

C6648920

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

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

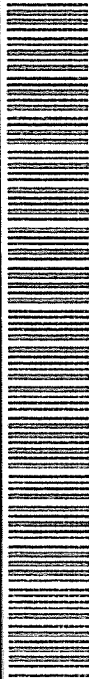
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6648920

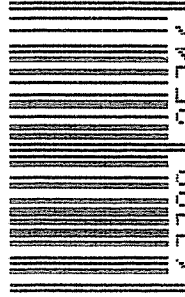
ORDER NO.
5716

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



5716 C6648920

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6648920

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KS
600	Proof		6/27/91	KS
607	Check Headspace		6/27/91	KS
610	Dis-assemble Gun		6/27/91	KS
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		6-27-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	HL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	HL
	C) Inspect Ejector Hole for Chamfer		8/27/91	HL
	D) Oil Firing Pin Ass'y		8/27/91	HL
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	HL

op. #	BARBER - M24 0033345 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/28/91	JK
	G) Safety Off Force	3	3	3			8/28/91	JK
	H) Trigger Pull Test & Retainability						8/28/91	JK
	I) Firing Pin Indent	.021	.0215	.0215			8/28/91	JK
	J) Assemble Stock						8/28/91	JK
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	JK
	M) Iron Sight Alignment						8/28/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	JK
	O) Attach Scope to Rifle						8/28/91	JK
	P) Detach & Attach Scope 20 Times						8/28/91	JK
640	Gallery Target & Test						8-29-91	DH
	A) Time						8-29-91	DH
	B) Malfunctions						8-29-91	DH
	C) Pierced Primers						8-29-91	DH
	D) Optical Clarity of Scope						8-29-91	DH
645	Inspect for Live Ammo						8-29-91	DH
655	Final Inspection A) Headspace						8-31-91	DH
	B) Trigger Pull	2.43	2.34	2.34	2.35	2.35	8-29-91	DH
	C) Function						8-31-91	DH
660	Pack						9-18-91	AC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6648920

DATE 8/28/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.41	2.48	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.36	2.44	2.34	
PULL #3	2.29	2.32	2.43	2.34	
PULL #4	2.31	2.37	2.30	2.35	
PULL #5	2.35	2.39	2.42	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.66	3.58		
PULL #2	3.30	3.39		
PULL #3	3.53	3.44		
PULL #4	3.66	3.48		
PULL #5	3.65	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.56		4.33
PULL #2	4.62	4.28		4.38
PULL #3	4.48	4.48		4.50
PULL #4	4.45	4.50		4.49
PULL #5	4.49	4.35		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648920
29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.294646
1 TO	2	.278361
1 TO	3	.437321
1 TO	4	.112508
1 TO	5	.0514296

2.6 <----POA

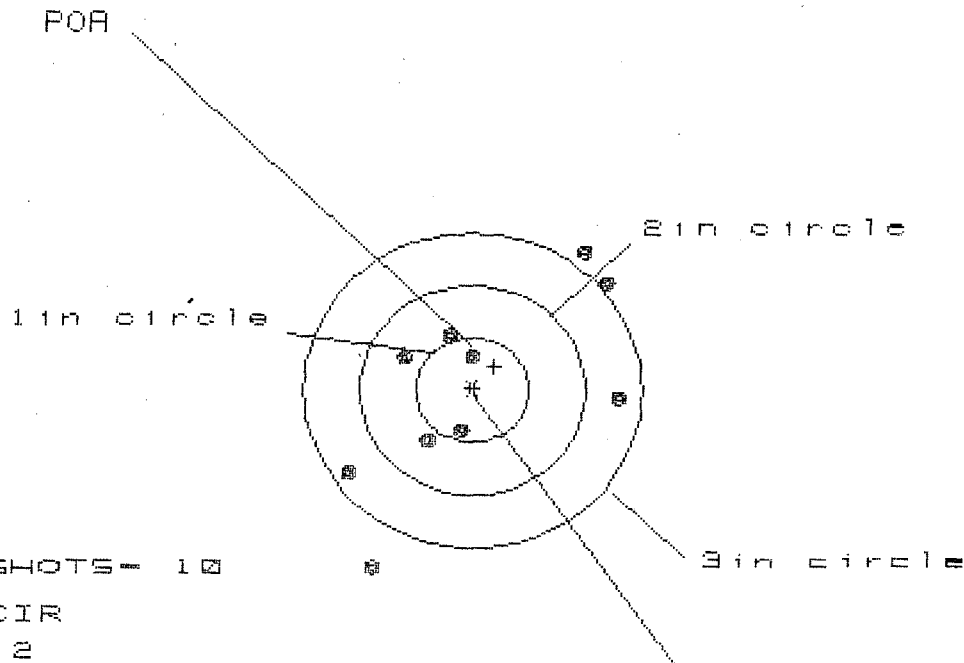
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1508
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0972
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179411

THE AMR FOR THIS RIFLE IS: .9106

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646920

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 2.399

VS = 2.947

GS = 3.484

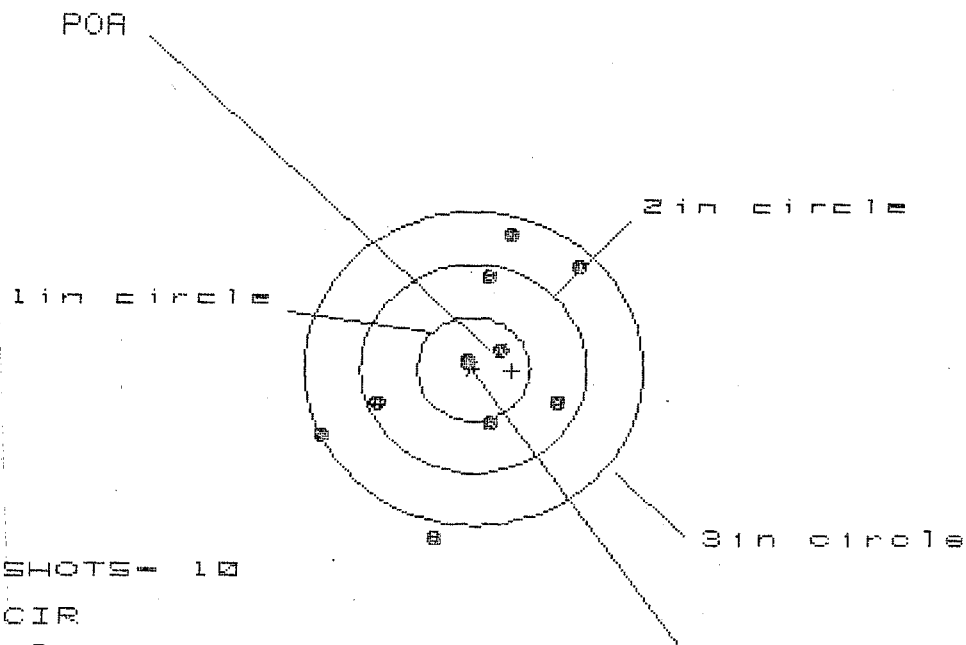
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.246	1.147	1.257
MINIMUM X	-1.153	-1.252	-1.142
MAXIMUM Y	1.280	1.095	.958
MINIMUM Y	-1.667	-.969	-.832
CENTROID X	-.196	-.097	-.207
CENTROID Y	-.220	-.035	-.172
POA TO CENTROID in.	.295	.103	.269
MIN RADIUS	.283	.168	.233
MEAN RADIUS	1.024	.922	.838
MAX RADIUS	1.887	1.583	1.536
HORIZONTAL SPREAD	2.399	2.399	2.399
VERTICAL SPREAD	2.947	2.064	1.790
EXTREME SPREAD	3.484	2.963	2.949
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

29 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.299

VS = 2.885

GS = 2.971

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.914	.879	.701
MINIMUM X	-1.385	-1.420	-1.108
MAXIMUM Y	1.272	1.093	.999
MINIMUM Y	-1.613	-.749	-.761
CENTROID X	-.342	-.307	-.129
CENTROID Y	.017	.196	.290
POA TO CENTROID in.	.343	.364	.317
MIN RADIUS	.052	.136	.080
MEAN RADIUS	.937	.849	.732
MAX RADIUS	1.644	1.606	1.279
HORIZONTAL SPREAD	2.299	2.299	1.809
VERTICAL SPREAD	2.885	1.842	1.760
EXTREME SPREAD	2.971	2.760	2.242
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6648920

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.569

VS= 2.228

GS= 2.577

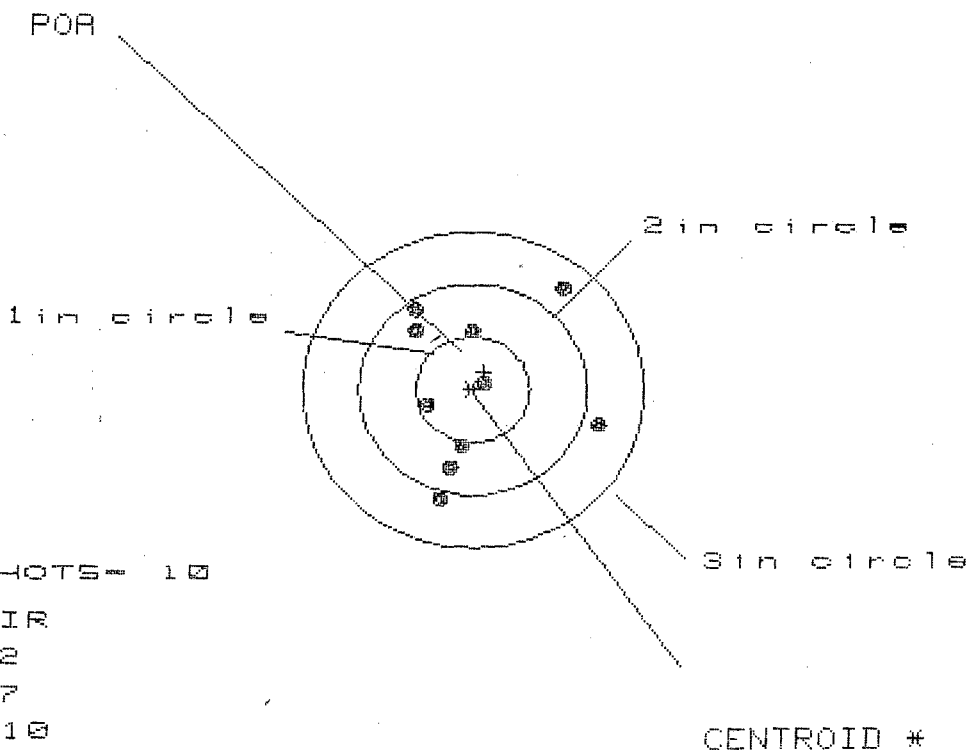
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.286	1.302	1.461
MINIMUM X	-1.283	-1.267	-1.108
MAXIMUM Y	1.495	.881	.854
MINIMUM Y	-.733	-.567	-.594
CENTROID X	.125	.109	-.050
CENTROID Y	.077	-.089	-.062
POA TO CENTROID in.	.147	.140	.079
MIN RADIUS	.423	.288	.221
MEAN RADIUS	.966	.878	.800
MAX RADIUS	1.501	1.329	1.400
HORIZONTAL SPREAD	2.569	2.569	2.569
VERTICAL SPREAD	2.228	1.448	1.448
EXTREME SPREAD	2.577	2.577	2.569
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.568

VS= 2.031

GS= 2.269

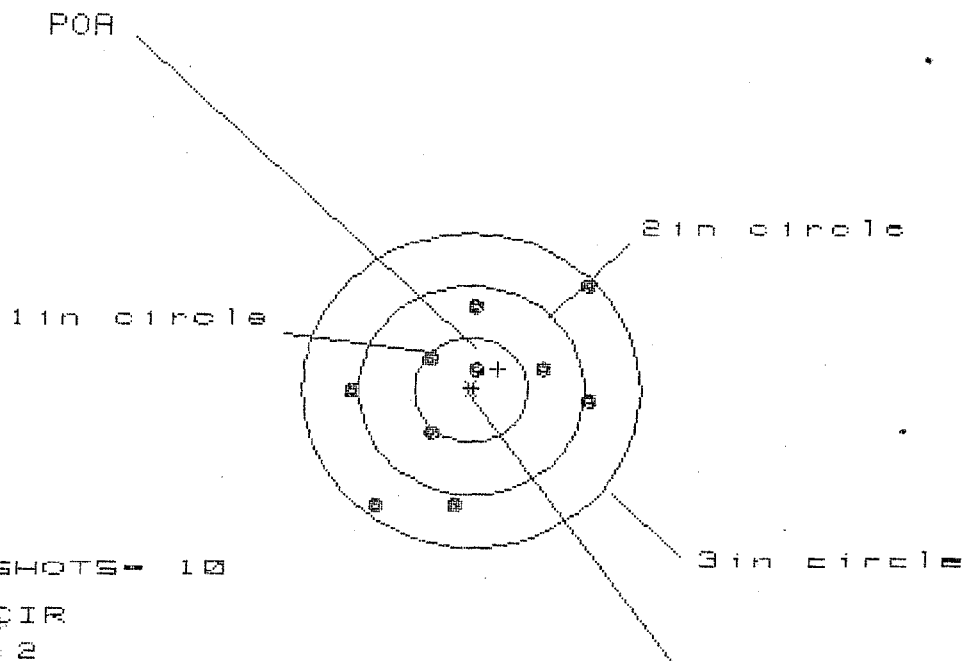
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.067	1.151	.334
MINIMUM X	-.502	-.417	-.274
MAXIMUM Y	.965	.865	.838
MINIMUM Y	-1.066	-.959	-.986
CENTROID X	-.099	-.184	-.327
CENTROID Y	-.163	-.270	-.243
POA TO CENTROID in.	.191	.327	.408
MIN RADIUS	.109	.230	.159
MEAN RADIUS	.747	.682	.608
MAX RADIUS	1.227	1.171	.986
HORIZONTAL SPREAD	1.568	1.568	.608
VERTICAL SPREAD	2.031	1.824	1.824
EXTREME SPREAD	2.269	1.900	1.840
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

29 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.129

VS= 2.149

GS= 2.815

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.031	1.138	1.046
MINIMUM X	-1.098	-.983	-1.076
MAXIMUM Y	1.031	.956	.838
MINIMUM Y	-1.118	-1.003	-1.121
CENTROID X	-.242	-.357	-.265
CENTROID Y	-.197	-.312	-.194
POA TO CENTROID in.	.312	.474	.328
MIN RADIUS	.238	.356	.240
MEAN RADIUS	.879	.814	.745
MAX RADIUS	1.458	1.199	1.126
HORIZONTAL SPREAD	2.129	2.121	2.121
VERTICAL SPREAD	2.149	1.959	1.959
EXTREME SPREAD	2.815	2.123	2.123
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		