

C6636082

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6636082

ORDER NO.
5716

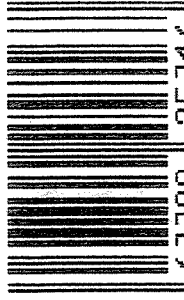
20

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



5716 C6636082

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636082

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		Rw
600	Proof	4 8 91		Rw
607	Check Headspace	4 8 91		Rw
610	Dis-assemble Gun	4 8 91		Rw
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	11
615	Rollmark Caliber		APR 9 1991	JS
617	Drill and Tap Sight Holes		APR 9 1991	LB
618	Polish Barrel		APR 9 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/14/91	Rw
	D) Oil Firing Pin Ass'y		5/14/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	JS

op. #	OP. NAME	BARBER, M24 0037492					READINGS	DATE	INIT
625 cont.	F) Safety On Force	6	6	6				6-4-91	DH
	G) Safety Off Force	3	3	3				6-4-91	DH
	H) Trigger Pull Test & Retainability							6-4-91	JP
	I) Firing Pin Indent	.020	.020	.020				6-4-91	DH
	J) Assemble Stock							6/5/91	Rev
	K) Assemble Swivel Studs							6-8-91	DH
	L) Attach Front and Rear Sight Assemblies							6/5/91	Rev
	M) Iron Sight Alignment							6/5/91	Rev
	N) Detach Front & Rear Sights & place in numbered container							6/5/91	Rev
	O) Attach Scope to Rifle							6/5/91	Rev
	P) Detach & Attach Scope 20 Times							6/5/91	Rev
640	Gallery Target & Test							6-5-91	AF
	A) Time								AF
	B) Malfunctions								AF
	C) Pierced Primers								AF
	D) Optical Clarity of Scope								AF
645	Inspect for Live Ammo							6-5-91	AF
655	Final Inspection								
	A) Headspace							6-8-91	DH
	B) Trigger Pull	2.36	2.38	2.59	2.65	2.69		6-8-91	JP
	C) Function							6-8-91	DH
660	Pack							6-20-91	AF

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

SERIAL NO 16636082DATE 6-4-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.56	2.53	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.43	2.48	2.38	
PULL #3	2.57	2.29	2.48	2.59	
PULL #4	2.54	2.39	2.51	2.45	
PULL #5	2.55	2.60	2.53	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.40		
PULL #2	3.53	3.40		
PULL #3	3.30	3.35		
PULL #4	3.55	3.45		
PULL #5	3.44	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.56	4.48		4.44
PULL #2	4.64	4.47		4.40
PULL #3	4.56	4.34		4.40
PULL #4	4.56	4.31		4.38
PULL #5	4.56	4.36		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636082
5 Jun 1991

CENTROIDAL DISTANCES

0 TO 1 .243181
1 TO 2 .257402
1 TO 3 .496082
1 TO 4 .406433
1 TO 5 .460353

4 <---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0268
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .079
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0834221

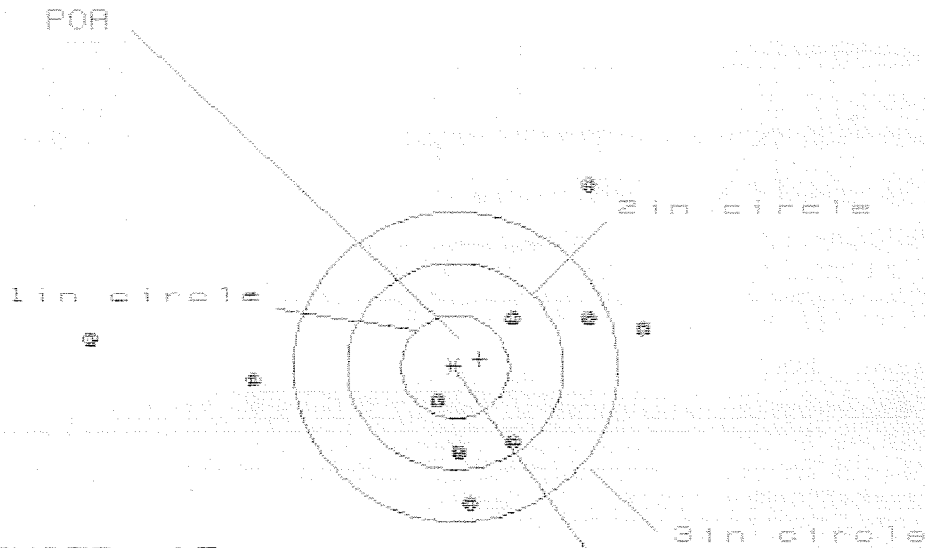
THE AMR FOR THIS RIFLE IS: 1.077

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66360B2

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 5.059

VS= 3.039

GS= 5.059

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.749

1.388

1.491

MINIMUM X

-3.319

-2.255

-2.144

MAXIMUM Y

1.745

1.777

.728

MINIMUM Y

-1.294

-1.262

-1.040

CENTROID X

-.231

.138

.027

CENTROID Y

-.076

-.108

-.330

POA TO CENTROID in.

.243

.175

.331

MIN RADIUS

.389

.513

.468

MEAN RADIUS

1.459

1.191

1.053

MAX RADIUS

3.331

2.258

2.148

HORIZONTAL SPREAD

5.068

3.635

3.635

VERTICAL SPREAD

3.039

3.039

1.768

EXTREME SPREAD

5.069

3.670

3.670

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

6

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66360B2

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 7

HS= 1.235

VS= 4.249

GS= 4.329

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	.692	.738	.692
MINIMUM X	:	-.543	-.497	-.543
MAXIMUM Y	:	1.973	1.720	1.410
MINIMUM Y	:	-2.276	-1.842	-1.627
CENTROID X	:	-.015	-.061	-.015
CENTROID Y	:	.064	.317	.102
POA TO CENTROID in.	:	.066	.323	.103
MIN RADIUS	:	.631	.503	.618
MEAN RADIUS	:	1.213	1.069	.976
MAX RADIUS	:	2.314	1.857	1.638
HORIZONTAL SPREAD	:	1.235	1.235	1.235
VERTICAL SPREAD	:	4.249	3.562	3.037
EXTREME SPREAD	:	4.329	3.612	3.044
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06836082

CENTERFIRE PATTERNS

3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 9

HS= 2.296

VS= 1.979

GS= 2.520

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.794

.627

.484

MINIMUM X

:

-1.502

-1.141

-.966

MAXIMUM Y

:

1.075

1.156

1.057

MINIMUM Y

:

-.904

-.823

-.922

CENTROID X

:

.265

.432

.575

CENTROID Y

:

-.085

-.166

-.067

POR TO CENTROID IN.

:

.278

.463

.578

MIN RADIUS

:

.700

.548

.406

MEAN RADIUS

:

1.003

.890

.796

MAX RADIUS

:

1.670

1.387

1.105

HORIZONTAL SPREAD

:

2.296

1.768

1.450

VERTICAL SPREAD

:

1.979

1.979

1.979

EXTREME SPREAD

:

2.520

2.520

2.070

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS636082

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.287

VS = 2.835

GS = 2.835

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.950	.783
MINIMUM X	-1.365	-1.337	-.628
MAXIMUM Y	1.873	.530	.584
MINIMUM Y	-.962	-.754	-.700
CENTROID X	.017	-.011	.156
CENTROID Y	.246	.038	-.016
POA TO CENTROID in.	.247	.040	.157
MIN RADIUS	.271	.108	.074
MEAN RADIUS	.831	.655	.540
MAX RADIUS	1.890	1.406	.963
HORIZONTAL SPREAD	2.287	2.287	1.411
VERTICAL SPREAD	2.835	1.284	1.284
EXTREME SPREAD	2.835	2.280	1.712
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGG360B2

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 8

HS = 2.230

VS = 2.896

GS = 3.655

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X : .965 1.010 .866

MINIMUM X : -1.265 -1.158 -.821

MAXIMUM Y : 1.692 .654 .527

MINIMUM Y : -1.204 -1.016 -.756

CENTROID X : .098 -.009 .135

CENTROID Y : .246 .058 .185

POA TO CENTROID in. : .264 .058 .229

MIN RADIUS : .202 .278 .138

MEAN RADIUS : .888 .772 .630

MAX RADIUS : 1.948 1.540 .913

HORIZONTAL SPREAD : 2.230 2.168 1.687

VERTICAL SPREAD : 2.896 1.670 1.283

EXTREME SPREAD : 3.655 2.517 1.792

NUMBER IN ONE INCH CIRCLE = 3

NUMBER IN TWO INCH CIRCLE = 8

NUMBER IN THREE INCH CIRCLE = 8