

C6649106

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.

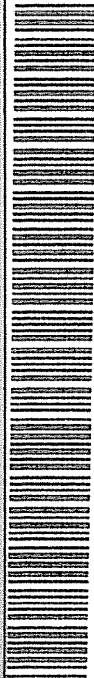
MODEL 700™ M24

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

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

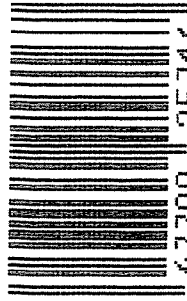
DU PONT

SERIAL NO. C6649106	ORDER NO. 5716
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5716 C6649106

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649106

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/2/91	KA
600	Proof		8/2/91	KA
607	Check Headspace		8/2/91	KA
610	Dis-assemble Gun		8/2/91	KA
612	Magnaflux Barrel Action	AUG 7 1991		KR
	Magnaflux Bolt	AUG 7 1991		KR
615	Rollmark Caliber	AUG 7 1991		LS
617	Drill and Tap Sight Holes	AUG 7 1991		LB
618	Polish Barrel	AUG 13 1991		WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		9/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/5/91	KA
	C) Inspect Ejector Hole for Chamfer		9/5/91	KA
	D) Oil Firing Pin Ass'y		9/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9-6-91	KA

op. #	BARBER M24 0064882	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/7/91	QH
	G) Safety Off Force	4	4	4			9/7/91	QH
	H) Trigger Pull Test & Retainability						9-6-91	QH
	I) Firing Pin Indent	.021	.022	.022			9-7-91	QH
	J) Assemble Stock						9/9/91	QH
	K) Assemble Swivel Studs						9-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/9/91	QH
	M) Iron Sight Alignment						9/9/91	QH
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	QH
	O) Attach Scope to Rifle						9/9/91	QH
	P) Detach & Attach Scope 20 Times						9/9/91	QH
640	Gallery Target & Test						9-10-91	AC
	A) Time						9-10-91	AC
	B) Malfunctions						9-10-91	AC
	C) Pierced Primers						9-10-91	AC
	D) Optical Clarity of Scope						9-10-91	AC
645	Inspect for Live Ammo						9-10-91	AC
655	Final Inspection							
	A) Headspace						9-13-91	D/H
	B) Trigger Pull	2.51	2.54	2.49	2.53	2.49	9-12-91	QH
	C) Function						9-13-91	D/H
660	Pack						9-17-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649106DATE 9-6-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.23	2.38	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.35	2.34	2.54	
PULL #3	2.62	2.36	2.30	2.49	
PULL #4	2.60	2.32	2.39	2.53	
PULL #5	2.65	2.30	2.45	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.30		
PULL #2	3.40	3.40		
PULL #3	3.40	3.45		
PULL #4	3.37	3.40		
PULL #5	3.39	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.27		4.40
PULL #2	4.43	4.37		4.32
PULL #3	4.29	4.38		4.36
PULL #4	4.26	4.38		4.35
PULL #5	4.29	4.39		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649106
10 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.554401
1 TO	2	.707008
1 TO	3	.216116
1 TO	4	.58845
1 TO	5	.893377

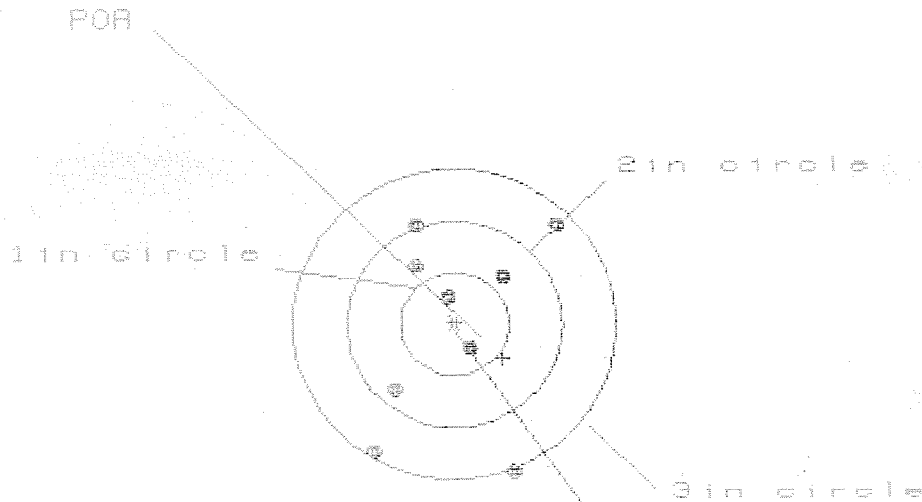
12
2 4 5 <----PDR

DATE FOR THIS RIFLE IS: -.2496
DATE FOR THIS RIFLE IS: -.0296
RADIUS FOR THIS RIFLE IS: .251349
1.785

3 of 531

FILE: \PATTERNING\CENTERFIRE_PATT\08649106

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 1.702

VS = 2.400

GS = 2.736

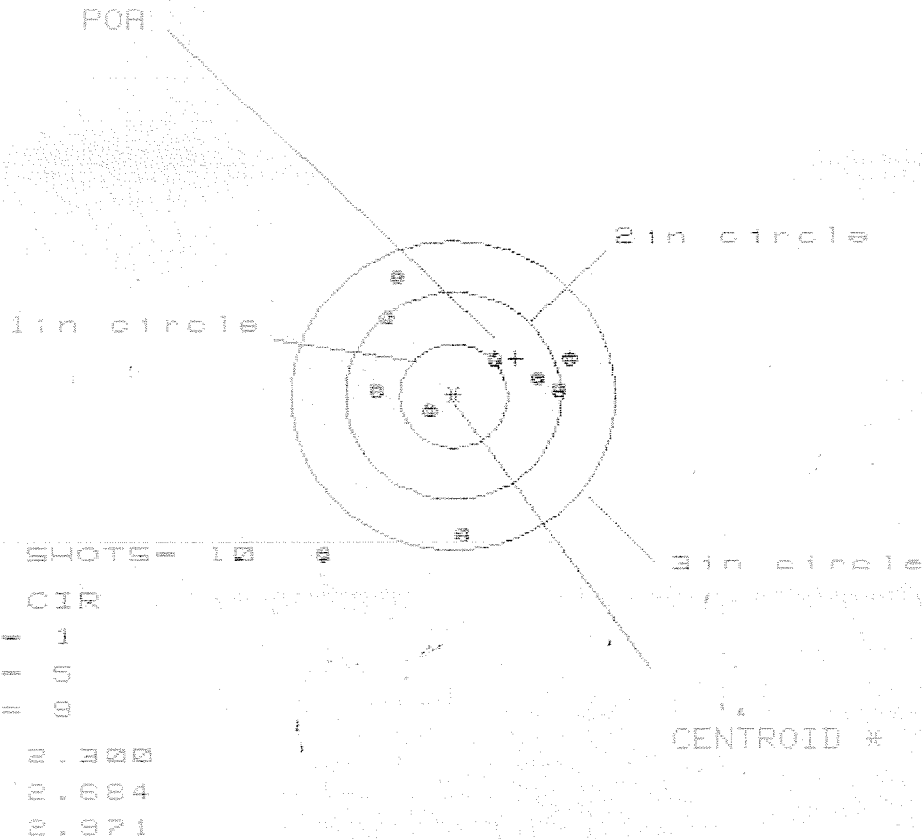
CENTROID +

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.959	1.020	.934
MINIMUM X	-.743	-.682	-.560
MAXIMUM Y	-.985	-.828	.657
MINIMUM Y	-1.415	-1.364	-.989
CENTROID X	-.444	-.505	-.419
CENTROID Y	.332	.489	.660
FOR TO CENTROID in.	.554	.703	.782
MIN RADIUS	.228	.080	.109
MEAN RADIUS	.825	.706	.587
MAX RADIUS	1.517	1.525	1.136
HORIZONTAL SPREAD	1.702	1.702	1.494
VERTICAL SPREAD	2.400	2.192	1.646
EXTREME SPREAD	2.736	2.736	2.186
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

10 Sep 1991

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CENTERFIRE PATTERNS # 2



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.120	.989	.960
MINIMUM X	-1.180	-.862	-.871
MAXIMUM Y	1.181	1.014	.821
MINIMUM Y	-1.503	-1.550	-.462
CENTROID X	-.579	-.448	-.439
CENTROID Y	-.362	-.195	-.002
POA TO CENTROID in.	.683	.488	.439
MIN RADIUS	.282	.313	.198
MEAN RADIUS	1.010	.880	.777
MAX RADIUS	1.911	1.551	1.024
HORIZONTAL SPREAD	2.300	1.851	1.851
VERTICAL SPREAD	2.684	2.564	1.282
EXTREME SPREAD	2.971	2.619	1.879
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

10 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8649186

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 2.022

VS = 2.115

GS = 2.125

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X	1.058	.587	.624
MINIMUM X	-.964	-.847	-.810
MAXIMUM Y	1.134	1.081	.608
MINIMUM Y	-.981	-1.034	-.899
CENTROID X	-.235	-.352	-.389
CENTROID Y	.387	.440	.305
POA TO CENTROID in.	.453	.564	.494
MIN RADIUS	.132	.116	.181
MEAN RADIUS	.713	.653	.590
MAX RADIUS	1.160	1.119	.908
HORIZONTAL SPREAD	2.022	1.434	1.434
VERTICAL SPREAD	2.115	2.115	1.507
EXTREME SPREAD	2.125	2.125	1.596
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.936

VS = 1.787

GS = 2.059

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.134

1.045

.840

MINIMUM X

-.802

-.795

-.664

MAXIMUM Y

.830

.724

.678

MINIMUM Y

-.957

-.618

-.663

CENTROID X

-.147

-.050

-.189

CENTROID Y

-.176

-.070

-.024

POA TO CENTROID in.

.230

.091

.190

MIN RADIUS

.036

.132

.121

MEAN RADIUS

.703

.648

.568

MAX RADIUS

1.248

1.106

.877

HORIZONTAL SPREAD

1.936

1.840

1.504

VERTICAL SPREAD

1.787

1.342

1.342

EXTREME SPREAD

2.059

1.848

1.504

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649186

CENTERFIRE PATTERNS

5

POA

2in circle

1in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.393

VS = 1.911

GS = 2.060

PATTERN

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	.754	.429	.426
MINIMUM X	-.639	-.555	-.558
MAXIMUM Y	1.044	1.140	1.067
MINIMUM Y	-.867	-.771	-.628
CENTROID X	.157	.073	.076
CENTROID Y	-.329	-.425	-.568
POA TO CENTROID in.	.365	.431	.573
MIN RADIUS	.171	.049	.094
MEAN RADIUS	.674	.598	.511
MAX RADIUS	1.147	1.140	1.082
HORIZONTAL SPREAD	1.393	.984	.984
VERTICAL SPREAD	1.911	1.911	1.695
EXTREME SPREAD	2.060	1.918	1.736
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	