

66648942

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

DU PONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6648942

ORDER NO.
5716

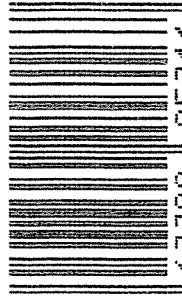
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6648942

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648942

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	WB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8/2/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/9/91	JA

BARBER - M24 0033590								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-19-91	DH
	G) Safety Off Force	5	5	5			8-19-91	DH
	H) Trigger Pull Test & Retainability						8/19/91	DH
	I) Firing Pin Indent	.022	.023	.022			8-19-91	DH
	J) Assemble Stock						8/20/91	RW
	K) Assemble Swivel Studs						8-21-91	AC
	L) Attach Front and Rear Sight Assemblies						8/20/91	RW
	M) Iron Sight Alignment						8/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	RW
	O) Attach Scope to Rifle						8/20/91	RW
	P) Detach & Attach Scope 20 Times						8/20/91	RW
640	Gallery Target & Test						8-20-91	DH
	A) Time						8-20-91	DH
	B) Malfunctions						8-20-91	DH
	C) Pierced Primers						8-20-91	DH
	D) Optical Clarity of Scope						8-20-91	DH
645	Inspect for Live Ammo						8-20-91	DH
655	Final Inspection							
	A) Headspace						8-21-91	AC
	B) Trigger Pull	2.21	2.27	2.21	2.16	2.19	8-20-91	DH
	C) Function						8-21-91	AC
660	Pack						9-18-91	NF

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

SERIAL NO. C6648942
DATE 8-19-91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.44	2.40	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.54	2.38	2.27	
PULL #3	2.56	2.48	2.35	2.21	
PULL #4	2.61	2.24	2.29	2.16	
PULL #5	2.67	2.47	2.43	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.77		
PULL #2	3.65	3.58		
PULL #3	3.46	3.69		
PULL #4	3.68	3.50		
PULL #5	3.48	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.20		4.44
PULL #2	4.49	4.38		4.26
PULL #3	4.49	4.38		4.42
PULL #4	4.57	4.28		4.50
PULL #5	4.60	4.40		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648942
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.317241
1 TO	2	.574252
1 TO	3	1.3736
1 TO	4	.402906
1 TO	5	.330442

EN 1 <----POA

3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0876
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1788
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .139106
THE AMR FOR THIS RIFLE IS: .9824

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6640342

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 3.120

VS= 2.533

GS= 3.215

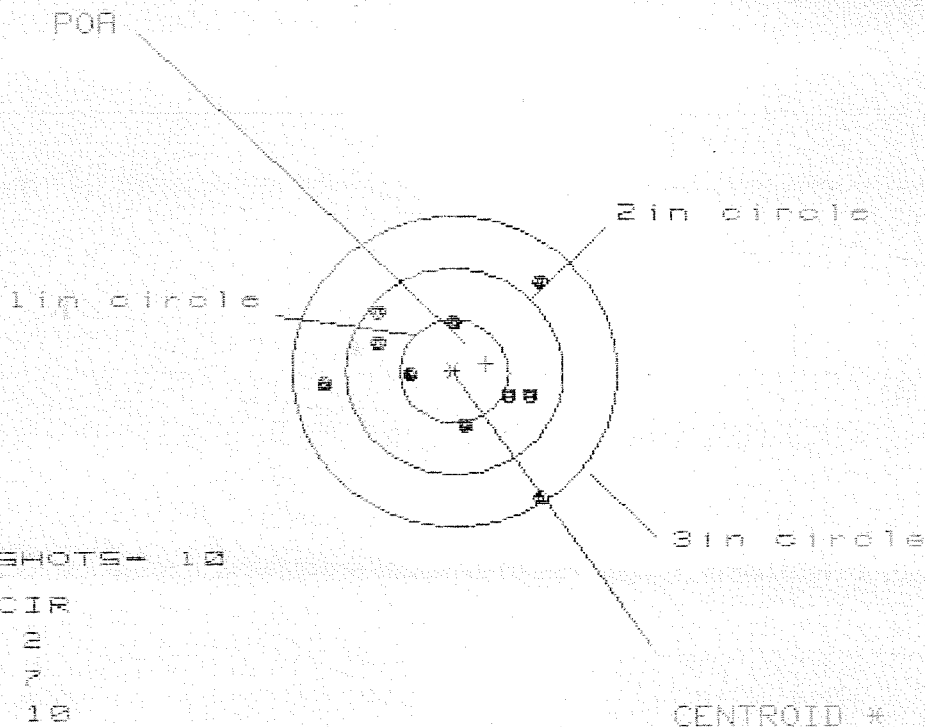
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.800	.776	.636
MINIMUM X	-1.320	-1.119	-.903
MAXIMUM Y	1.514	1.502	1.388
MINIMUM Y	-1.018	-1.031	-1.145
CENTROID X	.151	-.050	.090
CENTROID Y	.279	.292	.406
POR TO CENTROID in.	.317	.297	.416
MIN RADIUS	.564	.364	.452
MEAN RADIUS	1.004	.900	.822
MAX RADIUS	1.804	1.521	1.392
HORIZONTAL SPREAD	3.120	1.895	1.139
VERTICAL SPREAD	2.533	2.533	2.533
EXTREME SPREAD	3.215	2.765	2.535
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B942

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.015

VS= 2.025

GS= 2.315

CENTROID #

PATTERN # : 2

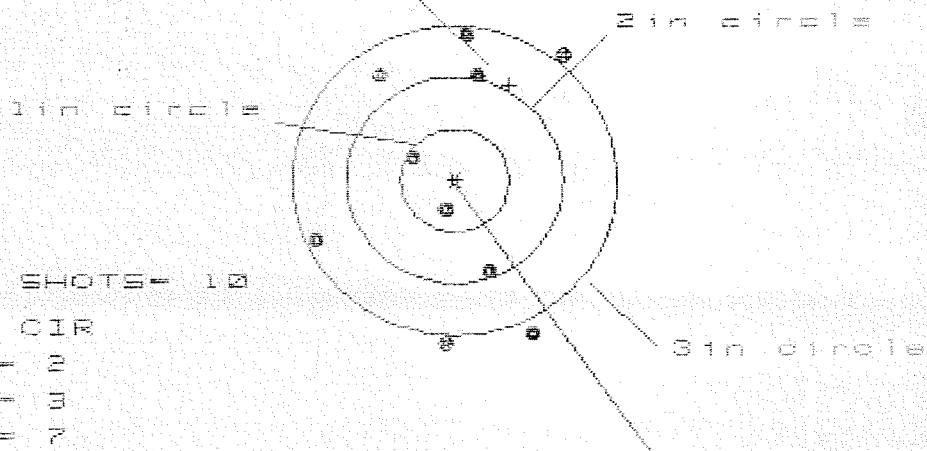
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.832	.871	.735
MINIMUM X	-1.183	-1.091	-.750
MAXIMUM Y	.846	.715	.686
MINIMUM Y	-1.179	-.664	-.693
CENTROID X	-.298	-.390	-.254
CENTROID Y	-.079	.052	.001
POA TO CENTROID in.	.308	.394	.266
MIN RADIUS	.361	.286	.279
MEAN RADIUS	.805	.716	.666
MAX RADIUS	1.443	1.127	1.006
HORIZONTAL SPREAD	2.015	1.962	1.485
VERTICAL SPREAD	2.025	1.379	1.379
EXTREME SPREAD	2.315	2.178	1.594
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B942

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

HS = 2.251

VS = 2.971

GS = 2.982

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.997	1.080	1.083
MINIMUM X	-1.254	-1.171	-1.168
MAXIMUM Y	1.386	1.218	.999
MINIMUM Y	-1.585	-1.753	-1.297
CENTROID X	-.512	-.595	-.598
CENTROID Y	-.924	-.756	-.937
POA TO CENTROID in.	1.057	.963	.804
MIN RADIUS	.273	.259	.327
MEAN RADIUS	1.154	1.078	.988
MAX RADIUS	1.685	1.753	1.526
HORIZONTAL SPREAD	2.251	2.251	2.251
VERTICAL SPREAD	2.971	2.971	2.296
EXTREME SPREAD	2.982	2.982	2.881
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B942

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.803

VS = 2.439

GS = 2.738

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.876	.965	.861
MINIMUM X	-.927	-.830	-.730
MAXIMUM Y	1.257	1.125	1.219
MINIMUM Y	-1.182	-.931	-.837
CENTROID X	.124	.027	.131
CENTROID Y	-.123	.009	-.085
POA TO CENTROID in.	.175	.028	.156
MIN RADIUS	.085	.148	.050
MEAN RADIUS	.849	.775	.715
MAX RADIUS	1.471	1.341	1.219
HORIZONTAL SPREAD	1.803	1.795	1.591
VERTICAL SPREAD	2.439	2.056	2.056
EXTREME SPREAD	2.738	2.456	2.221
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6648942

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 8

HS = 1.578

VS = 3.115

GS = 3.155

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.882	.930	.778
MINIMUM X	-.596	-.648	-.532
MAXIMUM Y	1.344	1.147	.958
MINIMUM Y	-1.771	-1.519	-1.513
CENTROID X	.097	.050	-.066
CENTROID Y	-.047	.150	.339
POA TO CENTROID in.	.108	.158	.346
MIN RADIUS	.543	.394	.380
MEAN RADIUS	1.100	.980	.838
MAX RADIUS	1.822	1.781	1.521
HORIZONTAL SPREAD	1.578	1.578	1.310
VERTICAL SPREAD	3.115	2.666	2.471
EXTREME SPREAD	3.155	2.956	2.528
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	