

C6611754

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.



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

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

MODEL 700™ M24

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

20

SERIAL NO.
C6611754

ORDER NO.
5716

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

5716 C6611754

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611754

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 10 91	RW
600	Proof		1 10 91	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		1/6/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		1 17 91	LB
618	Polish Barrel		1 17 91	LB
620	Apply Coatings (Barrel Action)		1-12-91	LB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/6/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/6/91	RW
	C) Inspect Ejector Hole for Chamfer		3/6/91	RW
	D) Oil Firing Pin Ass'y		3/6/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/8/91	LB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			3/8/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/8/91	WB
	H) Trigger Pull Test & Retainability						3/8/91	gpl
	I) Firing Pin Indent	.0215	.0215	.0215			3/8/91	WB
	J) Assemble Stock						4/8/91	RW
	K) Assemble Swivel Studs						4-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/4/91	RW
	M) Iron Sight Alignment						4/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	RW
	O) Attach Scope to Rifle						4/4/91	RW
	P) Detach & Attach Scope 20 Times						4/4/91	RW
640	Gallery Target & Test						4-5-91	AC
	A) Time						4-5-91	AC
	B) Malfunctions						4-5-91	AC
	C) Pierced Primers						4-5-91	AC
	D) Optical Clarity of Scope						4-5-91	AC
645	Inspect for Live Ammo						4-5-91	AC
655	Final Inspection							
	A) Headspace						4-8-91	D/H
	B) Trigger Pull	2.32	2.21	2.42	2.37	2.38	4/8/91	gpl
	C) Function						4-8-91	D/H
660	Pack						6-18-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611754

DATE 3-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.49	2.41	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.40	2.46	2.21	
PULL #3	2.46	2.39	2.40	2.42	
PULL #4	2.44	2.39	2.38	2.37	
PULL #5	2.46	2.29	2.38	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.41		
PULL #2	3.38	3.41		
PULL #3	3.43	3.37		
PULL #4	3.42	3.38		
PULL #5	3.42	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.50		4.19
PULL #2	4.48	4.32		4.17
PULL #3	4.50	4.53		4.56
PULL #4	4.52	4.55		4.58
PULL #5	4.49	4.19		4.52
TOTAL				
AVG.				

POINT TO POINT DISTANCE CALCULATIONS

RIFLE # 06611754

DATE 1991

CENTROIDAL DISTANCES

0 TO	1	.391004
1 TO	2	.523687
1 TO	3	.302729
1 TO	4	.395214
1 TO	5	.317246

21 <----POB

COORDINATE FOR THIS RIFLE IS: .13

COORDINATE FOR THIS RIFLE IS: -.0056

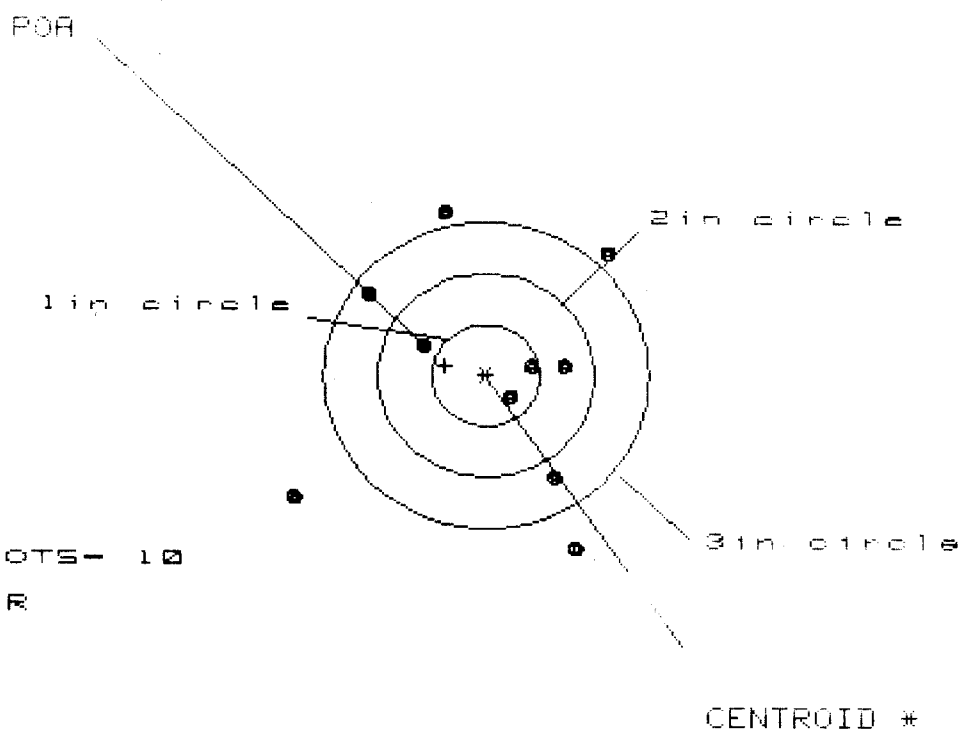
POB RADIUS FOR THIS RIFLE IS: .130121

POB IS: 1.119

5 Apr 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06611754

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 6

HS = 2.908

VS = 3.358

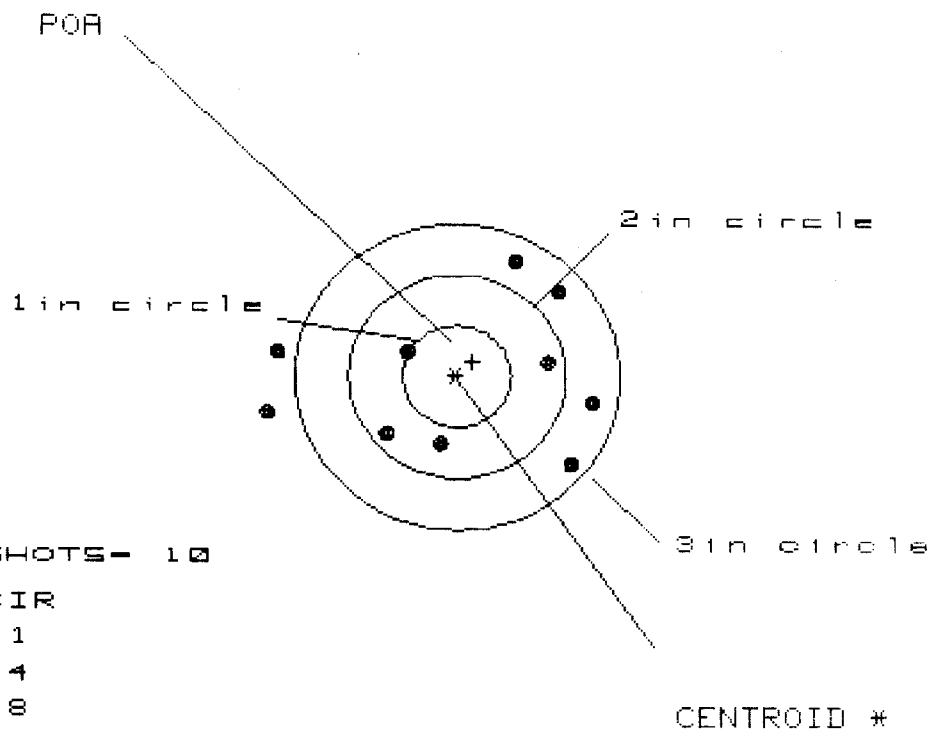
GS = 3.727

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.098	.897	.969
MINIMUM X	-1.810	-1.242	-1.170
MAXIMUM Y	1.617	1.486	1.252
MINIMUM Y	-1.741	-1.872	-1.331
CENTROID X	.378	.579	.507
CENTROID Y	-.100	.031	.265
POA TO CENTROID in.	.391	.580	.572
MIN RADIUS	.311	.186	.373
MEAN RADIUS	1.191	1.043	.951
MAX RADIUS	2.161	1.961	1.412
HORIZONTAL SPREAD	2.908	2.139	2.139
VERTICAL SPREAD	3.358	3.564	2.583
EXTREME SPREAD	3.727	3.564	2.773
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.976

VS = 1.959

GS = 2.979

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.221	1.026	.800
MINIMUM X	:	-1.755	-1.806	-1.043
MAXIMUM Y	:	1.147	1.106	1.132
MINIMUM Y	:	-.812	-.853	-.827
CENTROID X	:	-.144	.051	.277
CENTROID Y	:	-.142	-.101	-.128
POA TO CENTROID in.	:	.202	.113	.305
MIN RADIUS	:	.467	.639	.467
MEAN RADIUS	:	1.134	1.046	.922
MAX RADIUS	:	1.792	1.818	1.210
HORIZONTAL SPREAD	:	2.976	2.832	1.843
VERTICAL SPREAD	:	1.959	1.959	1.959
EXTREME SPREAD	:	2.979	2.883	2.106
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 2

3in = 9

HS = 2.187

VS = 2.399

GS = 2.869

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.273	1.172	1.154
MINIMUM X	:	-.914	-1.006	-.860
MAXIMUM Y	:	1.108	.964	1.004
MINIMUM Y	:	-1.291	-1.117	-1.077
CENTROID X	:	.149	.250	.104
CENTROID Y	:	.098	.242	.202
POA TO CENTROID in.	:	.178	.348	.227
MIN RADIUS	:	.718	.815	.667
MEAN RADIUS	:	1.181	1.124	1.101
MAX RADIUS	:	1.582	1.503	1.378
HORIZONTAL SPREAD	:	2.187	2.178	2.014
VERTICAL SPREAD	:	2.399	2.081	2.081
EXTREME SPREAD	:	2.869	2.646	2.646
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

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 1.973

VS = 2.721

GS = 2.771

CENTROID #

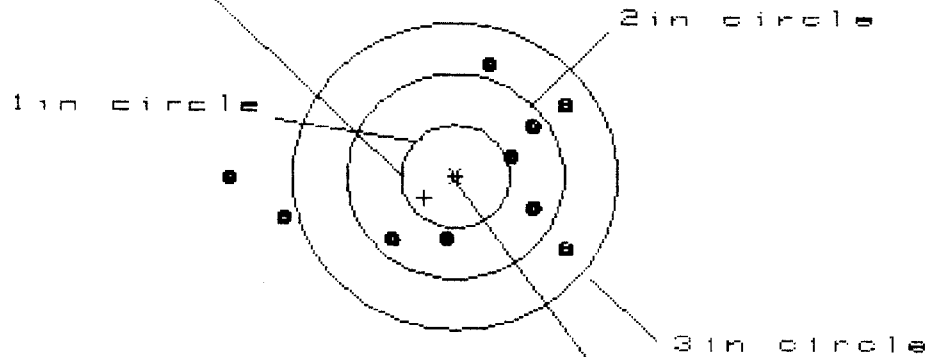
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.329	1.305	1.341
MINIMUM X	-.644	-.668	-.633
MAXIMUM Y	1.380	1.456	1.307
MINIMUM Y	-1.341	-1.187	-.948
CENTROID X	-.017	.007	-.028
CENTROID Y	-.087	-.241	-.092
POA TO CENTROID in.	.089	.241	.096
MIN RADIUS	.314	.218	.304
MEAN RADIUS	.983	.914	.879
MAX RADIUS	1.397	1.460	1.343
HORIZONTAL SPREAD	1.973	1.973	1.973
VERTICAL SPREAD	2.721	2.643	2.255
EXTREME SPREAD	2.771	2.648	2.388
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 3.152

VS= 1.846

GS= 3.229

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	.823	.591
MINIMUM X	:	-2.096	-1.858	-1.062
MAXIMUM Y	:	1.145	1.144	1.088
MINIMUM Y	:	-.701	-.702	-.758
CENTROID X	:	.284	.517	.749
CENTROID Y	:	.203	.204	.260
POA TO CENTROID (in)	:	.349	.556	.793
MIN RADIUS	:	.563	.378	.176
MEAN RADIUS	:	1.106	.936	.752
MAX RADIUS	:	2.096	1.911	1.225
HORIZONTAL HEAD	:	3.152	2.681	1.653
VERTICAL HEAD	:	1.846	1.846	1.846
EXTREME HEAD	:	3.229	2.875	2.037
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	8	8	8