

C6636154

MODEL 700™ M24

Model **SWS**™

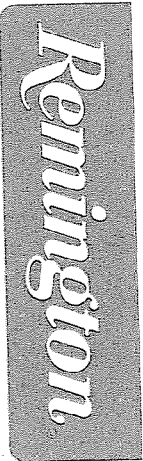
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
MODEL 700TM M24

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

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

SERIAL NO.
 C6636154

ORDER NO.
5716

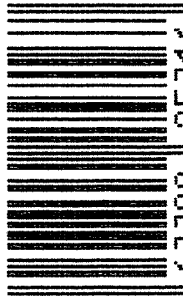
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636154

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636154

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		CB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/29/91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/91	JH

op. #	BARBER - M24 0038327	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-31-91	DH
	G) Safety Off Force	2	2	2			5-31-91	DH
	H) Trigger Pull Test & Retainability						5/31/91	JH
	I) Firing Pin Indent	.022	.022	.020			5-31-91	DH
	J) Assemble Stock						6/1/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/1/91	RW
	M) Iron Sight Alignment						6/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/1/91	RW
	O) Attach Scope to Rifle						6/1/91	RW
	P) Detach & Attach Scope 20 Times						6/1/91	RW
640	Gallery Target & Test						6-3-91	AC
	A) Time						6-3-91	AC
	B) Malfunctions						6-3-91	AC
	C) Pierced Primers						6-3-91	AC
	D) Optical Clarity of Scope						6-3-91	AC
645	Inspect for Live Ammo						6-3-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.13	2.15	2.14	2.14	2.18	6-8-91	JH
	C) Function						6-8-91	DH
660	Pack						6-20-91	AF

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6636154DATE 5/31/91TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.18	2.28	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.48	2.30	2.15	
PULL #3	2.23	2.47	2.26	2.14	
PULL #4	2.23	2.45	2.43	2.14	
PULL #5	2.20	2.27	2.43	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.45		
PULL #2	3.60	3.43		
PULL #3	3.70	3.43		
PULL #4	3.27	3.48		
PULL #5	3.47	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.40		4.27
PULL #2	4.41	4.39		4.24
PULL #3	4.21	4.30		4.25
PULL #4	4.46	4.29		4.25
PULL #5	4.34	4.26		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636154
3 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.19799
1 TO	2	.326956
1 TO	3	.0534135
1 TO	4	.573397
1 TO	5	.425229

4
2
3

-----POR

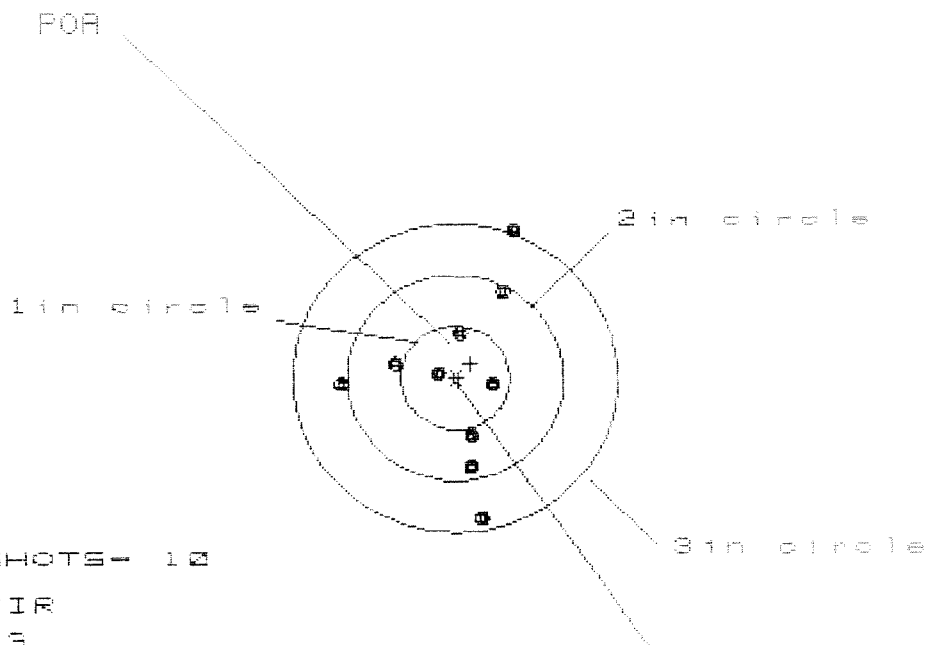
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1458
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1284
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189067

THE AMR FOR THIS RIFLE IS: .822

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636154

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.511

VS= 2.741

GS= 2.754

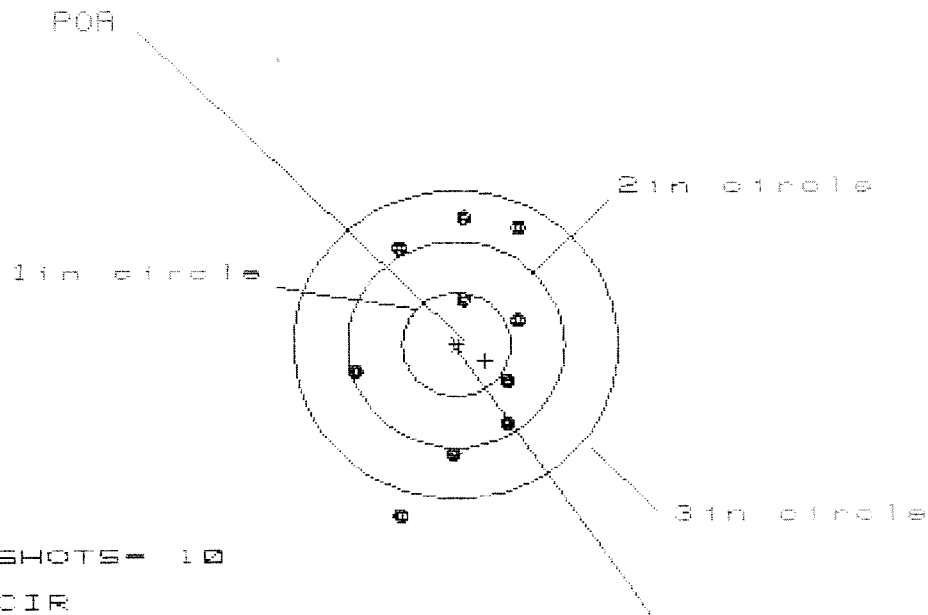
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.494	.468	.503
MINIMUM X	-1.017	-.962	-.927
MAXIMUM Y	1.420	.952	.806
MINIMUM Y	-1.321	-1.163	-.932
CENTROID X	-.140	-.195	-.230
CENTROID Y	-.140	-.298	-.152
POA TO CENTROID in.	.198	.356	.275
MIN RADIUS	.171	.251	.107
MEAN RADIUS	.774	.693	.605
MAX RADIUS	1.503	1.196	.950
HORIZONTAL SPREAD	1.511	1.430	1.430
VERTICAL SPREAD	2.741	2.115	1.638
EXTREME SPREAD	2.754	2.124	1.663
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06635134

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 1.529

VS = 2.907

CS = 2.961

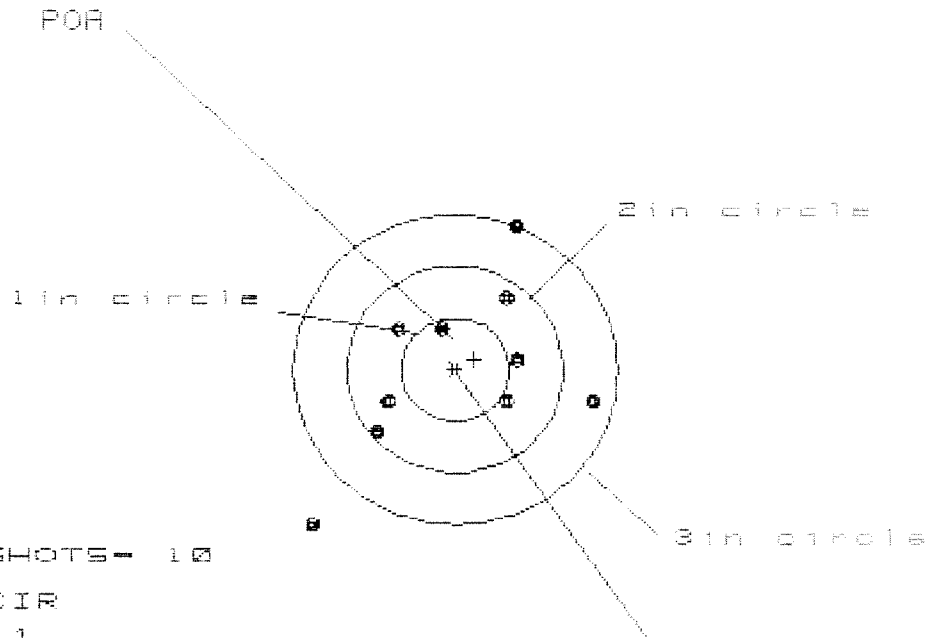
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.552
MINIMUM X	-.977
MAXIMUM Y	1.266
MINIMUM Y	-1.641
CENTROID X	-.270
CENTROID Y	.160
POA TO CENTROID in.	.313
MIN RADIUS	.456
MEAN RADIUS	.985
MAX RADIUS	1.722
HORIZONTAL SPREAD	1.529
VERTICAL SPREAD	2.907
EXTREME SPREAD	2.961
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636154

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 2.598

VS = 2.879

GS = 3.470

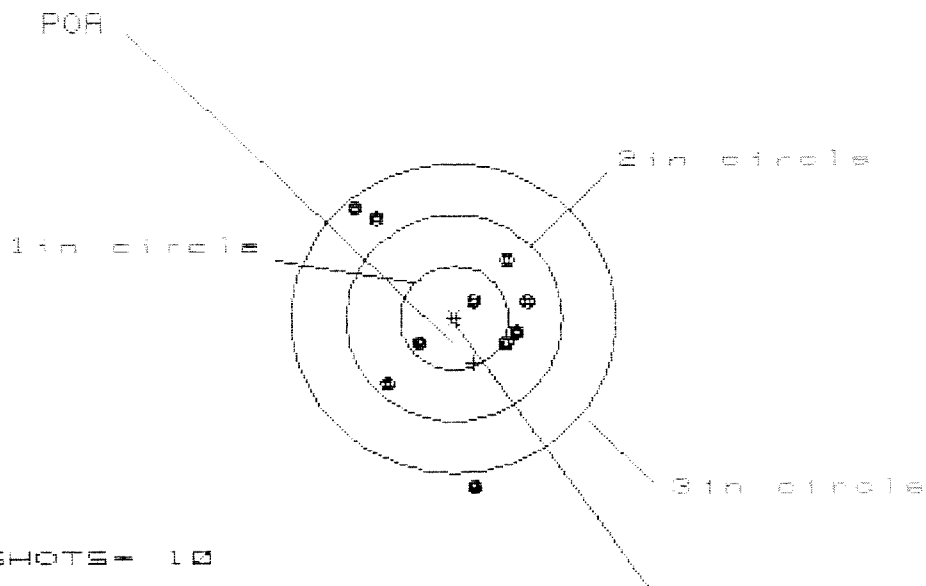
CENTROID #

PATTERN #	:	3		
3 SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.258	1.189	1.165
MINIMUM X	:	-1.340	-0.838	-0.782
MAXIMUM Y	:	1.400	1.235	0.676
MINIMUM Y	:	-1.479	-0.769	-0.614
CENTROID X	:	-0.173	-0.024	-0.080
CENTROID Y	:	-0.098	0.067	-0.088
POA TO CENTROID in.	:	0.198	0.071	0.118
MIN RADIUS	:	0.399	0.367	0.430
MEAN RADIUS	:	0.946	0.806	0.739
MAX RADIUS	:	1.996	1.314	1.215
HORIZONTAL SPREAD	:	2.598	1.947	1.947
VERTICAL SPREAD	:	2.879	2.004	1.290
EXTREME SPREAD	:	3.470	2.381	1.965
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636154

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.604

VS= 2.694

GS= 2.902

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.688	.706	.594
MINIMUM X	:	-.916	-.898	-.811
MAXIMUM Y	:	1.071	.890	.905
MINIMUM Y	:	-1.623	-.792	-.680
CENTROID X	:	-.180	-.198	-.086
CENTROID Y	:	.432	.613	.501
POA TO CENTROID in.	:	.468	.644	.509
MIN RADIUS	:	.262	.230	.145
MEAN RADIUS	:	.835	.749	.639
MAX RADIUS	:	1.631	1.265	1.215
HORIZONTAL SPREAD	:	1.604	1.604	1.405
VERTICAL SPREAD	:	2.694	1.682	1.585
EXTREME SPREAD	:	2.902	1.925	1.710
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08838154

CENTERFIRE PATTERNS # 5

POB

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.957

VS= 1.631

GS= 2.479

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.823	.488	.369
MINIMUM X	:	-1.044	-.952	-.462
MAXIMUM Y	:	1.076	.612	.558
MINIMUM Y	:	-.555	-.436	-.421
CENTROID X	:	.034	-.058	.061
CENTROID Y	:	.248	.129	.183
POB TO CENTROID in.	:	.250	.141	.193
MIN RADIUS	:	.042	.142	.030
MEAN RADIUS	:	.570	.486	.394
MAX RADIUS	:	1.355	1.047	.669
HORIZONTAL SPREAD	:	1.867	1.440	.831
VERTICAL SPREAD	:	1.631	1.040	.979
EXTREME SPREAD	:	2.479	1.781	1.251
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	