

C6636171

MODEL 700™ M24

Model **SWS**

Action _____™

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.

Remington



MODEL 700TM H24

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

20

SERIAL NO.
C6636171

ORDER NO.
5716

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



5716 C6636171



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636171**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	28
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	KS
	C) Inspect Ejector Hole for Chamfer		5/28/91	KS
	D) Oil Firing Pin Ass'y		5/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	PM

op. #	BARBER - M24 0038531 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	6			5/30/91	QU
	G) Safety Off Force	3	3	3			5/30/91	SP
	H) Trigger Pull Test & Retainability						5/30/91	SP
	I) Firing Pin Indent	.020	.020	.020			5/30/91	SP
	J) Assemble Stock						6/3/91	KS
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/3/91	KS
	M) Iron Sight Alignment						6/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	KS
	O) Attach Scope to Rifle						6/3/91	KS
	P) Detach & Attach Scope 20 Times						6/3/91	KS
640	Gallery Target & Test						6-4-91	AC
	A) Time						6-4-91	AC
	B) Malfunctions						6-4-91	AC
	C) Pierced Primers						6-4-91	AC
	D) Optical Clarity of Scope						6-4-91	AC
645	Inspect for Live Ammo						6-4-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.18	2.15	2.14	2.18	2.15	6-8-91	SP
	C) Function						6-8-91	D/H
660	Pack						6-20-91	DF

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

SERIAL NO. C6636171DATE 5/30/91TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.38	2.42	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.40	2.40	2.15	
PULL #3	2.62	2.36	2.45	2.14	
PULL #4	2.67	2.37	2.38	2.18	
PULL #5	2.63	2.41	2.38	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.63	3.57		
PULL #2	3.49	3.20		
PULL #3	3.50	3.35		
PULL #4	3.51	3.50		
PULL #5	3.55	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.54		4.62
PULL #2	4.44	4.40		4.64
PULL #3	4.51	4.51		4.64
PULL #4	4.51	4.62		4.65
PULL #5	4.51	4.62		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636171
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.282064
1 TO	2	.118849
1 TO	3	.16269
1 TO	4	.280665
1 TO	5	.428422

5
24#

<----POR

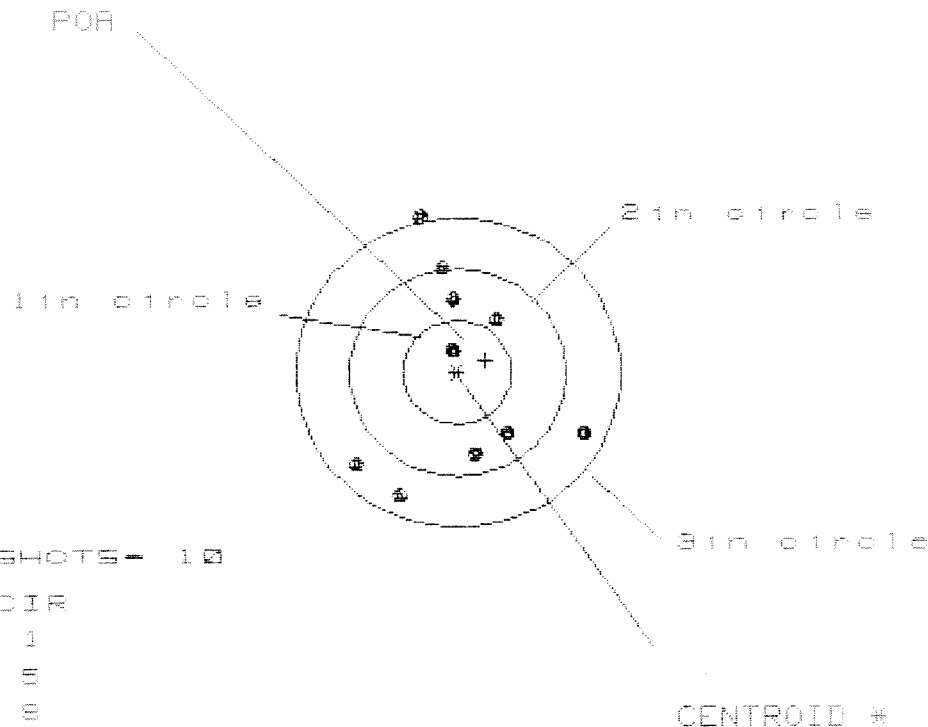
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0076
THE RESULTING AVERAGE PG: RADIUS FOR THIS RIFLE IS: .288736
THE RM: FOR THIS RIFLE IS: .9568

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636171

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.131

VS= 2.632

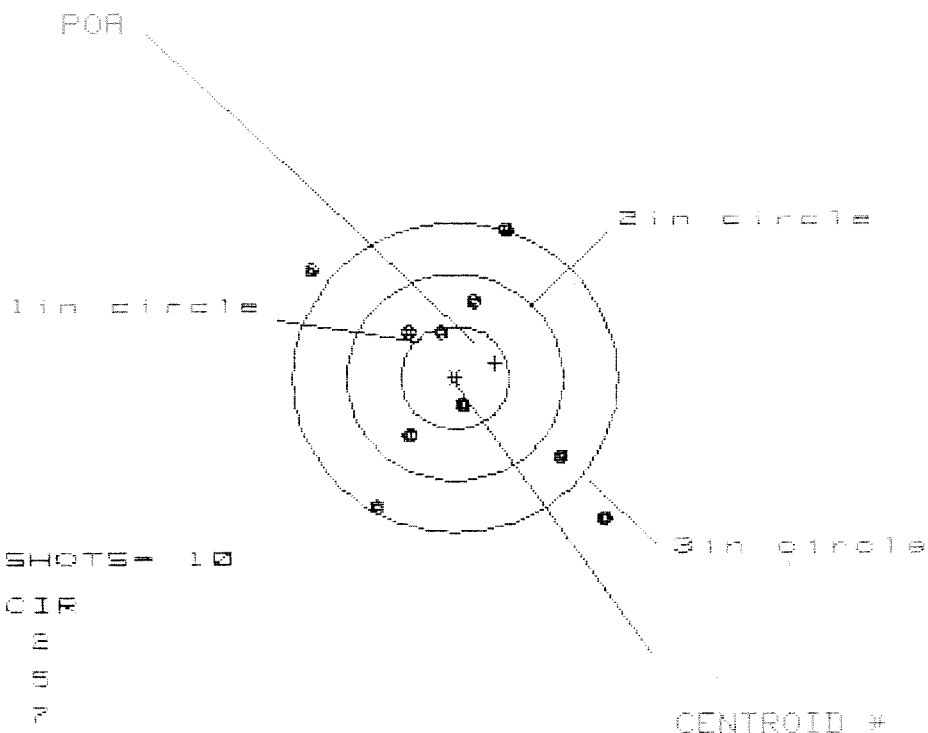
GS= 2.639

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.165	1.124	.998
MINIMUM X	-.966	-1.007	-.725
MAXIMUM Y	1.488	1.208	1.113
MINIMUM Y	-1.143	-.978	-1.073
CENTROID X	-.258	-.217	-.091
CENTROID Y	-.114	-.279	-.183
POA TO CENTROID in.	.282	.354	.285
MIN RADIUS	.212	.382	.343
MEAN RADIUS	.959	.895	.830
MAX RADIUS	1.534	1.263	1.295
HORIZONTAL SPREAD	2.131	2.131	1.723
VERTICAL SPREAD	2.632	2.186	2.186
EXTREME SPREAD	2.639	2.231	2.231
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08630171

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.521

VS= 2.760

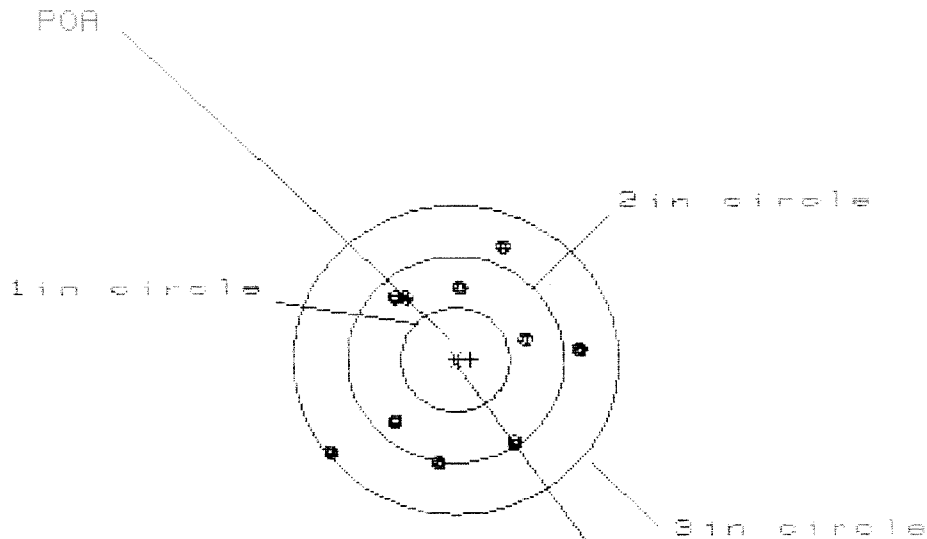
GS= 3.506

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.344
MINIMUM X	:	-1.277
MAXIMUM Y	:	1.454
MINIMUM Y	:	-1.306
CENTROID X	:	-.373
CENTROID Y	:	-.144
POA TO CENTROID in.	:	.399
MIN RADIUS	:	.320
MEAN RADIUS	:	1.047
MAX RADIUS	:	1.874
HORIZONTAL SPREAD	:	2.621
VERTICAL SPREAD	:	2.760
EXTREME SPREAD	:	3.506
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	7

4 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636171

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS = 2.344

VS = 2.127

GS = 2.601

CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.151	1.019	1.055
MINIMUM X	-1.193	-.647	-.611
MAXIMUM Y	1.104	1.000	.761
MINIMUM Y	-1.023	-1.127	-1.002
CENTROID X	-.140	-.808	-.844
CENTROID Y	-.002	.102	-.923
POA TO CENTROID in.	.140	.103	.049
MIN RADIUS	.718	.562	.635
MEAN RADIUS	.964	.884	.866
MAX RADIUS	1.516	1.157	1.058
HORIZONTAL SPREAD	2.344	1.666	1.666
VERTICAL SPREAD	2.127	1.763	1.763
EXTREME SPREAD	2.601	2.197	1.788
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08886171

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.314

VS = 1.844

GS = 2.903

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.680	.483
MINIMUM X	-1.471	-1.573	-1.795
MAXIMUM Y	1.095	1.012	1.023
MINIMUM Y	-.749	-.758	-.747
CENTROID X	.005	.168	.365
CENTROID Y	-.016	.067	.056
POA TO CENTROID in.	.017	.101	.369
MIN RADIUS	.219	.128	.179
MEAN RADIUS	.922	.814	.713
MAX RADIUS	1.650	1.576	1.102
HORIZONTAL SPREAD	2.314	2.253	1.278
VERTICAL SPREAD	1.844	1.770	1.770
EXTREME SPREAD	2.903	2.387	1.950
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/06838171

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.100

VS= 1.704

GS= 3.107

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.357	1.163	.982
MINIMUM X	-1.743	-1.448	-.624
MAXIMUM Y	1.010	1.018	.992
MINIMUM Y	-.694	-.686	-.559
CENTROID X	-.277	-.083	.098
CENTROID Y	.314	.306	.179
POA TO CENTROID in.	.419	.317	.204
MIN RADIUS	.235	.056	.168
MEAN RADIUS	.892	.782	.650
MAX RADIUS	1.745	1.770	1.226
HORIZONTAL SPREAD	3.100	2.611	1.606
VERTICAL SPREAD	1.704	1.704	1.551
EXTREME SPREAD	3.107	2.854	1.817
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	