

C66361B7

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

Remington[®]

MODEL 700[™] M24

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

DU PONT

SERIAL NO.
C6636187

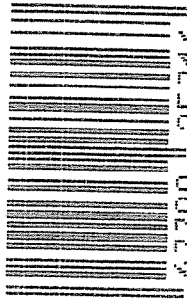
ORDER NO.
5716

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



5716 C6636187

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636187

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		W.D.
620	Apply Coatings (Barrel Action)		5-21-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KA
	C) Inspect Ejector Hole for Chamfer		7/15/91	KA
	D) Oil Firing Pin Ass'y		7/15/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		7/16/91	JA

op. #	BARBER - M24 0038704	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7/16/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			7/16/91	WB
	H) Trigger Pull Test & Retainability						7-16-91	SH
	I) Firing Pin Indent	.0725	.0715	.072			7/16/91	WB
	J) Assemble Stock						7/16/91	KS
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/16/91	KS
	M) Iron Sight Alignment						7/16/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/16/91	KS
	O) Attach Scope to Rifle						7/16/91	KS
	P) Detach & Attach Scope 20 Times						7/16/91	KS
640	Gallery Target & Test						7-17-91	AC
	A) Time						7-17-91	AC
	B) Malfunctions						7-17-91	AC
	C) Pierced Primers						7-17-91	AC
	D) Optical Clarity of Scope						7-17-91	AC
645	Inspect for Live Ammo						7-17-91	AC
655	Final Inspection							
	A) Headspace						7-23-91	D/H
	B) Trigger Pull	2.61	2.57	2.66	2.59	2.58	7-22-91	SH
	C) Function						7-23-91	D/H
660	Pack						9-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 6636187

DATE 7-16-91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.55	2.37	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.40	2.40	2.57	
PULL #3	2.55	2.39	2.42	2.56	
PULL #4	2.55	2.41	2.38	2.59	
PULL #5	2.36	2.39	2.38	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.37		
PULL #2	3.42	3.36		
PULL #3	3.39	3.35		
PULL #4	3.38	3.30		
PULL #5	3.39	3.41		
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	4.23		4.41
PULL #2	4.22	4.20		4.43
PULL #3	4.23	4.19		4.41
PULL #4	4.16	4.42		4.45
PULL #5	4.20	4.41		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636187
17 Jul 1991

CENTROIDAL DISTANCES

Ø TO	1	.487259
1 TO	2	.475689
1 TO	3	.697877
1 TO	4	.317099
1 TO	5	.231812

$\#^{14}_3$ <----FOR

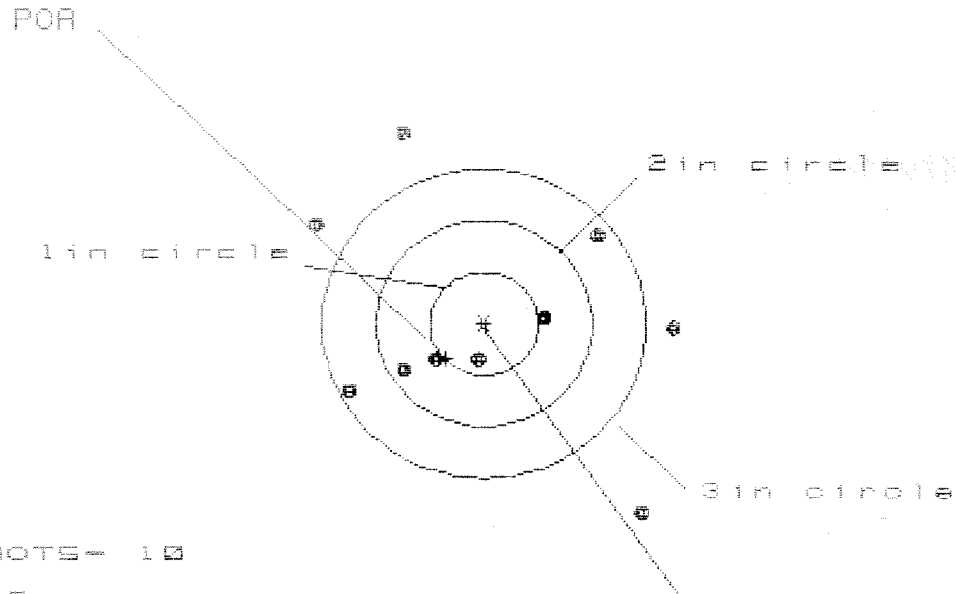
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3628
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .111
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .379401
THE AMR FOR THIS RIFLE IS: 1.166

17 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8838187

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 6

HS = 3.257

VS = 3.672

GS = 4.270

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.702	1.867	1.800
MINIMUM X	-1.565	-1.400	-1.467
MAXIMUM Y	1.822	1.616	.913
MINIMUM Y	-1.850	-1.862	-1.660
CENTROID X	.350	.185	.252
CENTROID Y	.339	.545	.343
POR TO CENTROID in.	.487	.575	.426
MIN RADIUS	.370	.588	.377
MEAN RADIUS	1.282	1.173	1.056
MAX RADIUS	2.369	1.887	1.801
HORIZONTAL SPREAD	3.267	3.267	3.267
VERTICAL SPREAD	3.672	2.478	1.573
EXTREME SPREAD	4.270	3.412	3.412
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

17 Jul 1991

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS = 2.854

VS = 3.763

GS = 3.998

CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	1.022	.987
MINIMUM X	-1.657	-1.060	-1.095
MAXIMUM Y	1.901	1.719	1.182
MINIMUM Y	-1.862	-2.044	-1.829
CENTROID X	-.036	.149	.184
CENTROID Y	.061	.243	.028
POA TO CENTROID in.	.070	.285	.186
MIN RADIUS	.232	.454	.453
MEAN RADIUS	1.311	1.173	1.115
MAX RADIUS	2.332	2.045	1.832
HORIZONTAL SPREAD	2.864	2.082	2.082
VERTICAL SPREAD	3.763	3.763	3.011
EXTREME SPREAD	3.998	3.770	3.200
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

(7 Jul 1991)

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.044

VS= 2.644

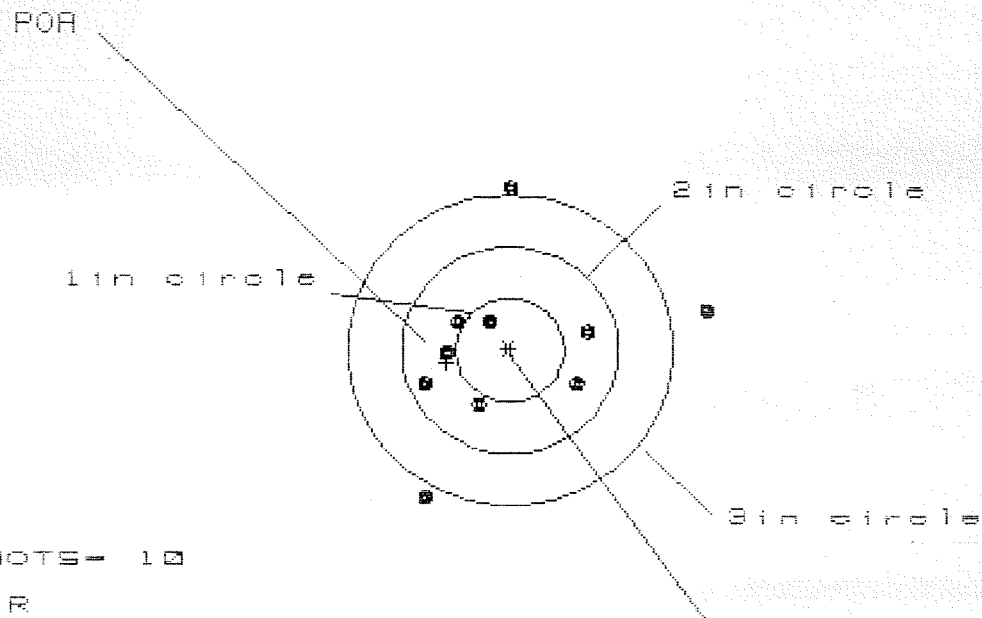
GS= 3.544

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.084	1.569	.811
MINIMUM X	:	-.960	-.728	-.532
MAXIMUM Y	:	1.067	1.138	.950
MINIMUM Y	:	-1.577	-1.506	-1.288
CENTROID X	:	.777	.545	.349
CENTROID Y	:	-.213	-.284	-.096
POA TO CENTROID in.	:	.805	.615	.362
MIN RADIUS	:	.497	.558	.286
MEAN RADIUS	:	1.177	1.029	.832
MAX RADIUS	:	2.182	2.175	1.393
HORIZONTAL SPREAD	:	3.044	2.297	1.343
VERTICAL SPREAD	:	2.644	2.644	2.238
EXTREME SPREAD	:	3.544	3.265	2.312
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 7

HS= 2.571

VS= 2.993

GS= 3.107

CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.805	.901	.922
MINIMUM X	-.766	-.565	-.544
MAXIMUM Y	1.604	1.645	.507
MINIMUM Y	-1.389	-1.348	-1.143
CENTROID X	.584	.383	.362
CENTROID Y	.125	.084	-.121
POA TO CENTROID in.	.597	.392	.382
MIN RADIUS	.327	.302	.284
MEAN RADIUS	.930	.785	.673
MAX RADIUS	1.842	1.653	1.263
HORIZONTAL SPREAD	2.571	1.466	1.466
VERTICAL SPREAD	2.993	2.993	1.650
EXTREME SPREAD	3.107	3.080	2.105
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	

17 JUL 1991

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 3.269

VS= 3.203

GS= 3.529

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.027	1.015	.922
MINIMUM X	:	-1.242	-1.017	-1.110
MAXIMUM Y	:	1.640	1.615	1.450
MINIMUM Y	:	-1.563	-1.588	-1.386
CENTROID X	:	.139	-.086	.007
CENTROID Y	:	.243	.268	.066
POA TO CENTROID in.	:	.280	.281	.066
MIN RADIUS	:	.368	.142	.312
MEAN RADIUS	:	1.128	1.018	.914
MAX RADIUS	:	2.039	1.779	1.576
HORIZONTAL SPREAD	:	3.269	2.032	2.032
VERTICAL SPREAD	:	3.203	3.203	2.836
EXTREME SPREAD	:	3.529	3.276	2.874
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	