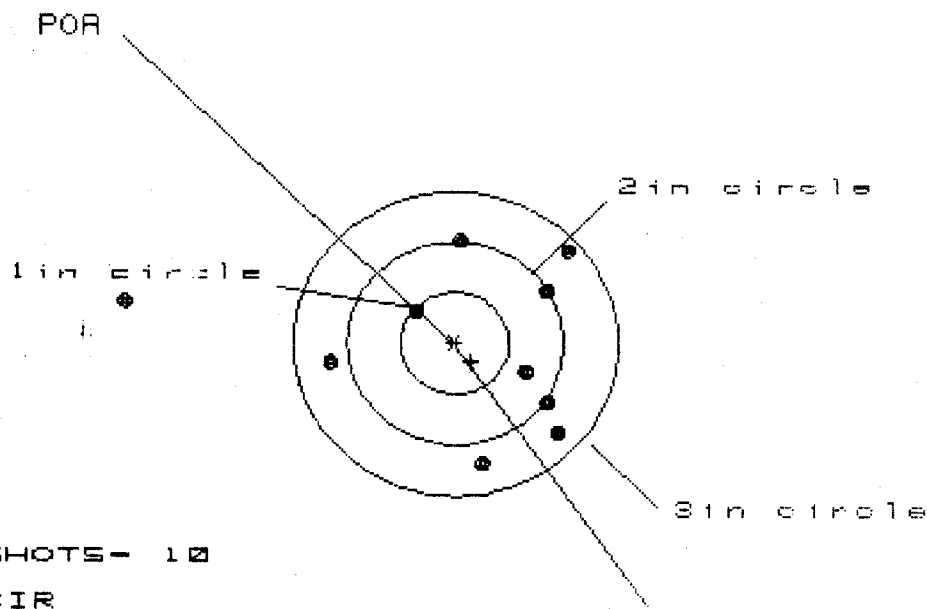
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.599	.656	.539
MINIMUM X	-.989	-.932	-.745
MAXIMUM Y	.925	.770	.847
MINIMUM Y	-1.391	-.863	-.786
CENTROID X	-.103	-.160	-.043
CENTROID Y	.590	.745	.668
POA TO CENTROID in.	.599	.762	.669
MIN RADIUS	.405	.392	.475
MEAN RADIUS	.876	.803	.752
MAX RADIUS	1.483	1.117	1.019
HORIZONTAL SPREAD	1.588	1.588	1.284
VERTICAL SPREAD	2.316	1.633	1.633
EXTREME SPREAD	2.633	2.034	1.841
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 2

3 in = 9

HS = 4.169

VS = 2.228

GS = 4.196

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.090	.748	.668
MINIMUM X	:	-3.079	-1.505	-1.412
MAXIMUM Y	:	.999	1.046	1.165
MINIMUM Y	:	-1.229	-1.182	-1.063
CENTROID X	:	-.146	.196	.103
CENTROID Y	:	.181	.134	.015
POR TO CENTROID in.	:	.232	.238	.104
MIN RADIUS	:	.531	.387	.430
MEAN RADIUS	:	1.247	.966	.936
MAX RADIUS	:	3.109	1.514	1.413
HORIZONTAL SPREAD	:	4.169	2.253	2.080
VERTICAL SPREAD	:	2.228	2.228	2.228
EXTREME SPREAD	:	4.196	2.512	2.233
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.597

VS= 1.501

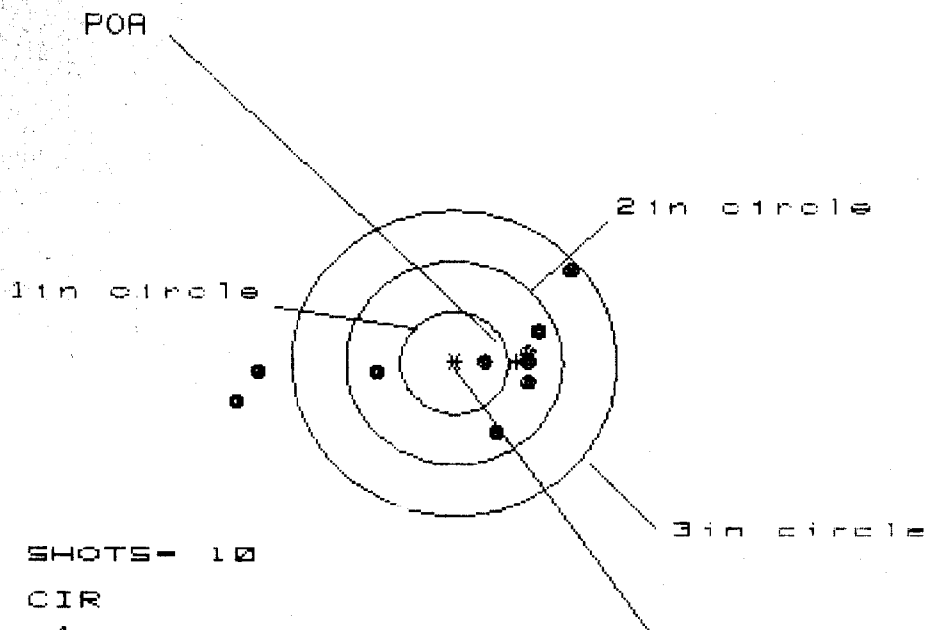
GS= 1.879

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.626	.519	.454
MINIMUM X	:	-.971	-.515	-.511
MAXIMUM Y	:	.801	.736	.650
MINIMUM Y	:	-.700	-.765	-.673
CENTROID X	:	.043	.150	.215
CENTROID Y	:	.118	.183	.091
POA TO CENTROID in.	:	.126	.237	.233
MIN RADIUS	:	.059	.066	.134
MEAN RADIUS	:	.580	.502	.451
MAX RADIUS	:	1.132	.899	.734
HORIZONTAL SPREAD	:	1.597	1.034	.965
VERTICAL SPREAD	:	1.501	1.501	1.323
EXTREME SPREAD	:	1.879	1.528	1.449
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 3.093

VS = 1.591

GS = 3.358

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.055	.829	.572
MINIMUM X	-2.038	-2.055	-1.221
MAXIMUM Y	.898	.853	.841
MINIMUM Y	-.693	-.738	-.750
CENTROID X	-.579	-.353	-.096
CENTROID Y	-.016	.029	.041
POA TO CENTROID in.	.580	.354	.105
MIN RADIUS	.328	.119	.173
MEAN RADIUS	1.009	.794	.538
MAX RADIUS	2.078	2.057	1.226
HORIZONTAL SPREAD	3.093	2.884	1.793
VERTICAL SPREAD	1.591	1.591	1.591
EXTREME SPREAD	3.358	3.037	2.031
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		