

C6636086

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

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

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

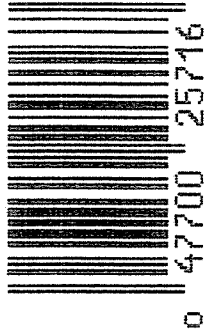
SERIAL NO. C6636086

ORDER NO. 5715

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6636086*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	<i>RW</i>
600	Proof	4 8	91	<i>RW</i>
607	Check Headspace	4 8	91	<i>RW</i>
610	Dis-assemble Gun	4 8	91	<i>RW</i>
612	Magnaflux Barrel Action	APR	9 1991	<i>KP</i>
	Magnaflux Bolt	APR	9 1991	<i>Y</i>
615	Rollmark Caliber	APR	9 1991	<i>JS</i>
617	Drill and Tap Sight Holes	APR	19 1991	<i>FB</i>
618	Polish Barrel	APR	19 1991	<i>WB</i>
620	Apply Coatings (Barrel Action)		5-10-91	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		5/14/91	<i>RW</i>
	D) Oil Firing Pin Ass'y		5/14/91	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	<i>JS</i>

op. #	BARBER-M24 0037538	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-4-91	JK
	G) Safety Off Force	3	3	3			6-4-91	JK
	H) Trigger Pull Test & Retainability						6-4-91	JK
	I) Firing Pin Indent	.022	.023	.023			6-4-91	JK
	J) Assemble Stock						6/4/91	RW
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/4/91	RW
	M) Iron Sight Alignment						6/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	RW
	O) Attach Scope to Rifle						6/4/91	RW
	P) Detach & Attach Scope 20 Times						6/4/91	RW
640	Gallery Target & Test						6-4-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-4-91	AF
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.58	2.33	2.37	2.36	2.58	6-13-91	JK
	C) Function						6-13-91	A
660	Pack						6-19-91	AF

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

SERIAL NO. 26636086DATE 6-4-91TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.51	2.50	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.48	2.54	2.33	
PULL #3	2.50	2.47	2.49	2.37	
PULL #4	2.53	2.52	2.51	2.36	
PULL #5	2.36	2.57	2.51	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.57		
PULL #2	3.53	3.47		
PULL #3	3.48	3.48		
PULL #4	3.48	3.43		
PULL #5	3.37	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.24		4.32
PULL #2	4.33	4.26		4.33
PULL #3	4.34	4.28		4.30
PULL #4	4.43	4.29		4.37
PULL #5	4.40	4.28		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636086
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.235983
1 TO	2	.246378
1 TO	3	.359001
1 TO	4	.320028
1 TO	5	.205205

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .154
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .02
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155293

THE AMR FOR THIS RIFLE IS: .9786

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635086

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 8

HS = 2.743

VS = 2.788

GS = 3.198

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.301	1.424
MINIMUM X	-1.383	-1.442	-1.319
MAXIMUM Y	1.636	1.182	1.061
MINIMUM Y	-1.144	-0.962	-0.781
CENTROID X	.122	.181	.058
CENTROID Y	.202	.020	.141
POA TO CENTROID in.	.236	.182	.152
MIN RADIUS	.161	.310	.250
MEAN RADIUS	1.091	1.016	.959
MAX RADIUS	1.721	1.622	1.458
HORIZONTAL SPREAD	2.743	2.743	2.743
VERTICAL SPREAD	2.788	2.144	1.842
EXTREME SPREAD	3.198	2.967	2.849
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 8		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636086

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.428

VS= 2.931

GS= 2.946

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.455

1.477

1.541

MINIMUM X

-.973

-.951

-.887

MAXIMUM Y

1.527

.989

.835

MINIMUM Y

-1.484

-1.235

-1.815

CENTROID X

.148

.126

.062

CENTROID Y

-.043

-.212

-.058

POA TO CENTROID in.

.154

.247

.085

MIN RADIUS

.172

.093

.121

MEAN RADIUS

.928

.837

.741

MAX RADIUS

1.539

1.477

1.544

HORIZONTAL SPREAD

2.428

2.428

2.428

VERTICAL SPREAD

2.931

2.224

1.650

EXTREME SPREAD

2.946

2.483

2.483

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636086

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.235

VS= 3.186

QS= 2.572

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.365	1.273	.970
MINIMUM X	:	-.870	-.962	-.803
MAXIMUM Y	:	1.104	.873	.935
MINIMUM Y	:	-2.082	-1.055	-.993
CENTROID X	:	.123	.215	.056
CENTROID Y	:	-.157	.074	.012
POR TO CENTROID in.	:	.199	.228	.057
MIN RADIUS	:	.307	.148	.304
MEAN RADIUS	:	1.000	.817	.736
MAX RADIUS	:	2.243	1.367	1.388
HORIZONTAL SPREAD	:	2.235	2.235	1.773
VERTICAL SPREAD	:	3.186	1.928	1.928
EXTREME SPREAD	:	3.572	2.521	1.934
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635086

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.489

VS = 1.994

GS = 2.534

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X	: 1.228	1.088	.883
MINIMUM X	: -1.261	-.634	-.499
MAXIMUM Y	: .799	.770	.792
MINIMUM Y	: -1.195	-1.224	-1.202
CENTROID X	: .225	.365	.230
CENTROID Y	: -.101	-.072	-.094
POA TO CENTROID in.	: .247	.372	.248
MIN RADIUS	: .071	.138	.063
MEAN RADIUS	: .848	.798	.742
MAX RADIUS	: 1.289	1.308	1.232
HORIZONTAL SPREAD	: 2.489	1.722	1.382
VERTICAL SPREAD	: 1.994	1.994	1.994
EXTREME SPREAD	: 2.534	2.148	2.031
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636006

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.586

VS= 2.765

GS= 2.865

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X : 1.038

-1.909

-1.730

MINIMUM X : -1.548

-1.432

-1.112

MAXIMUM Y : 1.248

1.080

.947

MINIMUM Y : -1.517

-1.063

-1.813

CENTROID X : .152

.036

.215

CENTROID Y : -.001

.167

.300

POA TO CENTROID in. : .152

.171

.369

MIN RADIUS : .330

.286

.076

MEAN RADIUS : 1.034

.919

.745

MAX RADIUS : 1.838

1.784

1.356

HORIZONTAL SPREAD : 2.586

2.341

1.842

VERTICAL SPREAD : 2.765

2.143

1.760

EXTREME SPREAD : 2.865

2.822

2.181

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8