

C6636316

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington
MODEL 700TM M24

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

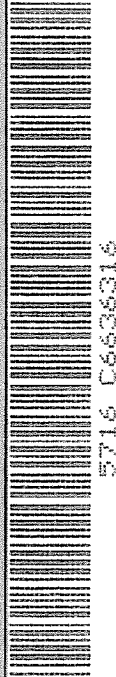
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6636316

ORDER NO.
5716

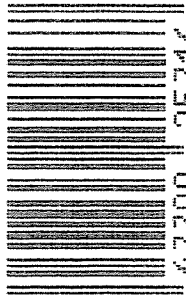
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636316

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636316

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	KCK
	Magnaflux Bolt	5 6	91	KCK
615	Rollmark Caliber	5 6	91	GB
617	Drill and Tap Sight Holes	5 10	91	LB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-18-91	JH

op. #	BARBER NM24 0032959	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-19-91	GU
	G) Safety Off Force	4	4	4			7-19-91	GU
	H) Trigger Pull Test & Retainability						7-18-91	GU
	I) Firing Pin Indent	.023	.023	.023			7-19-91	GU
	J) Assemble Stock						7/22/91	RW
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/22/91	RW
	M) Iron Sight Alignment						7/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	RW
	O) Attach Scope to Rifle						7/22/91	RW
	P) Detach & Attach Scope 20 Times						7/22/91	RW
640	Gallery Target & Test						7-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						7-22-91	NF
655	Final Inspection							
	A) Headspace						7-23-91	D/H
	B) Trigger Pull	2.50	2.45	2.43	2.45	2.47	7-23-91	GU
	C) Function						7-23-91	D/H
660	Pack						9-14-91	NF

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

SERIAL NO. 0-6636316DATE 7-18-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.45	2.50	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.50	2.48	2.45	
PULL #3	2.59	2.46	2.44	2.43	
PULL #4	2.48	2.43	2.50	2.45	
PULL #5	2.46	2.52	2.53	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.25		
PULL #2	3.41	3.31		
PULL #3	3.37	3.27		
PULL #4	3.56	3.31		
PULL #5	3.22	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.22		4.24
PULL #2	4.30	4.30		4.32
PULL #3	4.23	4.26		4.16
PULL #4	4.32	4.28		4.28
PULL #5	4.23	4.29		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636316
22 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.182937
1 TO	2	.106738
1 TO	3	.159261
1 TO	4	.198497
1 TO	5	.277995

50' <---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0174
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1404
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141474
THE AMR FOR THIS RIFLE IS: 1.254

22 Jul 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8638316

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 1

3 in = 5

HS= 3.411

VS= 5.148

GS= 5.163

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.824

1.866

1.315

MINIMUM X

-1.587

-1.545

-1.311

MAXIMUM Y

2.382

2.074

2.248

MINIMUM Y

-2.766

-1.532

-1.358

CENTROID X

.065

.023

-.211

CENTROID Y

.171

.479

.305

POA TO CENTROID in.

.183

.479

.371

MIN RADIUS

.604

.641

.355

MEAN RADIUS

1.614

1.495

1.323

MAX RADIUS

2.792

2.326

2.263

HORIZONTAL SPREAD

3.411

3.411

2.626

VERTICAL SPREAD

5.148

3.606

3.606

EXTREME SPREAD

5.163

3.689

3.654

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

1

NUMBER IN THREE INCH CIRCLE =

5

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636316

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 6

HE= 3.854

VS= 3.795

GS= 4.938

CENTROID *

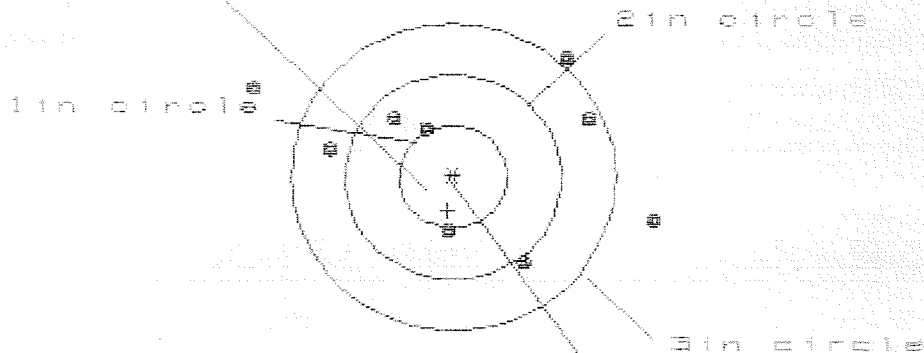
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.729	1.915	1.673
MINIMUM X	-2.125	-1.939	-1.544
MAXIMUM Y	2.515	1.025	1.079
MINIMUM Y	-1.280	-1.001	-0.947
CENTROID X	.093	-0.093	.149
CENTROID Y	.068	-.211	-.265
POA TO CENTROID in.	.115	.231	.304
MIN RADIUS	.111	.398	.310
MEAN RADIUS	1.292	1.129	.951
MAX RADIUS	3.020	1.986	1.811
HORIZONTAL SPREAD	3.854	3.854	3.217
VERTICAL SPREAD	3.795	2.026	2.026
EXTREME SPREAD	4.938	3.877	3.372
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

22 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636316

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 6

HE = 3.704

VS = 3.426

GS = 4.011

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.865

1.755

1.512

MINIMUM X

-1.839

-1.949

-1.468

MAXIMUM Y

1.187

1.939

1.013

MINIMUM Y

-2.239

-1.097

-1.023

CENTROID X

.045

.155

.398

CENTROID Y

.329

.577

.503

POA TO CENTROID in.

1.332

.598

.642

MIN RADIUS

.516

.460

.709

MEAN RADIUS

1.351

1.212

1.115

MAX RADIUS

2.446

2.038

1.619

HORIZONTAL SPREAD

3.704

3.704

2.900

VERTICAL SPREAD

3.426

2.036

2.036

EXTREME SPREAD

4.011

3.909

3.060

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

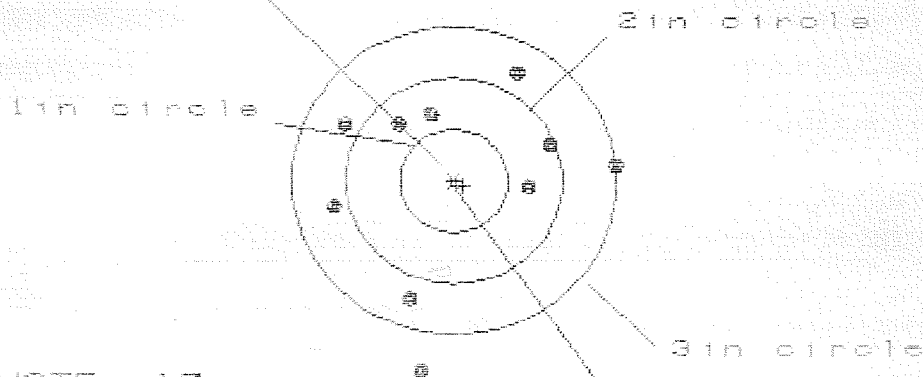
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22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636316

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 8

HS = 2.574

VS = 2.926

GS = 3.047

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.504
MINIMUM X	-1.070
MAXIMUM Y	1.064
MINIMUM Y	-1.862
CENTROID X	-0.090
CENTROID Y	.047
POA TO CENTROID in.	.101
MIN RADIUS	.634
MEAN RADIUS	1.112
MAX RADIUS	1.887
HORIZONTAL SPREAD	2.574
VERTICAL SPREAD	2.926
EXTREME SPREAD	3.047
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636316

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.446

VS= 2.653

GS= 2.898

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.275

1.306

1.201

MINIMUM X

-1.171

-1.140

-1.245

MAXIMUM Y

1.137

1.968

.651

MINIMUM Y

-1.516

-.693

-.572

CENTROID X

-.200

-.231

-.126

CENTROID Y

.087

.256

.135

POA TO CENTROID in.

.218

.345

.184

MIN RADIUS

.372

.340

.301

MEAN RADIUS

.900

.820

.749

MAX RADIUS

1.541

1.446

1.301

HORIZONTAL SPREAD

2.446

2.446

2.446

VERTICAL SPREAD

2.653

1.661

1.223

EXTREME SPREAD

2.898

2.669

2.503

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9