

C6636035

MODEL 700™ M24

Model **SWS**™

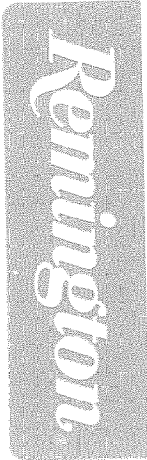
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700TM H24

SERIAL NO.
D6636035

ORDER NO.
5716

20

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

5716 D6636035

UPC

0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636035

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			RW
612	Magnaflux Barrel Action	5 6 9		IKed
	Magnaflux Bolt	5 6 9		IKed
615	Rollmark Caliber			GB
617	Drill and Tap Sight Holes	5 10	91	LB
618	Polish Barrel	5 10	91	LB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	Apply Coating (Bolt)		5-30-91	DA
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		7-16-91	RY

op. #	BARBER M24 0036938	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-17-91	JK
	G) Safety Off Force	4	4	4			7-17-91	JK
	H) Trigger Pull Test & Retainability						7-16-91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			7-17-91	JK
	J) Assemble Stock						7/18/91	RW
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/18/91	RW
	M) Iron Sight Alignment						7/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	RW
	O) Attach Scope to Rifle						7/18/91	RW
	P) Detach & Attach Scope 20 Times						7/18/91	RW
640	Gallery Target & Test						7-22-91	AC
	A) Time						7-22-91	AC
	B) Malfunctions						7-22-91	AC
	C) Pierced Primers						7-22-91	AC
	D) Optical Clarity of Scope						7-22-91	AC
645	Inspect for Live Ammo						7-22-91	AC
655	Final Inspection							
	A) Headspace						7-23-91	D/H
	B) Trigger Pull	2.47	2.47	2.49	2.52	2.53	7-23-91	JK
	C) Function						7-23-91	D/H
660	Pack						9-18-91	JK

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

SERIAL NO. 0-6636035
DATE 7-16-91
TESTER SP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.53	2.40	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.20	2.48	2.47	
PULL #3	2.21	2.47	2.40	2.49	
PULL #4	2.22	2.43	2.46	2.52	
PULL #5	2.25	2.44	2.43	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.31		
PULL #2	3.49	3.56		
PULL #3	3.55	3.57		
PULL #4	3.55	3.61		
PULL #5	3.54	3.39		
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	4.25		4.53
PULL #2	4.21	4.51		4.47
PULL #3	4.38	4.52		4.41
PULL #4	4.15	4.49		4.28
PULL #5	4.21	4.41		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636035
23 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.115261
1 TO	2	.263594
1 TO	3	.448028
1 TO	4	.57014
1 TO	5	.200569

424 <---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1844
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0352
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .18773

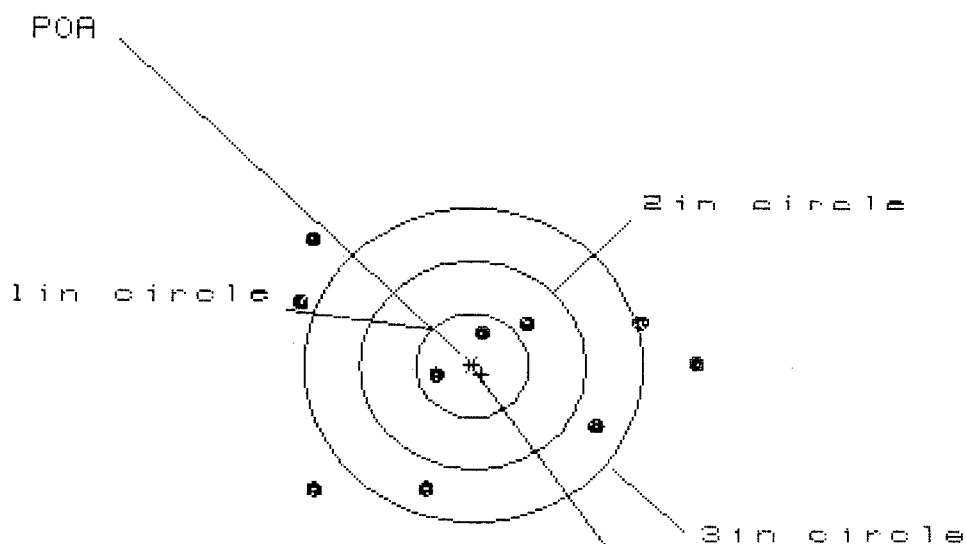
THE AMR FOR THIS RIFLE IS: 1.124

22 Jul 1991

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CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.472

VS= 2.411

GS= 3.588

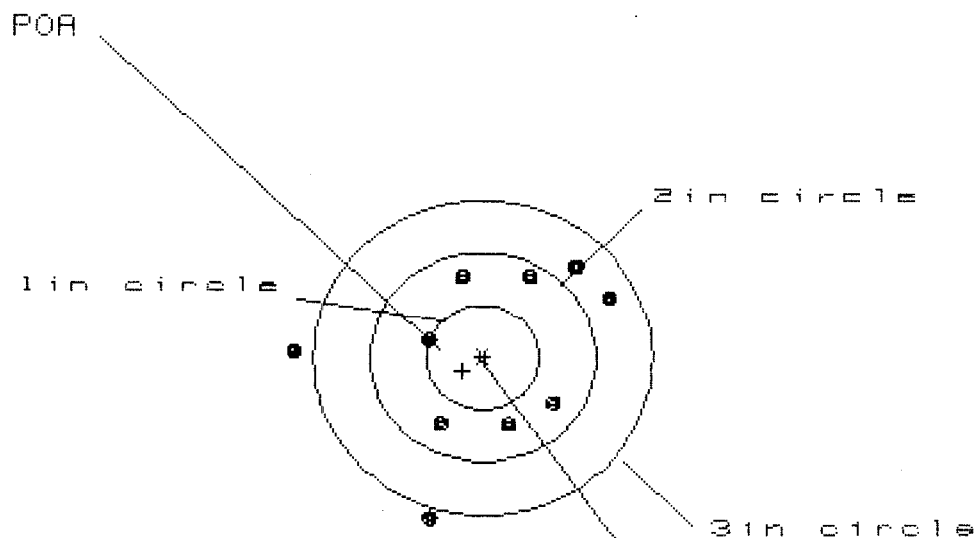
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.955	1.659	1.507
MINIMUM X	:	-1.517	-1.300	-1.452
MAXIMUM Y	:	1.205	1.209	.753
MINIMUM Y	:	-1.206	-1.202	-1.051
CENTROID X	:	-.081	-.298	-.146
CENTROID Y	:	.082	.078	-.073
POA TO CENTROID in.	:	.115	.308	.163
MIN RADIUS	:	.303	.113	.271
MEAN RADIUS	:	1.256	1.170	1.100
MAX RADIUS	:	1.955	1.724	1.663
HORIZONTAL SPREAD	:	3.472	2.959	2.959
VERTICAL SPREAD	:	2.411	2.411	1.804
EXTREME SPREAD	:	3.588	3.261	3.261
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	5		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 8

HS= 2.763

VS= 2.465

GS= 2.805

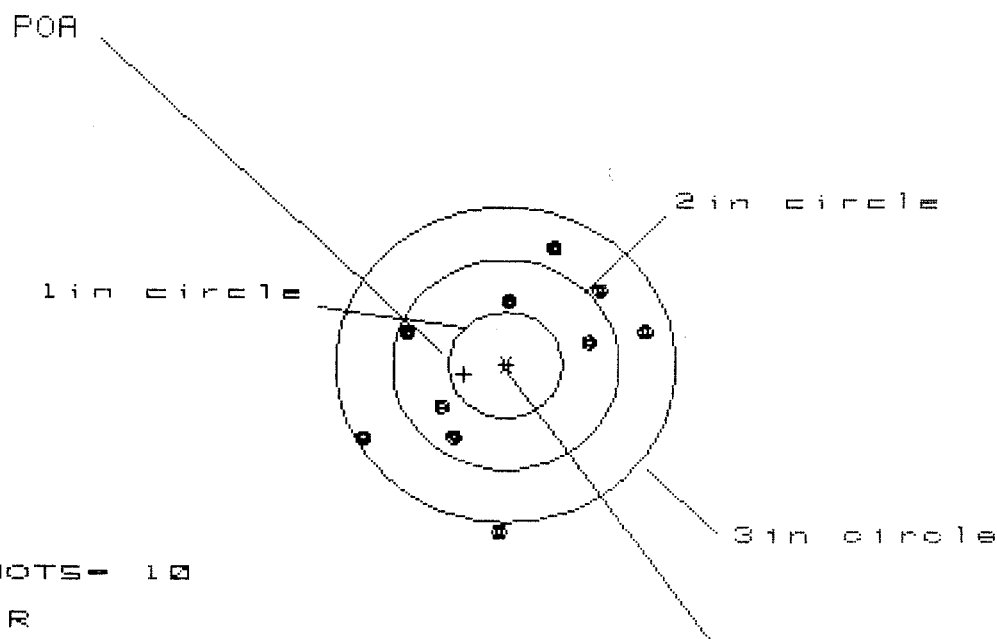
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.087	.901	.815
MINIMUM X	:	-1.676	-.691	-.703
MAXIMUM Y	:	.900	.906	.711
MINIMUM Y	:	-1.565	-1.559	-.827
CENTROID X	:	.178	.364	.450
CENTROID Y	:	.131	.125	.320
POA TO CENTROID in.	:	.221	.385	.553
MIN RADIUS	:	.473	.560	.565
MEAN RADIUS	:	.994	.903	.784
MAX RADIUS	:	1.676	1.706	1.009
HORIZONTAL SPREAD	:	2.763	1.592	1.518
VERTICAL SPREAD	:	2.465	2.465	1.538
EXTREME SPREAD	:	2.805	2.781	1.883
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.499

VS= 2.662

GS= 2.707

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.277	1.268	1.114
MINIMUM X	:	-1.222	-1.231	-1.017
MAXIMUM Y	:	1.119	.947	.846
MINIMUM Y	:	-1.543	-.877	-.978
CENTROID X	:	.367	.376	.530
CENTROID Y	:	.087	.259	.360
POA TO CENTROID in.	:	.377	.457	.641
MIN RADIUS	:	.617	.445	.366
MEAN RADIUS	:	1.036	.957	.863
MAX RADIUS	:	1.545	1.476	1.167
HORIZONTAL SPREAD	:	2.499	2.499	2.131
VERTICAL SPREAD	:	2.662	1.824	1.824
EXTREME SPREAD	:	2.707	2.658	2.131
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in = 7

HS= 3.589

VS= 2.553

GS= 4.345

CENTROID *

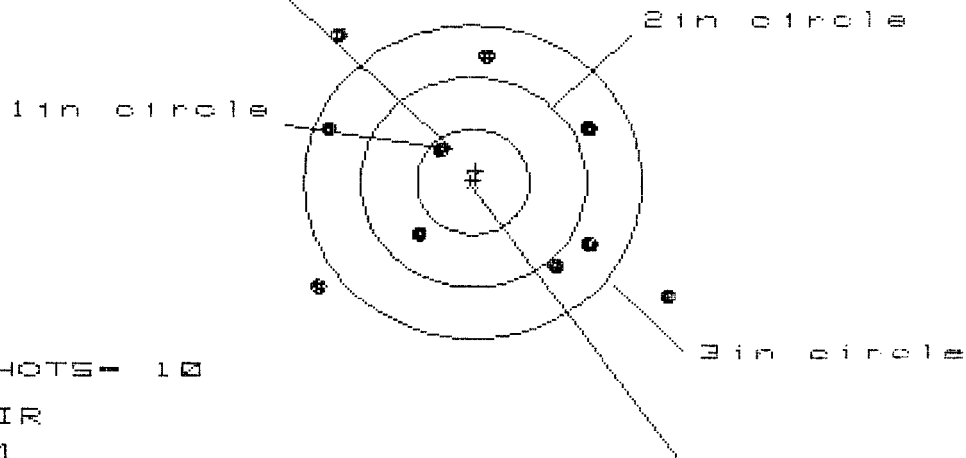
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.323	1.064	.938
MINIMUM X	:	-1.266	-1.008	-1.087
MAXIMUM Y	:	1.397	1.541	1.415
MINIMUM Y	:	-1.155	-1.012	-.782
CENTROID X	:	.481	.223	.349
CENTROID Y	:	-.014	-.158	-.032
POA TO CENTROID in.	:	.481	.274	.351
MIN RADIUS	:	.327	.337	.448
MEAN RADIUS	:	1.090	.905	.824
MAX RADIUS	:	2.659	1.613	1.538
HORIZONTAL SPREAD	:	3.589	2.072	2.025
VERTICAL SPREAD	:	2.553	2.553	2.197
EXTREME SPREAD	:	4.345	2.608	2.340
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA



CENTROID #

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 2

3 in = 7

HS = 3.125

VS = 2.475

GS = 3.798

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.736	1.205	1.086
MINIMUM X	:	-1.389	-1.197	-1.316
MAXIMUM Y	:	1.432	1.317	1.209
MINIMUM Y	:	-1.042	-1.096	-.932
CENTROID X	:	-.023	-.215	-.096
CENTROID Y	:	-.110	.006	-.158
POA TO CENTROID in.	:	.112	.216	.185
MIN RADIUS	:	.364	.169	.365
MEAN RADIUS	:	1.244	1.132	1.070
MAX RADIUS	:	2.025	1.625	1.612
HORIZONTAL SPREAD	:	3.125	2.402	2.402
VERTICAL SPREAD	:	2.475	2.413	2.141
EXTREME SPREAD	:	3.798	2.960	2.797
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	