

C6611677

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Remington®

DUPONT

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

MODEL 700TM M24

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

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

SERIAL NO.	C6611677
ORDER NO.	5716

20



5716 C6611677



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611677

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3 28 91	Rw
600	Proof		3 28 91	Rw
607	Check Headspace		3 28 91	Rw
610	Dis-assemble Gun		3 28 91	Rw
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	W
615	Rollmark Caliber		APR 2 1991	LS
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/91	JA

op. #	DESCRIPTION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/1/91	JH
	G) Safety Off Force	4	4	4			5/1/91	JH
	H) Trigger Pull Test & Retainability						5/1/91	JH
	I) Firing Pin Indent	.0205	.021	.021			5/1/91	JH
	J) Assemble Stock						5/2/91	RW
	K) Assemble Swivel Studs						5/6/91	DH
	L) Attach Front and Rear Sight Assemblies						5/2/91	RW
	M) Iron Sight Alignment						5/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/2/91	RW
	O) Attach Scope to Rifle						5/2/91	RW
	P) Detach & Attach Scope 20 Times						5/2/91	RW
640	Gallery Target & Test						5-2-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-2-91	AF
655	Final Inspection							
	A) Headspace						5-16-91	DH
	B) Trigger Pull	2.24	2.20	2.20	2.20	2.22	5/14/91	JH
	C) Function						5-16-91	DH
660	Pack						6-16-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611677

DATE 5/1/91

TESTER JRU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.23	2.20	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.31	2.24	2.20	
PULL #3	2.30	2.26	2.28	2.20	
PULL #4	2.30	2.18	2.20	2.20	
PULL #5	2.32	2.24	2.23	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.40		
PULL #2	3.42	3.40		
PULL #3	3.38	3.35		
PULL #4	3.39	3.35		
PULL #5	3.41	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.26		4.23
PULL #2	4.33	4.15		4.38
PULL #3	4.17	4.29		4.35
PULL #4	4.31	4.38		4.35
PULL #5	4.32	4.36		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611677
2 May 1991

CENTROIDAL DISTANCES

0 TO	1	.14798
1 TO	2	.0266271
1 TO	3	.0961665
1 TO	4	.459479
1 TO	5	.149626

$\frac{4}{5}$

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0122801

THE AMR FOR THIS RIFLE IS: .825

2 May 1991

FILE://PATTERNING/CENTERFIRE_PATT/C8B11677

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.310

VS= 1.292

GS= 2.345

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.841	.771
MINIMUM X	:	-1.322	-.800	-.695
MAXIMUM Y	:	.602	.624	.398
MINIMUM Y	:	-.690	-.668	-.590
CENTROID X	:	-.017	.130	.025
CENTROID Y	:	-.147	-.169	-.247
POA TO CENTROID in.	:	.148	.213	.248
MIN RADIUS	:	.294	.179	.207
MEAN RADIUS	:	.701	.610	.555
MAX RADIUS	:	1.337	1.047	.782
HORIZONTAL SPREAD	:	2.310	1.641	1.466
VERTICAL SPREAD	:	1.292	1.292	.988
EXTREME SPREAD	:	2.345	1.774	1.470
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

2 May 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.951

VS= 2.556

GS= 2.590

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	.938	1.014
MINIMUM X	:	-.962	-1.023	-.947
MAXIMUM Y	:	1.415	1.179	1.182
MINIMUM Y	:	-1.141	-.984	-.837
CENTROID X	:	.005	.066	-.010
CENTROID Y	:	-.132	-.289	-.436
POA TO CENTROID in.	:	.132	.296	.436
MIN RADIUS	:	.338	.399	.327
MEAN RADIUS	:	.917	.831	.752
MAX RADIUS	:	1.518	1.328	1.219
HORIZONTAL SPREAD	:	1.961	1.961	1.961
VERTICAL SPREAD	:	2.556	2.163	2.019
EXTREME SPREAD	:	2.590	2.362	2.027
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

2 May 1991

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 2.096

VS = 1.432

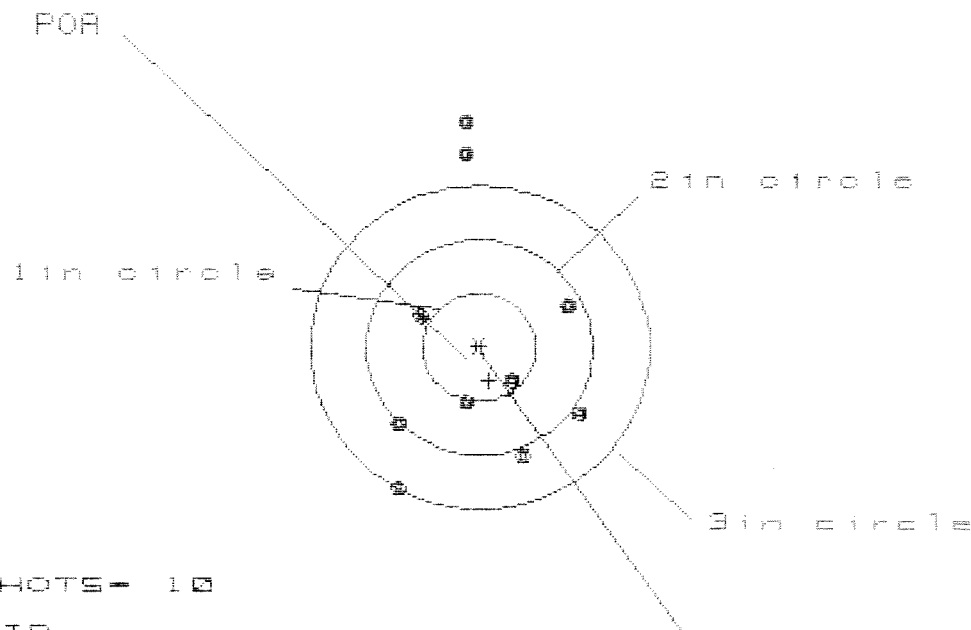
GS = 2.274

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	.779	.460
MINIMUM X	:	-1.186	-.635	-.538
MAXIMUM Y	:	.683	.649	.633
MINIMUM Y	:	-.749	-.673	-.689
CENTROID X	:	.051	.182	.085
CENTROID Y	:	-.079	-.155	-.139
POA TO CENTROID in.	:	.094	.239	.163
MIN RADIUS	:	.275	.207	.269
MEAN RADIUS	:	.652	.546	.523
MAX RADIUS	:	1.368	.789	.735
HORIZONTAL SPREAD	:	2.096	1.414	.998
VERTICAL SPREAD	:	1.432	1.322	1.322
EXTREME SPREAD	:	2.274	1.420	1.331
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

2 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 1.617

VS = 3.374

GS = 3.438

CENTROID *

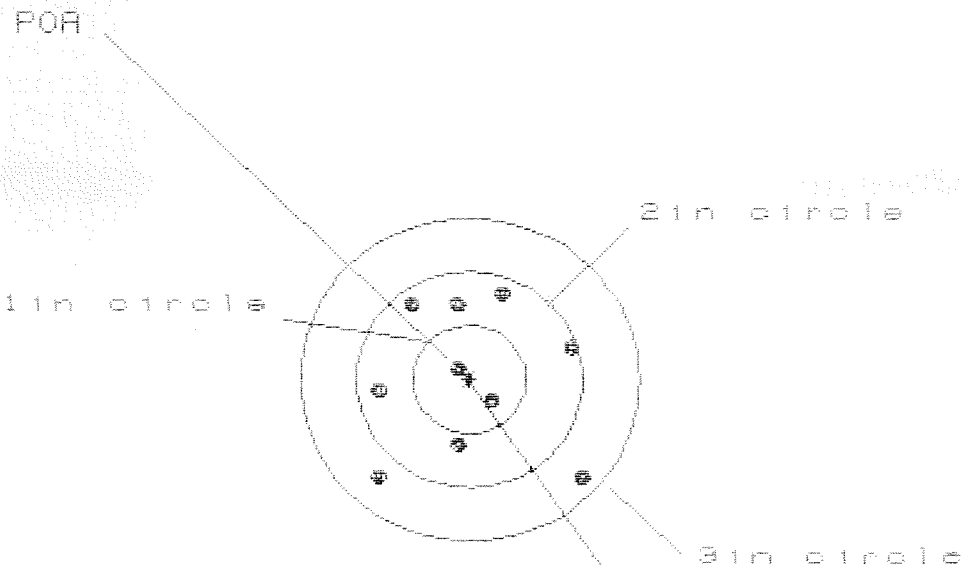
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.875	.866	.851
MINIMUM X	:	-.742	-.751	-.766
MAXIMUM Y	:	2.044	1.997	.840
MINIMUM Y	:	-1.330	-1.103	-.854
CENTROID X	:	-.081	-.073	-.058
CENTROID Y	:	.308	.081	-.168
POA TO CENTROID in.	:	.319	.109	.178
MIN RADIUS	:	.416	.264	.104
MEAN RADIUS	:	1.087	.920	.735
MAX RADIUS	:	2.045	2.000	1.147
HORIZONTAL SPREAD	:	1.617	1.617	1.617
VERTICAL SPREAD	:	3.374	3.100	1.693
EXTREME SPREAD	:	3.438	3.164	2.283
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

2 May 1991

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CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.757

VS= 1.693

GS= 2.171

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.958	1.030	.943
MINIMUM X	:	-.799	-.693	-.759
MAXIMUM Y	:	.809	.711	.588
MINIMUM Y	:	-.884	-.982	-.772
CENTROID X	:	.005	-.101	-.014
CENTROID Y	:	.001	.099	.222
POA TO CENTROID in.	:	.006	.142	.222
MIN RADIUS	:	.151	.037	.114
MEAN RADIUS	:	.768	.692	.625
MAX RADIUS	:	1.303	1.202	.945
HORIZONTAL SPREAD	:	1.757	1.723	1.702
VERTICAL SPREAD	:	1.693	1.693	1.360
EXTREME SPREAD	:	2.171	2.076	1.748
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	