C6649118

MODEL 700™ M24

Model SWS™

Action

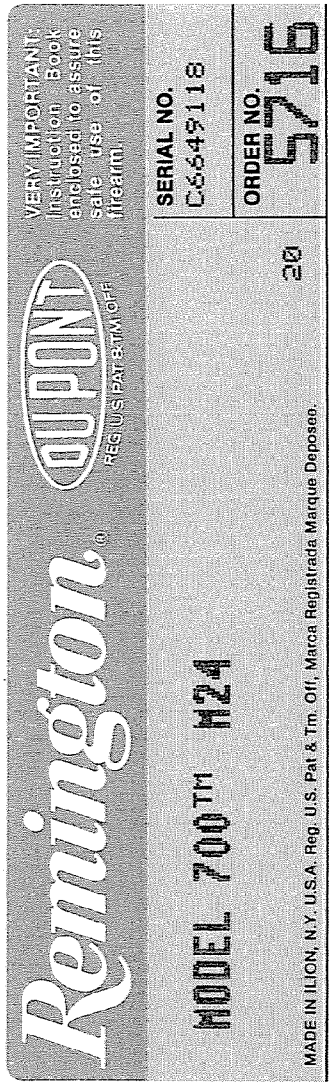
Barrel Length

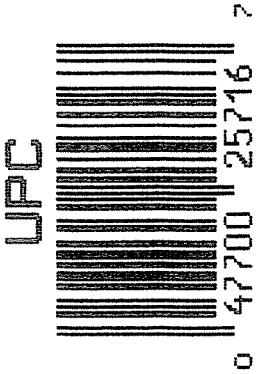
Capacity

Order No. 5716

*Includes 1 in chamber.

Remington


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm
MODEL 700™ M24
SERIAL NO.
C6649118
ORDER NO.
5715
20
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
5715 C6649118


UPC
0 47700 25716 7

M-24

No [redacted] Shim

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649118

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4 30 91	RW
600	Proof		4 30 91	RW
607	Check Headspace		4 30 91	RW
610	Dis-assemble Gun		4 30 91	RW
612	Magnaflux Barrel Action		5 6 91	KCR
	Magnaflux Bolt		5 6 91	KCR
615	Rollmark Caliber		5 6 91	GB
617	Drill and Tap Sight Holes		5 10 91	FB
618	Polish Barrel		5 10 91	WB
620	Apply Coatings (Barrel Action)		5-30-91	
	Apply Coating (Bolt)		5-30-91	
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/91	RW

QUALITY AUDIT

op. #	BARBER - M24 0065020	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-31-91	DH
	G) Safety Off Force	2	2	2			5-31-91	DH
	H) Trigger Pull Test & Retainability						6/3/1991	DH
	I) Firing Pin Indent	.020	.021	.020			5-31-91	DH
	J) Assemble Stock						6/3/91	Rw
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/3/91	Rw
	M) Iron Sight Alignment						6/3/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	Rw
	O) Attach Scope to Rifle						6/3/91	Rw
	P) Detach & Attach Scope 20 Times						6/3/91	Rw
640	Gallery Target & Test						6-4-91	DH
	A) Time						6-4-91	DH
	B) Malfunctions						6-4-91	DH
	C) Pierced Primers						6-4-91	DH
	D) Optical Clearity of Scope						6-4-91	DH
645	Inspect for Live Ammo						6-4-91	DH
655	Final Inspection A) Headspace						6-8-91	DH
	B) Trigger Pull	2-53	2-43	2-42	2-34	2-56	6-8-91	DH
	C) Function						6-8-91	DH
660	Pack						6-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO C6649118
DATE 5/31/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.39	2.42	2.55	MIN. SETTING,
PULL #2	2.15	2.39	2.40	2.43	NO AVG. OF 5
PULL #3	2.43	2.35	2.35	2.42	READINGS ACCEPT-
PULL #4	2.39	2.40	2.35	2.34	ABLE LESS THAN 2#
PULL #5	2.40	2.37	2.39	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.46		
PULL #2	3.36	3.41		
PULL #3	3.33	3.40		
PULL #4	3.41	3.45		
PULL #5	3.45	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.16		4.19
PULL #2	4.15	4.19		4.17
PULL #3	4.24	4.24		4.21
PULL #4	4.22	4.25		4.26
PULL #5	4.25	4.23		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649118
4 Jun 1991

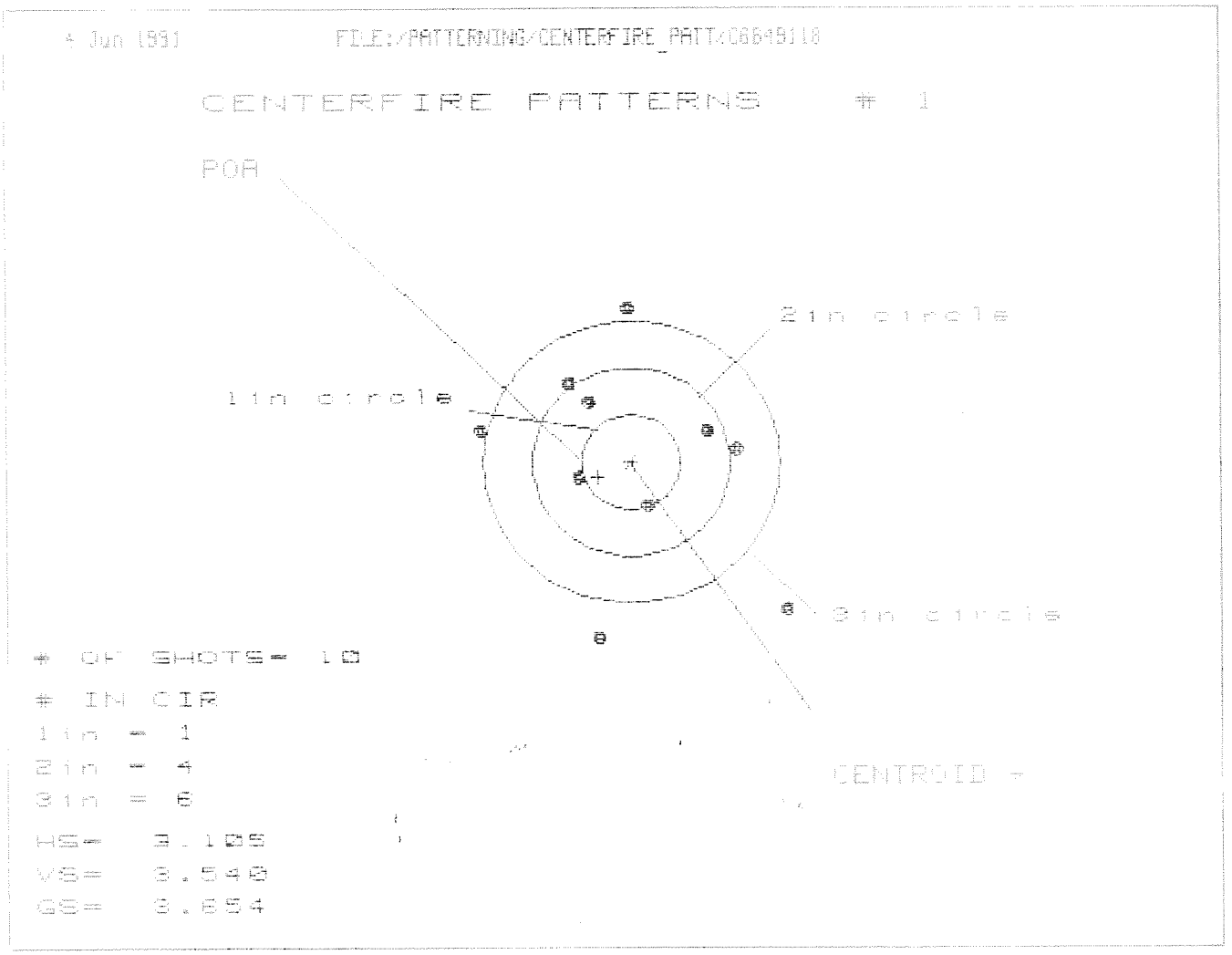
CENTROIDAL DISTANCES

0	TO	1	.369444
1	TO	2	.641723
1	TO	3	.413048
1	TO	4	.499144
1	TO	5	.0636553

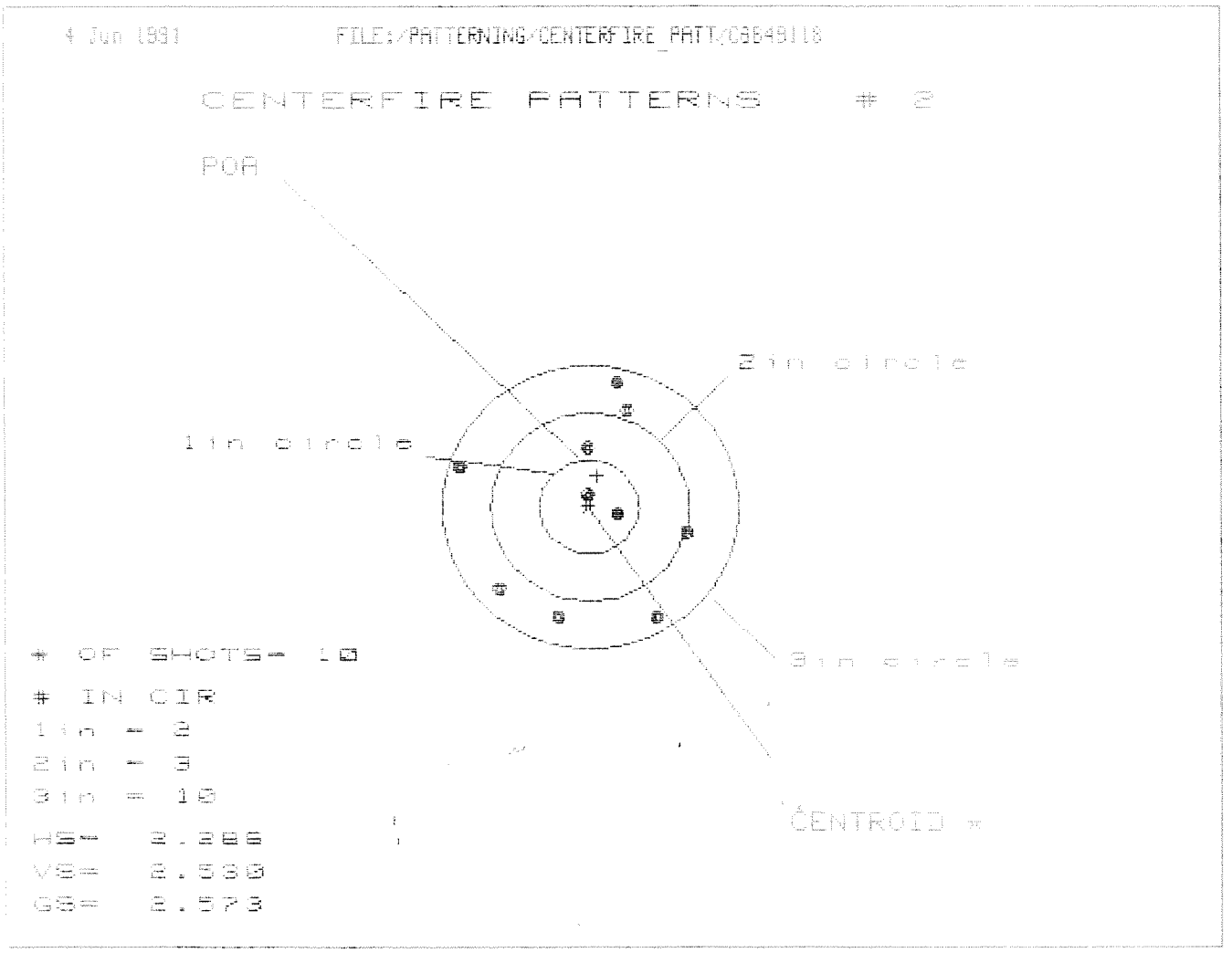
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .152
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1814
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .236064

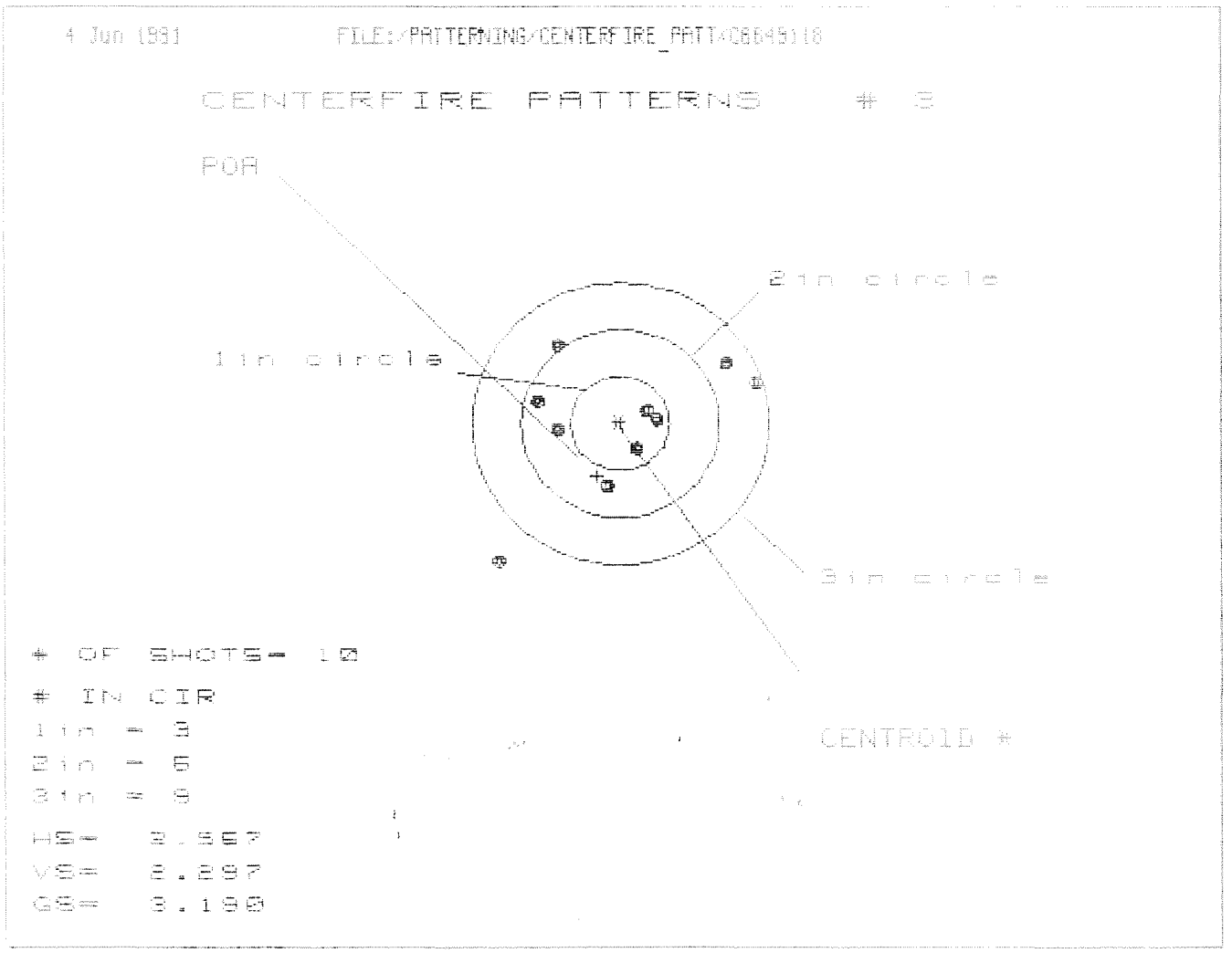
THE AMR FOR THIS RIFLE IS: 1.079



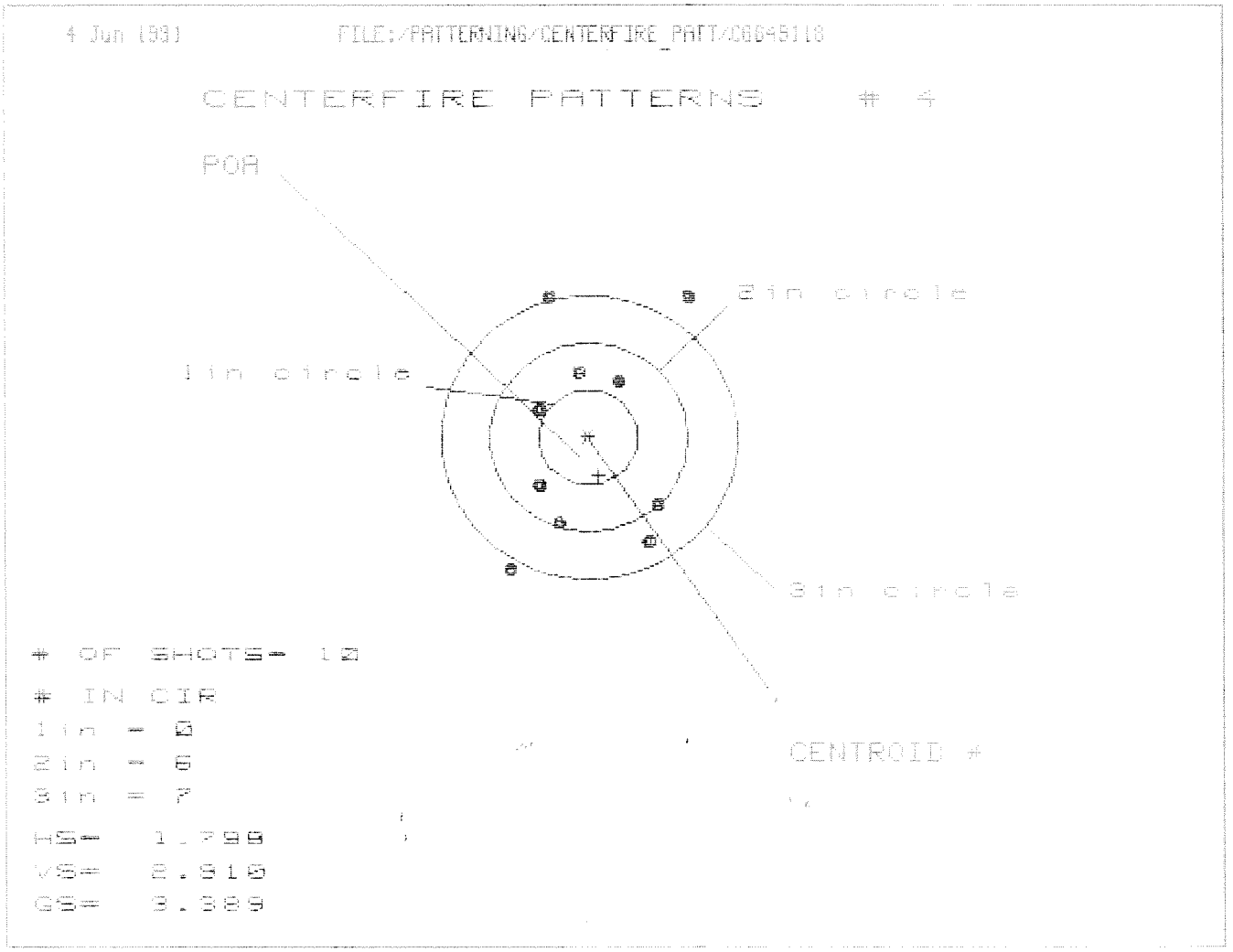
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.564	1.209	1.191
MINIMUM X	:	-1.541	-1.367	-1.385
MAXIMUM Y	:	1.684	1.509	1.255
MINIMUM Y	:	-1.856	-2.051	-.847
CENTROID X	:	.338	.159	.178
CENTROID Y	:	.160	.335	.509
POA TO CENTROID in.	:	.369	.371	.615
MIN RADIUS	:	.445	.498	.316
MEAN RADIUS	:	1.205	1.062	.914
MAX RADIUS	:	2.217	2.036	1.987
HORIZONTAL SPREAD	:	3.105	2.576	2.576
VERTICAL SPREAD	:	3.540	3.540	2.102
EXTREME SPREAD	:	3.654	3.548	2.583
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	



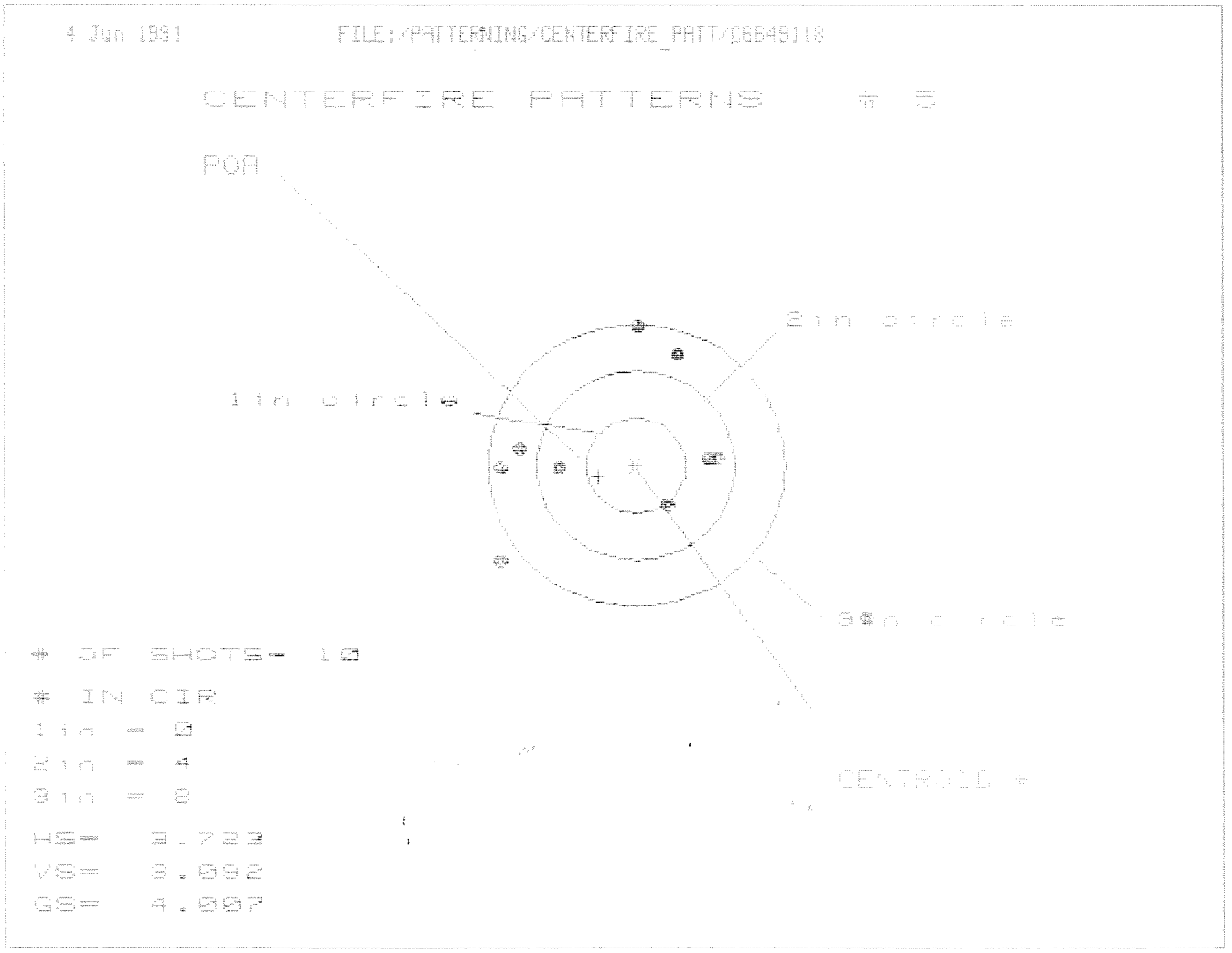
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.008	1.085	1.125
MINIMUM X	:	-1.278	-1.201	-1.161
MAXIMUM Y	:	1.324	1.190	1.061
MINIMUM Y	:	-1.206	-1.332	-1.183
CENTROID X	:	-.079	-.156	-.195
CENTROID Y	:	-.332	-.198	-.347
POA TO CENTROID in.	:	.341	.252	.396
MIN RADIUS	:	.186	.053	.205
MEAN RADIUS	:	.981	.914	.895
MAX RADIUS	:	1.391	1.346	1.283
HORIZONTAL SPREAD	:	2.286	2.286	2.286
VERTICAL SPREAD	:	2.500	2.522	2.244
EXTREME SPREAD	:	2.573	2.573	2.386
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	1.208	1.099
MINIMUM X	:	-1.223	-.951	-.800
MAXIMUM Y	:	.852	.691	.727
MINIMUM Y	:	-1.445	-.794	-.758
CENTROID X	:	.290	.366	.215
CENTROID Y	:	.560	.721	.685
POA TO CENTROID in.	:	.606	.808	.718
MIN RADIUS	:	.343	.153	.308
MEAN RADIUS	:	.876	.746	.686
MAX RADIUS	:	1.893	1.242	1.221
HORIZONTAL SPREAD	:	2.567	2.159	1.899
VERTICAL SPREAD	:	2.297	1.485	1.485
EXTREME SPREAD	:	3.190	2.172	1.950
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	.775	.692
MINIMUM X	:	-.777	-.663	-.497
MAXIMUM Y	:	1.530	1.696	1.545
MINIMUM Y	:	-1.380	-1.214	-1.081
CENTROID X	:	-.103	-.217	-.134
CENTROID Y	:	.403	.237	.388
POA TO CENTROID in.	:	.416	.321	.411
MIN RADIUS	:	.522	.538	.502
MEAN RADIUS	:	1.070	.969	.911
MAX RADIUS	:	1.809	1.720	1.588
HORIZONTAL SPREAD	:	1.798	1.438	1.189
VERTICAL SPREAD	:	2.910	2.910	2.626
EXTREME SPREAD	:	3.389	2.935	2.800
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.313	1.049	.405
MINIMUM X	:	-1.413	-1.153	-1.222
MAXIMUM Y	:	1.465	1.284	1.139
MINIMUM Y	:	-1.627	-1.159	-.718
CENTROID X	:	.379	.122	.267
CENTROID Y	:	.116	.297	.442
POA TO CENTROID in.	:	.397	.321	.516
MIN RADIUS	:	.521	.572	.762
MEAN RADIUS	:	1.260	1.069	.990
MAX RADIUS	:	2.028	1.635	1.256
HORIZONTAL SPREAD	:	3.723	2.202	2.126
VERTICAL SPREAD	:	3.092	2.442	1.857
EXTREME SPREAD	:	4.007	2.872	2.141
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	