

65348881

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

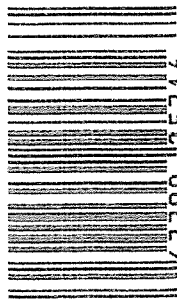
SERIAL NO. C6048881	01
ORDER NO. 5716	

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



5716 C6048881

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348881

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9-15-89	G.S.
7	Drill and Tap Sight Holes	9 15	89	TR
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-15-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		26/89	JS

BARBER - M24 0040576							
op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	4	4	4	10/3/89	JS	
	G) Safety Off Force	3	3	3	10/3/89	JS	
	H) Trigger Pull Test & Retainability				26/89	JS	
	I) Firing Pin Indent	.0215	.022	.0215	10/3/89	JS	
	J) Assemble Stock				10/17/89	RW	
	K) Assemble Swivel Studs				18/89	JS	
	L) Attach Front and Rear Sight Assemblies				12/11/89	JS	
	M) Iron Sight Alignment				12/11/89	RW	
	N) Detach Front & Rear Sights & place in numbered container				12/14/89	RW	
	O) Attach Scope to Rifle				10/17/89	JS	
	P) Detach & Attach Scope 20 Times				10/17/89	JS	
640	Gallery Target & Test				10-17-89	A	
	A) Time				10-17-89	A	
	B) Malfunctions				10-17-89	A	
	C) Pierced Primers				10-17-89	A	
	D) Optical Clarity of Scope				10-17-89	A	
645	Inspect for Live Ammo				10-17-89	A	
655	Final Inspection						
	A) Headspace				18/89	JS	
	B) Trigger Pull	211	221	226	232	227	18/89
	C) Function				18/89	JS	
660	Pack				18Dec89	JS	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 26348881

DATE 3-12-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.38	2.50		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.67	2.26	2.42		
PULL #3	2.30	2.64	2.43		
PULL #4	2.37	2.60	2.51		
PULL #5	2.35	2.51	2.41		
TOTAL	12.21	12.29	12.27		
AVG.	2.442	2.458	2.454		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.51		
PULL #2	3.18	3.66		
PULL #3	3.52	3.54		
PULL #4	3.52	3.60		
PULL #5	3.45	3.39		
TOTAL	16.88	17.70		
AVG.	3.376	3.54		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.26		4.25
PULL #2	4.30	4.25		4.28
PULL #3	4.28	4.31		4.27
PULL #4	4.26	4.31		4.35
PULL #5	4.31	4.34		4.38
TOTAL	21.39	21.47		21.53
AVG.	4.278	4.294		4.306

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348881
17 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.739173
1 TO	2	.579396
1 TO	3	.568719
1 TO	4	.578402
1 TO	5	.876362

2.7 1 0.000000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2398
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0908
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .256415
THE AMP FOR THIS RIFLE IS: 1.013

17 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348881

CENTERFIRE PATTERNS

1

FOR

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.918

VS= 2.590

CS= 3.445

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.269	1.085	1.032
MINIMUM X	-1.649	-1.155	-1.208
MAXIMUM Y	1.190	1.053	.861
MINIMUM Y	-1.401	-1.537	-1.073
CENTROID X	.619	.883	.856
CENTROID Y	-.484	-.267	-.074
FOR TO CENTROID in.	.739	.846	.850
MIN RADIUS	.354	.419	.227
MEAN RADIUS	1.097	.963	.844
MAX RADIUS	2.058	1.596	1.310
HORIZONTAL SPREAD	2.918	2.240	2.240
VERTICAL SPREAD	2.590	2.590	1.934
EXTREME SPREAD	3.445	2.644	2.304
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

17 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348881

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS = 1.697

VS = 3.547

GS = 3.819

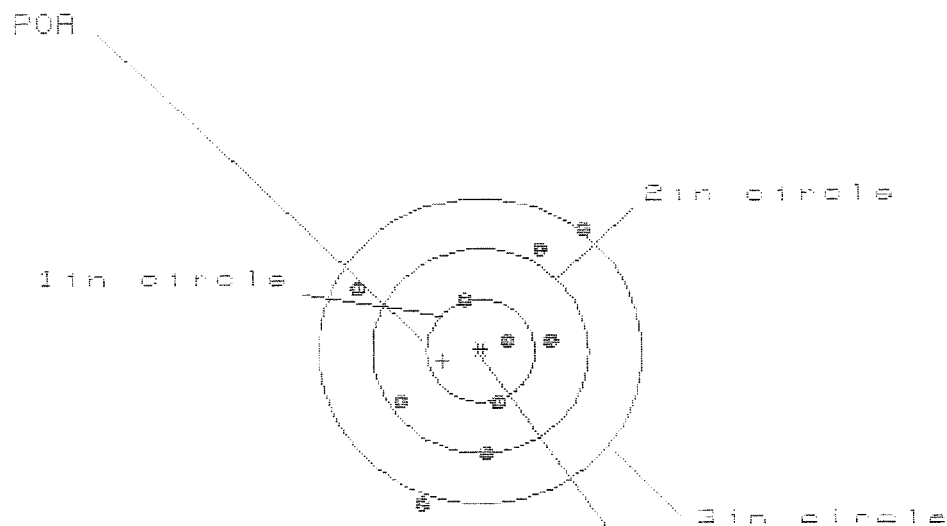
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.890	.831	.864
MINIMUM X	:	-.807	-.866	-.762
MAXIMUM Y	:	1.974	1.462	1.293
MINIMUM Y	:	-1.573	-1.354	-1.506
CENTROID X	:	.079	.138	.034
CENTROID Y	:	-.194	-.413	-.244
POA TO CENTROID in.	:	.210	.436	.246
MIN RADIUS	:	.133	.308	.201
MEAN RADIUS	:	1.047	.944	.839
MAX RADIUS	:	2.043	1.589	1.508
HORIZONTAL SPREAD	:	1.697	1.697	1.626
VERTICAL SPREAD	:	3.547	2.816	2.799
EXTREME SPREAD	:	3.819	2.992	2.803
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

17 Oct 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 3

HS = 2.104

VS = 2.636

GS = 3.055

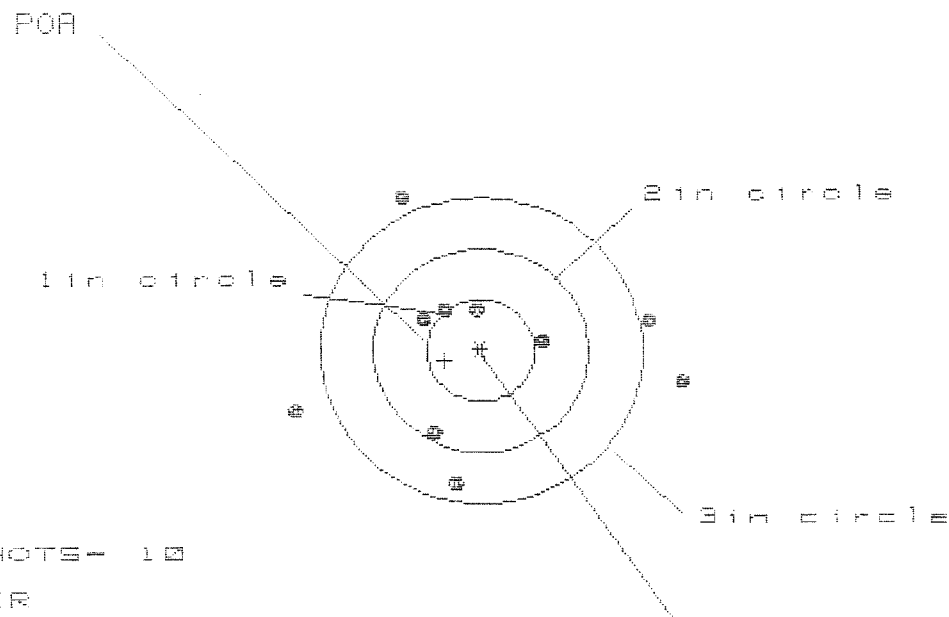
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.952
MINIMUM X	-1.152
MAXIMUM Y	1.163
MINIMUM Y	-1.473
CENTROID X	.348
CENTROID Y	.096
POA TO CENTROID in.	.361
MIN RADIUS	.282
MEAN RADIUS	.953
MAX RADIUS	1.587
HORIZONTAL SPREAD	2.104
VERTICAL SPREAD	2.636
EXTREME SPREAD	3.055
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	3

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 2.531

VS= 2.752

ES= 3.647

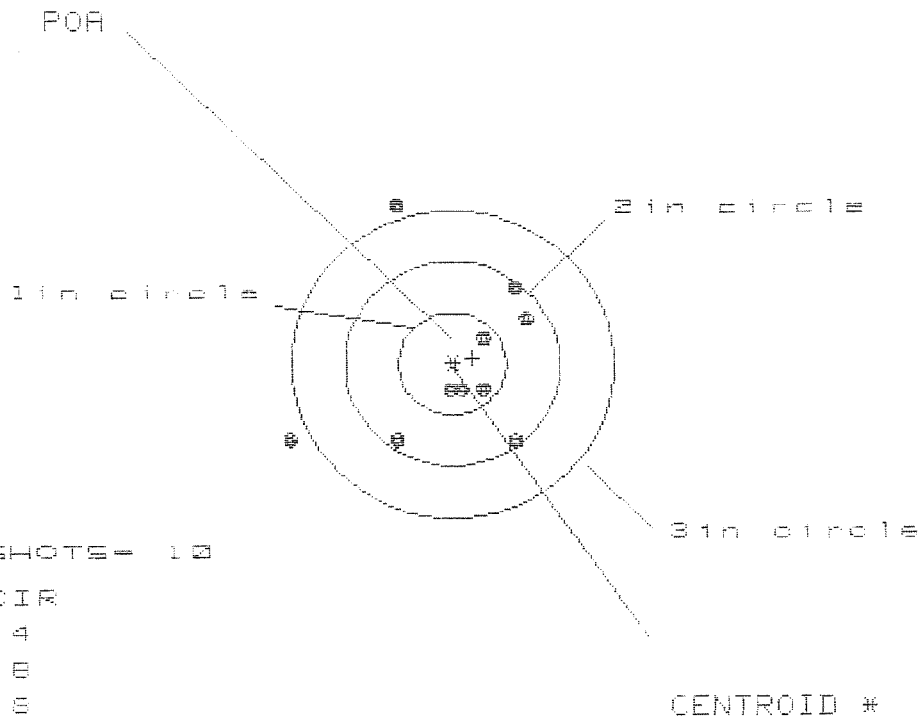
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.912	1.778	1.589
MINIMUM X	:	-1.719	-1.506	-1.752
MAXIMUM Y	:	1.483	1.453	1.373
MINIMUM Y	:	-1.269	-1.299	-1.379
CENTROID X	:	.337	.124	.313
CENTROID Y	:	.101	.131	.212
POA TO CENTROID in.	:	.352	.188	.377
MIN RADIUS	:	.375	.357	.261
MEAN RADIUS	:	1.136	1.019	.929
MAX RADIUS	:	1.931	1.801	1.603
HORIZONTAL SPREAD	:	3.631	3.284	2.941
VERTICAL SPREAD	:	2.752	2.752	2.752
EXTREME SPREAD	:	3.647	3.414	2.804
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 2.168

VS = 2.307

GS = 2.542

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.666	.499	.419
MINIMUM X	-1.502	-.662	-.742
MAXIMUM Y	1.551	1.469	.866
MINIMUM Y	-.756	-.838	-.655
CENTROID X	-.184	-.017	.063
CENTROID Y	-.053	.029	-.154
POR TO CENTROID in.	.191	.034	.167
MIN RADIUS	.259	.264	.191
MEAN RADIUS	.830	.714	.561
MAX RADIUS	1.676	1.602	.990
HORIZONTAL SPREAD	2.168	1.161	1.161
VERTICAL SPREAD	2.307	2.307	1.521
EXTREME SPREAD	2.542	2.528	1.843
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		