

C6636175

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

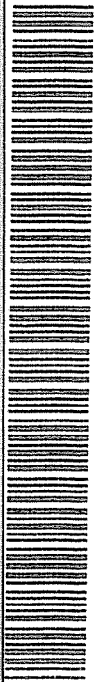
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6636175

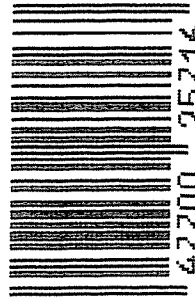
ORDER NO.
5716

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



5716 C6636175

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636175

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	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		Ked
	Magnaflux Bolt	5 6 91		Ked
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	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		6-12-91	JH

op. #	BARBER - M24 0038575	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-12-91	DH
	G) Safety Off Force	3	3	3			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-12-91	SH
	I) Firing Pin Indent	.021	.022	.020			6-12-91	DH
	J) Assemble Stock						6-13/91	RW
	K) Assemble Swivel Studs						6-14-91	SH
	L) Attach Front and Rear Sight Assemblies						6/13/91	RW
	M) Iron Sight Alignment						6/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/13/91	RW
	O) Attach Scope to Rifle						6/13/91	RW
	P) Detach & Attach Scope 20 Times						6/13/91	RW
640	Gallery Target & Test						6-14-91	DH
	A) Time						6-14-91	DH
	B) Malfunctions						6-14-91	DH
	C) Pierced Primers						6-14-91	DH
	D) Optical Clarity of Scope						6-14-91	DH
645	Inspect for Live Ammo						6-14-91	DH
655	Final Inspection							
	A) Headspace						6-14-91	SH
	B) Trigger Pull	2.48	2.40	2.36	2.37	2.37	6-14-91	SH
	C) Function						6-14-91	SH
660	Pack						6-20-91	RF

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

SERIAL NO C-6636175DATE C-12-91TESTER JUL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.59	2.55	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.60	2.50	2.40	
PULL #3	2.54	2.53	2.54	2.36	
PULL #4	2.62	2.57	2.49	2.37	
PULL #5	2.44	2.57	2.51	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.37		
PULL #2	3.37	3.19		
PULL #3	3.43	3.39		
PULL #4	3.45	3.16		
PULL #5	3.43	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.37		4.39
PULL #2	4.21	4.22		4.37
PULL #3	4.25	4.40		4.36
PULL #4	4.32	4.39		4.14
PULL #5	4.36	4.38		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636175
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.157334
1 TO	2	.247111
1 TO	3	.363849
1 TO	4	.160378
1 TO	5	.369542

3.45 (----POA

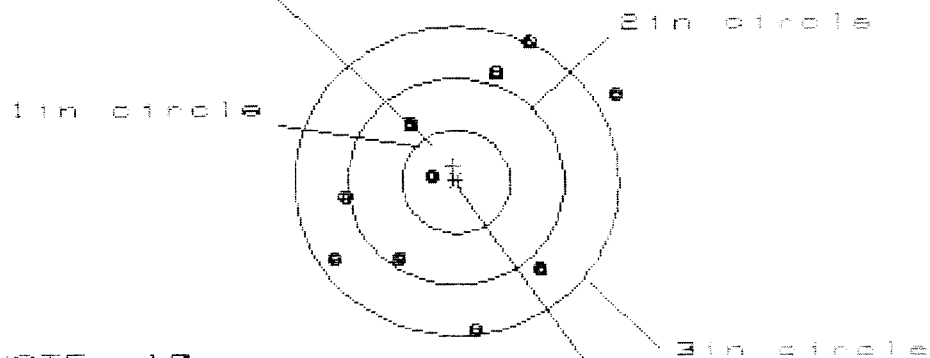
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0662
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141094
THE AMR FOR THIS RIFLE IS: .8456

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636175

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 2.603

VS = 2.853

GS = 3.068

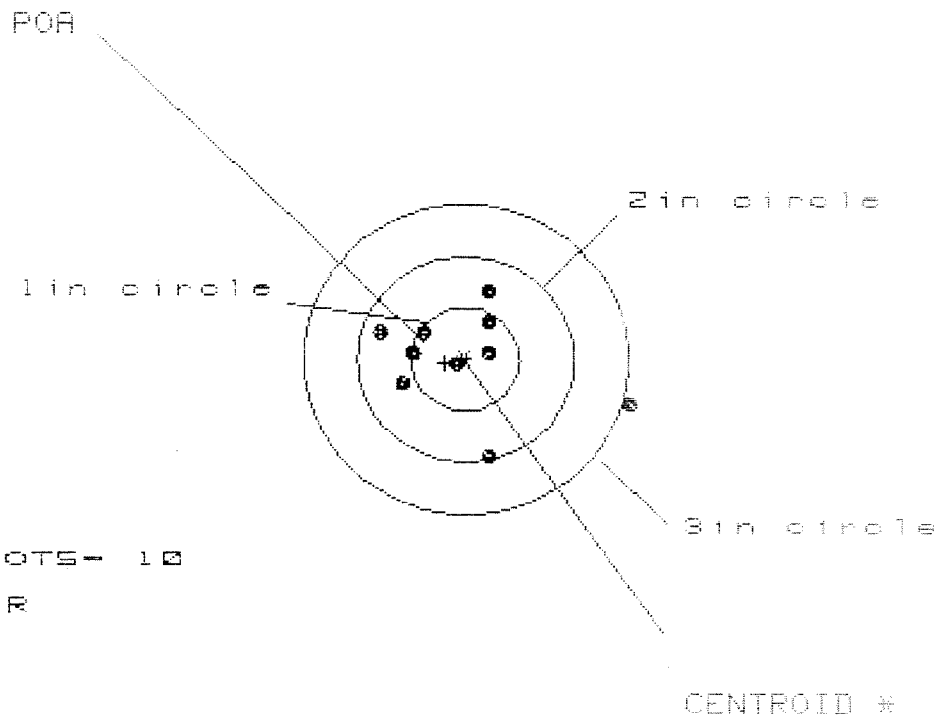
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	.909	1.016
MINIMUM X	:	-1.173	-1.014	-.907
MAXIMUM Y	:	1.402	1.499	1.388
MINIMUM Y	:	-1.451	-1.354	-1.167
CENTROID X	:	.027	-.132	-.239
CENTROID Y	:	-.155	-.252	-.439
POA TO CENTROID in.	:	.157	.284	.500
MIN RADIUS	:	.274	.165	.306
MEAN RADIUS	:	1.126	1.027	.921
MAX RADIUS	:	1.675	1.726	1.520
HORIZONTAL SPREAD	:	2.603	1.923	1.923
VERTICAL SPREAD	:	2.853	2.853	2.555
EXTREME SPREAD	:	3.068	2.906	2.563
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 2.328

VS= 1.618

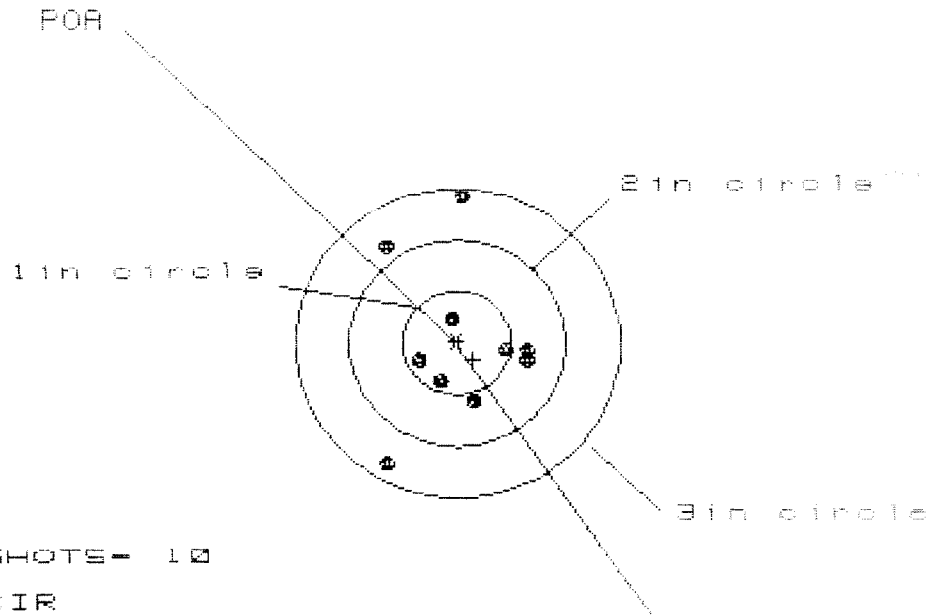
GS= 2.458

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.507	.430	.479
MINIMUM X	:	-.821	-.654	-.605
MAXIMUM Y	:	.652	.598	.471
MINIMUM Y	:	-.966	-1.020	-.433
CENTROID X	:	.185	.018	-.031
CENTROID Y	:	.035	.089	.216
POA TO CENTROID in.	:	.189	.091	.219
MIN RADIUS	:	.071	.169	.220
MEAN RADIUS	:	.660	.536	.455
MAX RADIUS	:	1.582	1.092	.618
HORIZONTAL SPREAD	:	2.328	1.084	1.084
VERTICAL SPREAD	:	1.618	1.618	.904
EXTREME SPREAD	:	2.458	1.648	1.208
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.304

VS= 2.627

GS= 2.724

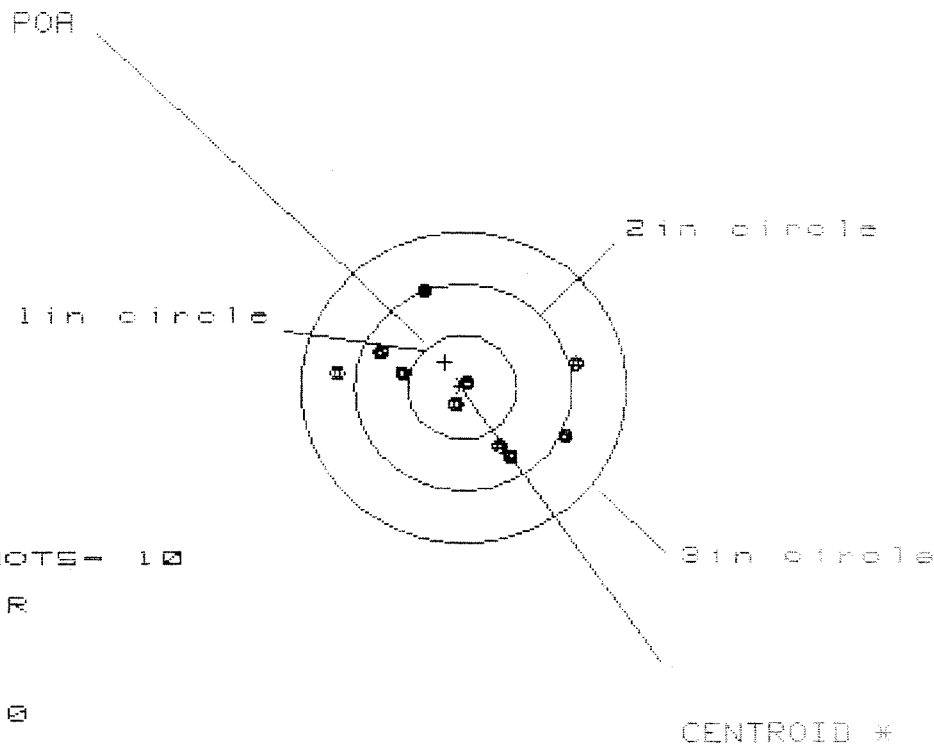
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.639	.646	.564
MINIMUM X	:	-.665	-.658	-.718
MAXIMUM Y	:	1.456	1.089	.963
MINIMUM Y	:	-1.171	-1.009	-.548
CENTROID X	:	-.148	-.154	-.072
CENTROID Y	:	.164	.002	.128
POA TO CENTROID in.	:	.220	.154	.147
MIN RADIUS	:	.243	.270	.297
MEAN RADIUS	:	.730	.628	.550
MAX RADIUS	:	1.457	1.261	1.201
HORIZONTAL SPREAD	:	1.304	1.304	1.281
VERTICAL SPREAD	:	2.627	2.098	1.511
EXTREME SPREAD	:	2.724	2.098	1.713
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.201

VS= 1.680

GS= 2.204

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	.951	.887
MINIMUM X	:	-1.125	-.838	-.719
MAXIMUM Y	:	.971	.984	1.013
MINIMUM Y	:	-.709	-.696	-.667
CENTROID X	:	.163	.288	.169
CENTROID Y	:	-.240	-.253	-.282
POA TO CENTROID in.	:	.290	.383	.329
MIN RADIUS	:	.072	.082	.096
MEAN RADIUS	:	.724	.681	.622
MAX RADIUS	:	1.131	1.098	1.078
HORIZONTAL SPREAD	:	2.201	1.739	1.606
VERTICAL SPREAD	:	1.680	1.680	1.680
EXTREME SPREAD	:	2.204	1.897	1.897
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.617

VS= 2.247

GS= 2.619

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	.923	.783
MINIMUM X	:	-1.218	-1.063	-.948
MAXIMUM Y	:	1.128	1.119	.978
MINIMUM Y	:	-1.119	-1.128	-1.252
CENTROID X	:	.396	.240	.125
CENTROID Y	:	-.135	-.126	.015
POA TO CENTROID in.	:	.418	.271	.126
MIN RADIUS	:	.400	.447	.453
MEAN RADIUS	:	.988	.936	.855
MAX RADIUS	:	1.401	1.457	1.345
HORIZONTAL SPREAD	:	2.617	1.986	1.731
VERTICAL SPREAD	:	2.247	2.247	2.230
EXTREME SPREAD	:	2.619	2.490	2.490
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	