

C6348892

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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.

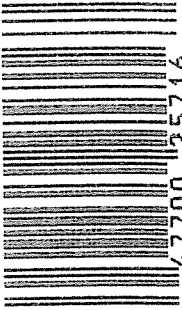
MODEL 700™ M24	SERIAL NO. C6348892	ORDER NO. 5716
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6348892

UPC



0 47700 25716 7

INTERCHANGEABILITY

BARBER - M24 0040853

M-24

SCOPE
0242

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348892

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 30	89	DW
600	Proof	8 30	89	DW
607	Check Headspace	8 30	89	DW
610	Dis-assemble Gun	8 30	89	DW
612	Magnaflux Barrel Action		8/31/89	KCR
	Magnaflux Bolt		8/31/89	KCR
615	Rollmark Caliber		8/31/89	G.S.
7	Drill and Tap Sight Holes	9 1	89	FE
618	Polish Barrel <i>R/B</i>	9 1	89	BT
620	Apply Coatings (Barrel Action)		9-7-89	KA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		9/24/89	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		27 Sept 89	928

op. #	BARBER - M24 0040854 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/2/89	94
	G) Safety Off Force	4	4	4			10/2/89	94
	H) Trigger Pull Test & Retainability						27 Sept 89	928
	I) Firing Pin Indent	.021	.0215	.021			10/2/89	94
	J) Assemble Stock						10/3/89	RW
	K) Assemble Swivel Studs						4 Oct 89	928
	L) Attach Front and Rear Sight Assemblies						10/3/89	RW
	M) Iron Sight Alignment						10/3/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/3/89	RW
	O) Attach Scope to Rifle						10/3/89	94
	P) Detach & Attach Scope 20 Times						10/3/89	94
640	Gallery Target & Test						10-3-89	DH
	A) Time						10-3-89	DH
	B) Malfunctions						10-3-89	DH
	C) Pierced Primers						10-3-89	DH
	D) Optical Clarity of Scope						10-3-89	DH
645	Inspect for Live Ammo						10-3-89	DH
655	Final Inspection A) Headspace						4 Oct 89	928
	B) Trigger Pull	266	259	261	264	265	4 Oct 89	928
	C) Function						4 Oct 89	928
660	Pack						14 Oct 89	928

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6348892DATE 4-6-90TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.49	2.40	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.37	2.43	
PULL #3	2.47	2.35	2.39	
PULL #4	2.42	2.36	2.38	
PULL #5	2.40	2.35	2.36	
TOTAL	12.19	11.83	12.02	
AVG.	2.43	2.36	2.41	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.38	3.33	
PULL #2	3.27	3.34	
PULL #3	3.23	3.34	
PULL #4	3.28	3.30	
PULL #5	3.25	3.33	
TOTAL	16.41	16.64	
AVG.	3.28	3.32	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.24		
PULL #2	4.22	4.19		
PULL #3	4.25	4.10		
PULL #4	4.22	4.16		
PULL #5	4.20	4.12		
TOTAL	21.10	20.81		
AVG.	4.21	4.16		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348892
3 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.618266
1 TO	2	.726176
1 TO	3	.77582
1 TO	4	.913474
1 TO	5	.48154

4 +3
1 52 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0668
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1774
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .18956

THE AMP FOR THIS RIFLE IS: 1.077

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08340892

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HE = 3.524

VS = 2.822

GS = 4.140

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.217	.961	1.060
MINIMUM X	:	-2.307	-.978	-.879
MAXIMUM Y	:	1.661	1.576	.883
MINIMUM Y	:	-1.161	-1.246	-1.049
CENTROID X	:	-.157	.099	.000
CENTROID Y	:	-.598	-.513	-.710
POR TO CENTROID in.	:	.619	.522	.710
MIN RADIUS	:	.198	.189	.296
MEAN RADIUS	:	1.061	.888	.791
MAX RADIUS	:	2.431	1.763	1.682
HORIZONTAL SPREAD	:	3.524	1.939	1.939
VERTICAL SPREAD	:	2.822	2.822	1.932
EXTREME SPREAD	:	4.140	2.930	1.959
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348852

CENTERFIRE PATTERNS # 2

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.477

VS= 1.345

GS= 3.485

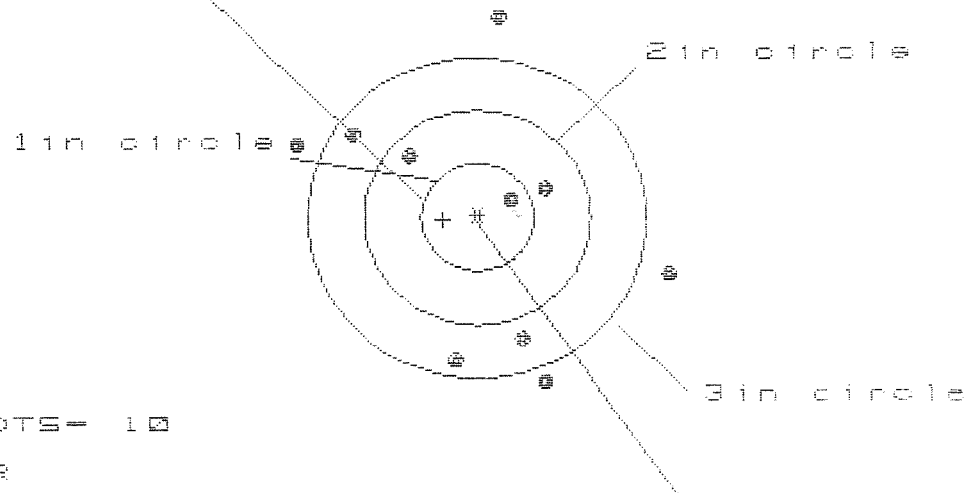
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.957	1.753	1.353
MINIMUM X	:	-1.520	-1.302	-1.083
MAXIMUM Y	:	.852	.799	.837
MINIMUM Y	:	-.493	-.546	-.508
CENTROID X	:	.507	.289	.070
CENTROID Y	:	-.304	-.251	-.289
FOR TO CENTROID in.	:	.591	.383	.297
MIN RADIUS	:	.157	.132	.300
MEAN RADIUS	:	1.143	1.017	.896
MAX RADIUS	:	2.016	1.779	1.469
HORIZONTAL SPREAD	:	3.477	3.055	2.436
VERTICAL SPREAD	:	1.345	1.345	1.345
EXTREME SPREAD	:	3.485	3.113	2.574
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08340852

CENTERFIRE PATTERNS # 3

POR



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.261

VS= 3.439

GS= 3.485

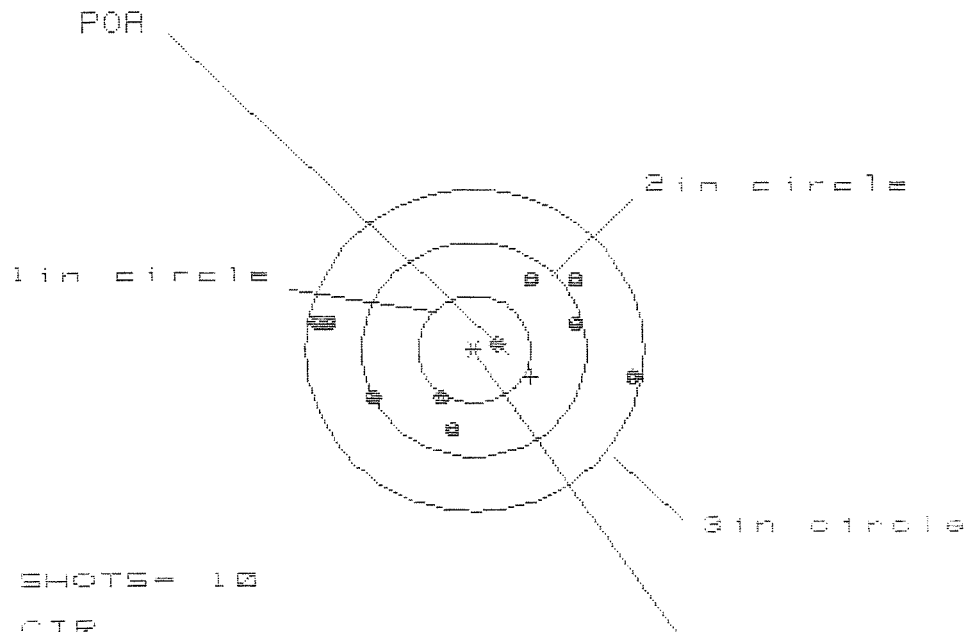
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.654	1.672	1.473
MINIMUM X	-1.607	-1.589	-1.329
MAXIMUM Y	1.894	.978	1.095
MINIMUM Y	-1.545	-1.334	-1.217
CENTROID X	.304	.286	.485
CENTROID Y	.026	-.185	-.301
POR TO CENTROID in.	.305	.341	.571
MIN RADIUS	.327	.499	.544
MEAN RADIUS	1.266	1.199	1.097
MAX RADIUS	1.901	1.843	1.722
HORIZONTAL SPREAD	3.261	3.261	2.802
VERTICAL SPREAD	3.439	2.312	2.312
EXTREME SPREAD	3.485	3.485	3.078
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C89408892

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.766

VS= 1.418

GS= 2.822

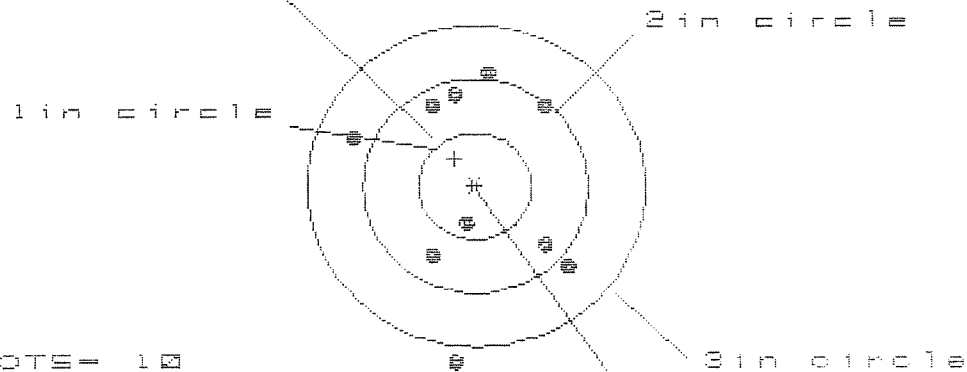
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.411	1.109	.959
MINIMUM X	:	-1.355	-1.198	-1.323
MAXIMUM Y	:	.635	.602	.631
MINIMUM Y	:	-.783	-.816	-.787
CENTROID X	:	-.504	-.661	-.511
CENTROID Y	:	.247	.280	.251
POA TO CENTROID in.	:	.561	.718	.569
MIN RADIUS	:	.237	.393	.244
MEAN RADIUS	:	.965	.917	.854
MAX RADIUS	:	1.441	1.221	1.341
HORIZONTAL SPREAD	:	2.766	2.307	2.282
VERTICAL SPREAD	:	1.418	1.418	1.418
EXTREME SPREAD	:	2.822	2.308	2.282
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08340892

CENTERFIRE PATTERNS # 5

POR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.926

VS= 2.694

GS= 2.710

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.857
MINIMUM X	-1.069
MAXIMUM Y	1.053
MINIMUM Y	-1.641
CENTROID X	.184
CENTROID Y	-.258
POR TO CENTROID in.	.316
MIN RADIUS	.329
MEAN RADIUS	.951
MAX RADIUS	1.652
HORIZONTAL SPREAD	1.926
VERTICAL SPREAD	2.694
EXTREME SPREAD	2.710
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348892
13 Dec 1989

CENTROIDAL DISTANCES

0 TO 1	.362724
1 TO 2	.210642
1 TO 3	.54904
1 TO 4	.500969
1 TO 5	.2502

3
104

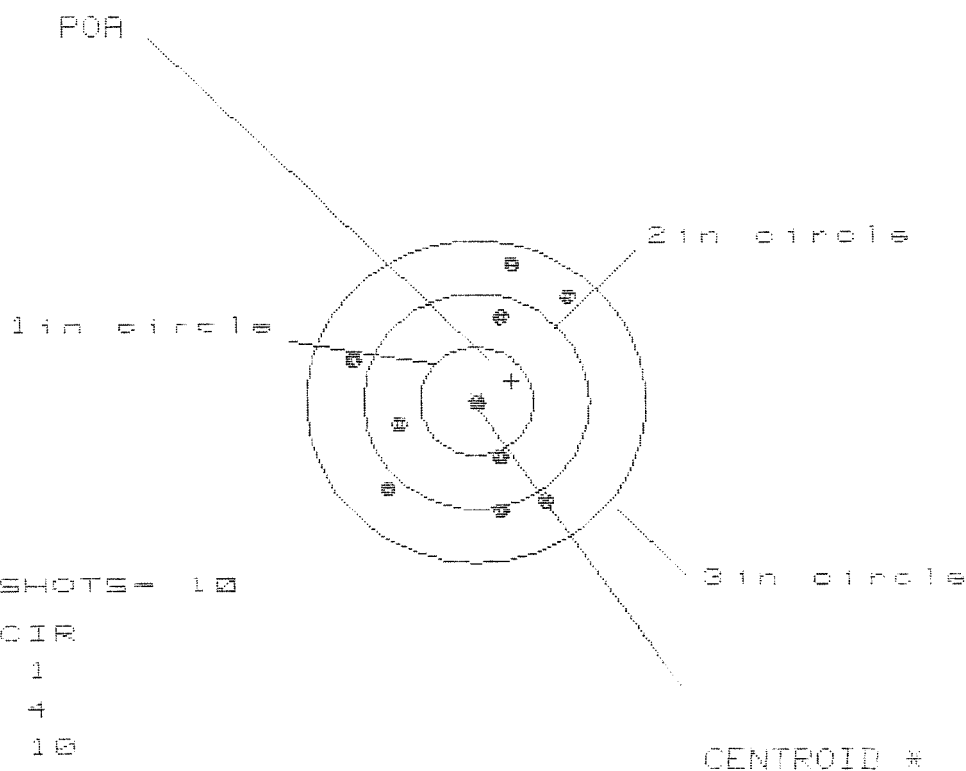
<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1236
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124106
THE AMR FOR THIS RIFLE IS: .936

13 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/083468892.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 1.875

VS = 2.322

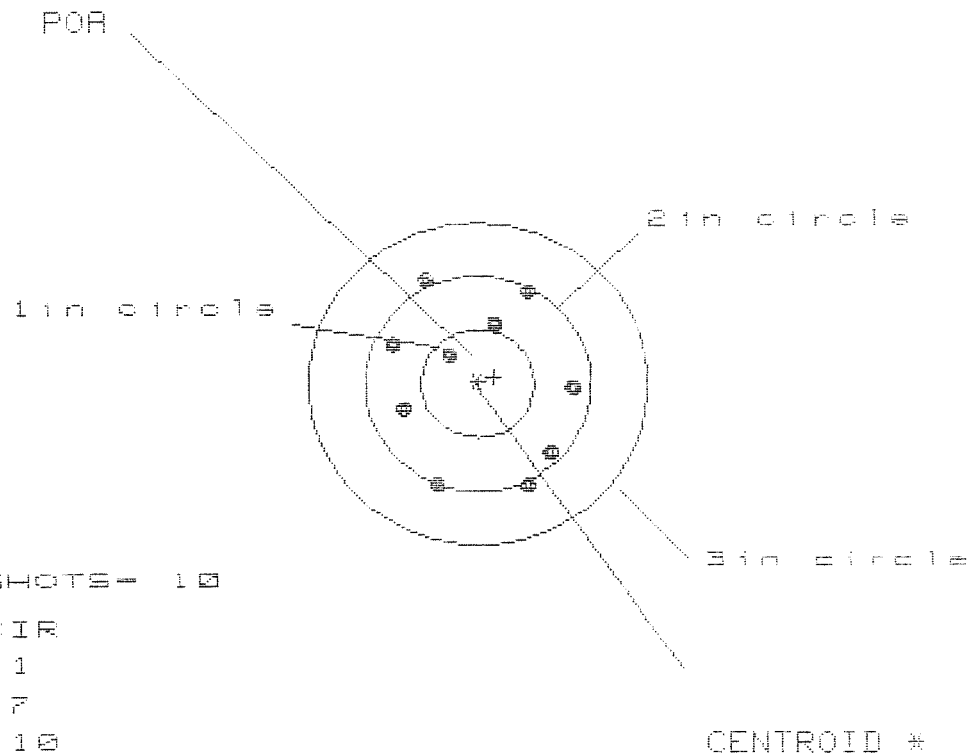
GS = 2.394

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.863	.842	.792
MINIMUM X	-1.072	-1.033	-.928
MAXIMUM Y	1.264	1.170	1.084
MINIMUM Y	-1.058	-.918	-.772
CENTROID X	-.312	-.351	-.456
CENTROID Y	-.185	-.325	-.471
POA TO CENTROID in.	.363	.478	.656
MIN RADIUS	.019	.137	.316
MEAN RADIUS	.918	.866	.784
MAX RADIUS	1.311	1.441	1.145
HORIZONTAL SPREAD	1.875	1.875	1.720
VERTICAL SPREAD	2.322	2.688	1.856
EXTREME SPREAD	2.394	2.394	2.146
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

13 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346882.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.667

VS= 1.951

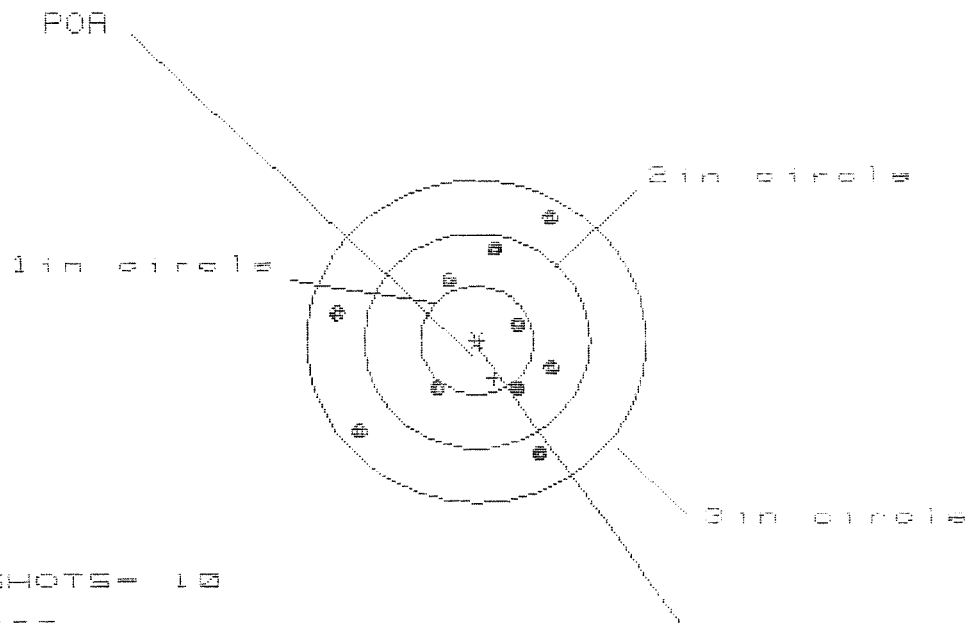
GS= 2.128

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.862	.810	.856
MINIMUM X	:	-.805	-.857	-.811
MAXIMUM Y	:	.965	.920	.813
MINIMUM Y	:	-.986	-.879	-.987
CENTROID X	:	-.141	-.089	-.135
CENTROID Y	:	-.062	-.169	-.061
POA TO CENTROID in.	:	.154	.191	.148
MIN RADIUS	:	.344	.456	.248
MEAN RADIUS	:	.840	.818	.785
MAX RADIUS	:	1.072	1.001	1.045
HORIZONTAL SPREAD	:	1.667	1.667	1.667
VERTICAL SPREAD	:	1.951	1.799	1.799
EXTREME SPREAD	:	2.128	1.962	1.962
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/063408892.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.894

VS= 2.171

GS= 2.578

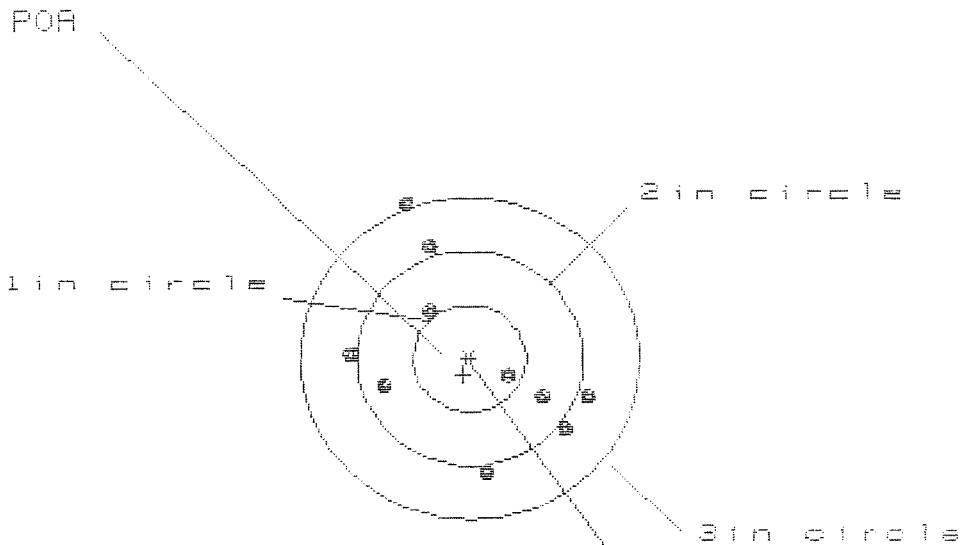
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.700	.583	.651
MINIMUM X	:	-1.194	-1.311	-1.242
MAXIMUM Y	:	1.133	1.044	.917
MINIMUM Y	:	-1.038	-1.127	-.996
CENTROID X	:	-.158	-.041	-.109
CENTROID Y	:	.342	.431	.300
POA TO CENTROID in.	:	.376	.433	.319
MIN RADIUS	:	.420	.284	.391
MEAN RADIUS	:	.887	.820	.773
MAX RADIUS	:	1.320	1.328	1.291
HORIZONTAL SPREAD	:	1.894	1.894	1.894
VERTICAL SPREAD	:	2.171	2.171	1.913
EXTREME SPREAD	:	2.578	2.224	2.224
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348882.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 0.030

VS = 2.530

GS = 0.630

CENTROID *

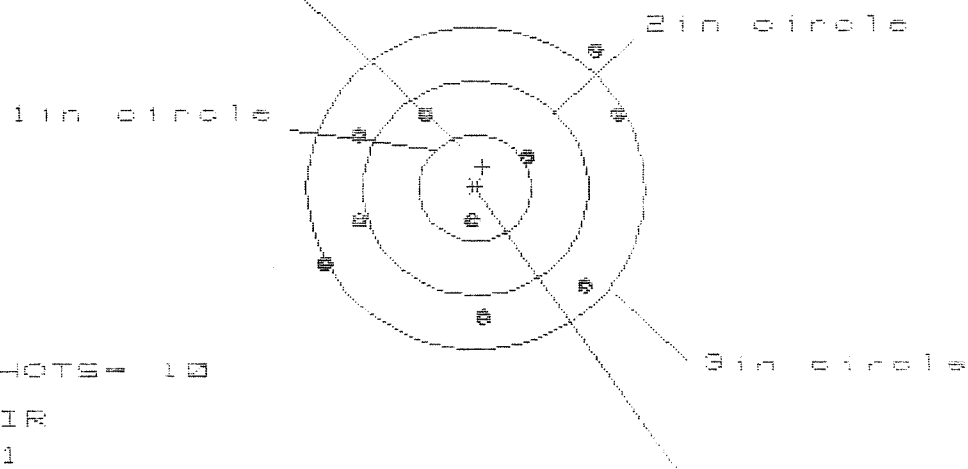
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.952	.966
MINIMUM X	:	-1.020	-1.078	-1.064
MAXIMUM Y	:	1.439	1.169	1.052
MINIMUM Y	:	-1.099	-.939	-.616
CENTROID X	:	.055	.113	.099
CENTROID Y	:	.156	-.004	.113
POR TO CENTROID in.	:	.165	.113	.150
MIN RADIUS	:	.424	.319	.385
MEAN RADIUS	:	.931	.843	.829
MAX RADIUS	:	1.530	1.240	1.125
HORIZONTAL SPREAD	:	2.030	2.030	2.030
VERTICAL SPREAD	:	2.538	2.108	1.668
EXTREME SPREAD	:	2.630	2.172	2.064
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/0683468892.1

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS = 2.527

VS = 2.475

GS = 3.140

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.232
MINIMUM X	-1.294
MAXIMUM Y	1.270
MINIMUM Y	-1.205
CENTROID X	-0.062
CENTROID Y	-0.195
FOR TO CENTROID in.	0.205
MIN RADIUS	0.282
MEAN RADIUS	1.104
MAX RADIUS	1.684
HORIZONTAL SPREAD	2.527
VERTICAL SPREAD	2.475
EXTREME SPREAD	3.140
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	9