

C6348859

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Sweet[®]

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

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

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

MODEL 700™ M24

SERIAL NO.
C6C48859

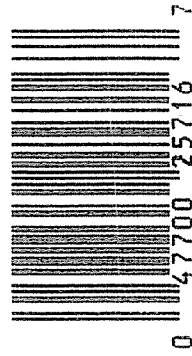
ORDER NO.
5716

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

5716 C6C48859

01

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348859

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 11	89	RW
600	Proof		89	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		7/13	KCR
	Magnaflux Bolt		7/13	KCR
615	Rollmark Caliber		7/13	DS
617	Drill and Tap Sight Holes	7 13	89	J
618	Polish Barrel <i>1603</i>	7 13	89	R
620	Apply Coatings (Barrel Action)		7/24/89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/89	RW
	C) Inspect Ejector Hole for Chamfer		7/25/89	RW
	D) Oil Firing Pin Ass'y		7/25/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7/25/89	J.C.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/28/89	WB
	G) Safety Off Force	3	3	3			7/28/89	WB
	H) Trigger Pull Test & Retainability						7/28/89	JU
	I) Firing Pin Indent	.020	.0207	.0215			7/28/89	WB
	J) Assemble Stock						7/31/89	RW
	K) Assemble Swivel Studs						2 Aug 89	JS
	L) Attach Front and Rear Sight Assemblies						7/31/89	RW
	M) Iron Sight Alignment						7/31/89	RW
	N) Detach Front & Rear Sights & place in numbered container						7/31/89	RW
	O) Attach Scope to Rifle						8/1/89	WB
	P) Detach & Attach Scope 20 Times						8/1/89	WB
640	Gallery Target & Test	103R	49L				8-1-89	A
	A) Time						8-1-89	A
	B) Malfunctions						8-1-89	A
	C) Pierced Primers						8-1-89	A
	D) Optical Clarity of Scope						8-1-89	A
645	Inspect for Live Ammo						8-1-89	A
655	Final Inspection							
	A) Headspace						2 Aug 89	JS
	B) Trigger Pull	2.29	2.46	2.60	2.83	2.08	2 Aug 89	JS
	C) Function						2 Aug 89	JS
660	Pack						7/20/89	A

BARBER - M24 0039981

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 16348859DATE 3-27-90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.42	2.47	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.48	2.55	
PULL #3	2.43	2.50	2.51	
PULL #4	2.43	2.52	2.56	
PULL #5	2.48	2.54	2.52	
TOTAL	12.17	12.51	12.74	
AVG.	2.434	2.502	2.548	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.26	3.44	
PULL #2	3.37	3.40	
PULL #3	3.46	3.46	
PULL #4	3.45	3.39	
PULL #5	3.46	3.43	
TOTAL	17.00	17.12	
AVG.	3.4	3.424	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.54		
PULL #2	4.53	4.52		
PULL #3	4.51	4.35		
PULL #4	4.52	4.36		
PULL #5	4.55	4.36		
TOTAL	22.45	22.13		
AVG.	4.49	4.426		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348859
3 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	.619397
1 TO	2	.721612
1 TO	3	.709612
1 TO	4	.521208
1 TO	5	.101356

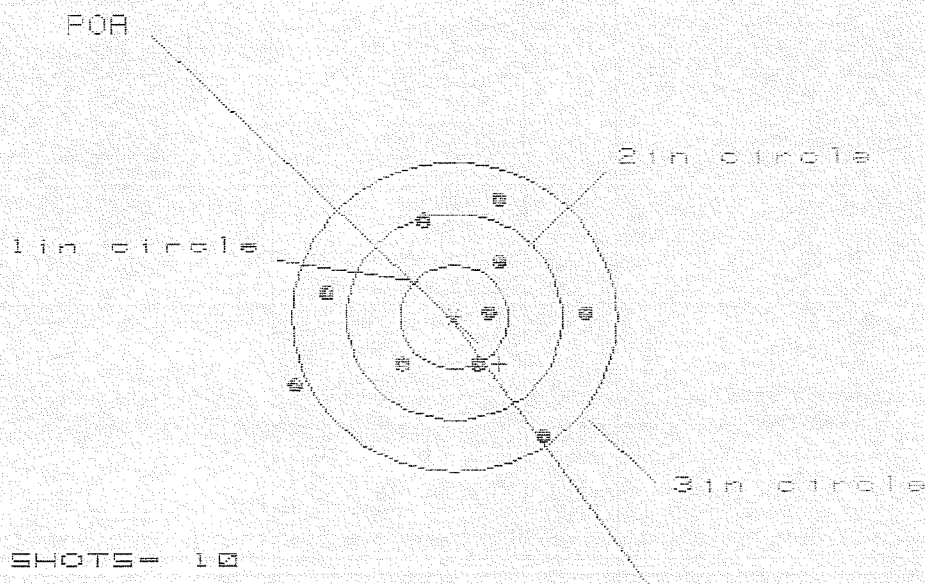
5
4.8 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .247342
THE AMR FOR THIS RIFLE IS: .834

2 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346859

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.729

VS= 2.294

GS= 2.833

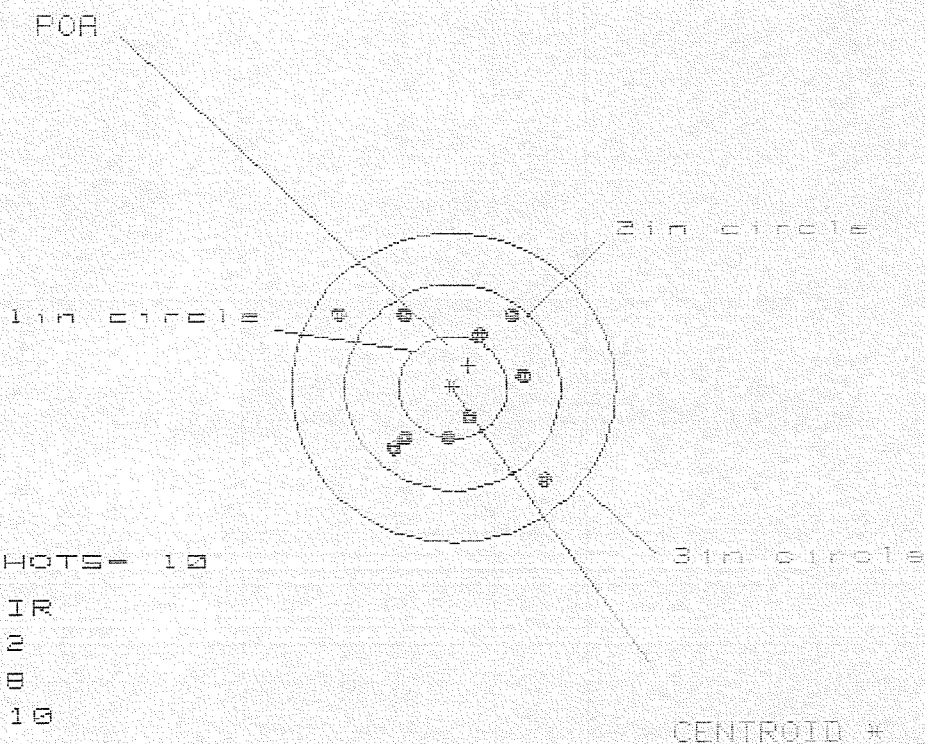
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.266	1.103	1.183
MINIMUM X	-1.463	-1.301	-1.221
MAXIMUM Y	1.117	1.039	.882
MINIMUM Y	-1.177	-1.255	-1.716
CENTROID X	-.417	-.254	-.334
CENTROID Y	.458	.536	.693
POA TO CENTROID in.	.619	.593	.769
MIN RADIUS	.311	.161	.317
MEAN RADIUS	.977	.877	.812
MAX RADIUS	1.625	1.408	1.221
HORIZONTAL SPREAD	2.729	2.404	2.404
VERTICAL SPREAD	2.294	2.294	1.598
EXTREME SPREAD	2.833	2.410	2.410
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

2 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348059

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.900

VS= 1.632

GS= 2.462

PATTERN #	2	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.844	.726	.622
MINIMUM X	-1.056	-1.642	-1.551
MAXIMUM Y	.753	.830	.739
MINIMUM Y	-.879	-.802	-.635
CENTROID X	-.149	-.031	-.122
CENTROID Y	-.212	-.289	-.188
POA TO CENTROID in.	.259	.290	.224
MIN RADIUS	.305	.191	.315
MEAN RADIUS	.766	.692	.648
MAX RADIUS	1.260	1.082	.848
HORIZONTAL SPREAD	1.900	1.368	1.173
VERTICAL SPREAD	1.632	1.632	1.364
EXTREME SPREAD	2.462	2.056	1.677
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

2 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348859

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.644

VS= 3.150

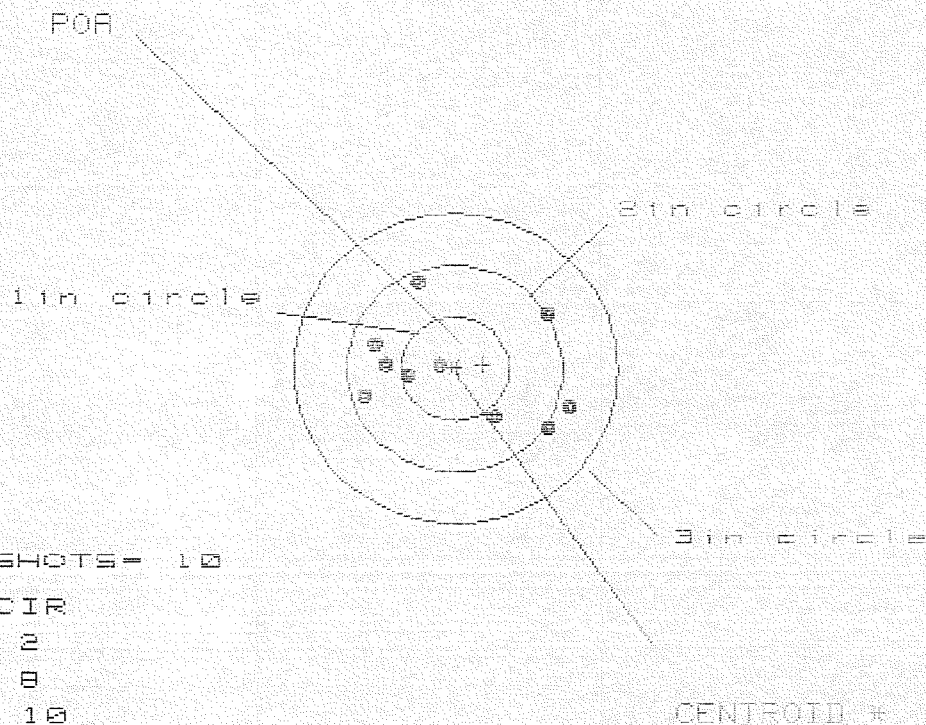
GS= 3.150

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.971	.993	1.015
MINIMUM X	:	-.673	-.651	-.629
MAXIMUM Y	:	1.468	1.281	.987
MINIMUM Y	:	-1.682	-1.411	-1.251
CENTROID X	:	.068	.046	.024
CENTROID Y	:	-.060	.127	-.033
POA TO CENTROID in.	:	.091	.135	.040
MIN RADIUS	:	.120	.287	.126
MEAN RADIUS	:	.920	.846	.754
MAX RADIUS	:	1.694	1.554	1.416
HORIZONTAL SPREAD	:	1.644	1.644	1.644
VERTICAL SPREAD	:	3.150	2.692	2.238
EXTREME SPREAD	:	3.150	2.817	2.777
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06340025

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.942

VS= 1.424

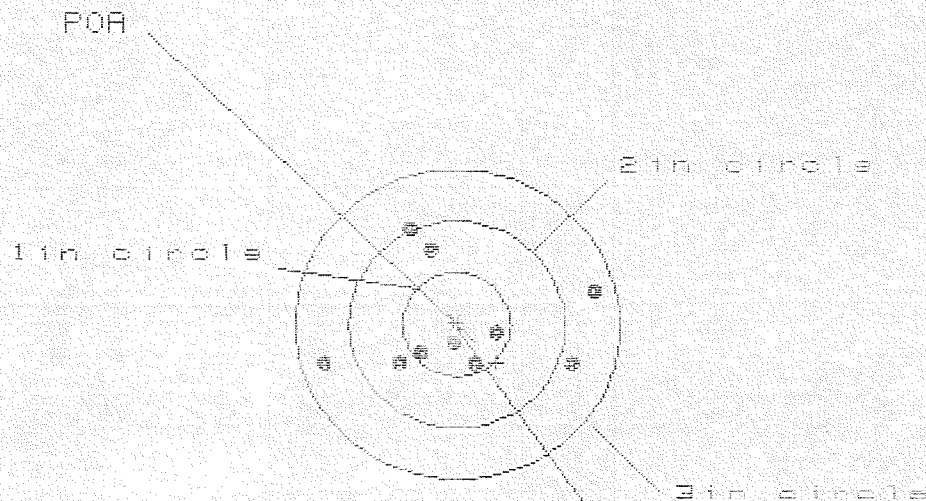
GS= 1.944

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.078	.962	1.051
MINIMUM X	-.864	-.745	-.624
MAXIMUM Y	.874	.833	.759
MINIMUM Y	-.550	-.531	-.558
CENTROID X	-.260	-.379	-.500
CENTROID Y	-.039	.002	.076
POA TO CENTROID in.	.263	.379	.505
MIN RADIUS	.123	.041	.148
MEAN RADIUS	.753	.678	.603
MAX RADIUS	1.138	1.129	1.116
HORIZONTAL SPREAD	1.942	1.707	1.675
VERTICAL SPREAD	1.424	1.424	1.318
EXTREME SPREAD	1.944	1.849	1.847
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

2 Aug 1985

FILE:/PATTERNING/CENTERFIRE_PATT/08040059

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 2.476

VS= 1.365

GS= 2.560

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.264
MINIMUM X	-1.212
MAXIMUM Y	.955
MINIMUM Y	-.410
CENTROID X	-.365
CENTROID Y	.371
POA TO CENTROID in.	.521
MIN RADIUS	.197
MEAN RADIUS	.754
MAX RADIUS	1.302
HORIZONTAL SPREAD	2.476
VERTICAL SPREAD	1.365
EXTREME SPREAD	2.560
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10