

C6649132

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

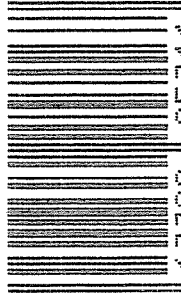
Order No. 5715

*Includes 1 in chamber.

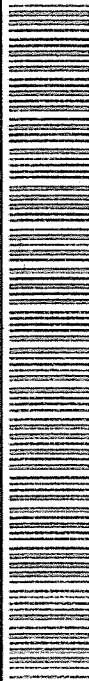


Remington REG. U.S. PAT. & TM. OFF.		DUPONT REG. U.S. PAT. & TM. OFF.	
MODEL 700™ M24		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		SERIAL NO. C6649132	ORDER NO. 5716

UPC



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5716 C6649132

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649132

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KL
600	Proof		6/26/91	KL
607	Check Headspace		6/26/91	KL
610	Dis-assemble Gun		6/26/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		7-91	1/5
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KL
	C) Inspect Ejector Hole for Chamfer		8/8/91	KL
	D) Oil Firing Pin Ass'y		8/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	DH

op. #	BARBER M24 0065178	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	8	8			8-10-91	DH
	G) Safety Off Force	3	3	3			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	DH
	I) Firing Pin Indent	.021	.022	.020			8-10-91	DH
	J) Assemble Stock						8-12-91	KP
	K) Assemble Swivel Studs						8-14-91	DH
	L) Attach Front and Rear Sight Assemblies						8-12-91	KP
	M) Iron Sight Alignment						8-12-91	KP
	N) Detach Front & Rear Sights & place in numbered container						8-12-91	KP
	O) Attach Scope to Rifle						8-12-91	KP
	P) Detach & Attach Scope 20 Times						8-12-91	KP
640	Gallery Target & Test						8-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-13-91	NF
655	Final Inspection							
	A) Headspace						8-14-91	DH
	B) Trigger Pull	2.65	2.70	2.41	2.33	2.33	8-14-91	JH
	C) Function						8-14-91	DH
660	Pack						8-17-91	DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06640132
21 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0230868
1 TO	2	.241853
1 TO	3	.231041
1 TO	4	.0606383
1 TO	5	.147872

-----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0584
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0496
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0711261
THE AMR FOR THIS RIFLE IS: .8484

13 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649132

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

CENTROID +

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 0.190

VS= 0.258

GS= 0.510

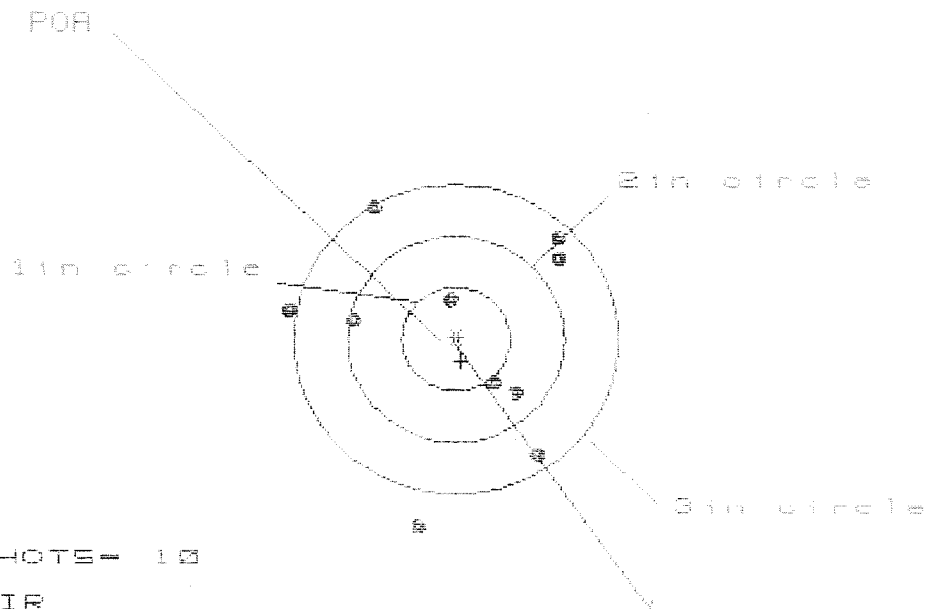
PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.044	1.065	.945
MINIMUM X	-1.088	-1.067	-1.187
MAXIMUM Y	.677	.582	.559
MINIMUM Y	-1.581	-.613	-.556
CENTROID X	-.007	-.036	.092
CENTROID Y	-.022	.153	.096
FOR TO CENTROID in.	.023	.156	.133
MIN RADIUS	.208	.371	.283
MEAN RADIUS	.815	.730	.667
MAX RADIUS	1.592	1.102	1.207
HORIZONTAL SPREAD	2.132	2.132	2.132
VERTICAL SPREAD	2.258	1.115	1.115
EXTREME SPREAD	2.510	2.176	2.176
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.521

VS = 3.027

GS = 3.057

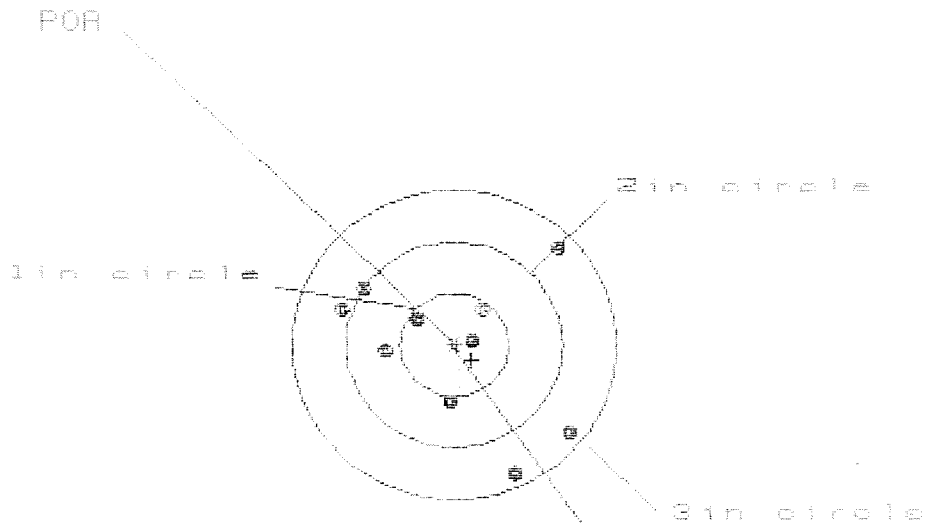
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.976	.939	.748
MINIMUM X	-1.555	-1.592	-1.147
MAXIMUM Y	1.256	1.059	1.070
MINIMUM Y	-1.771	-1.272	-1.261
CENTROID X	-.050	-.013	.186
CENTROID Y	.216	.413	.482
POA TO CENTROID in.	.232	.414	.446
MIN RADIUS	.371	.195	.347
MEAN RADIUS	1.136	1.042	.960
MAX RADIUS	1.802	1.594	1.461
HORIZONTAL SPREAD	2.531	2.531	1.887
VERTICAL SPREAD	3.027	2.331	2.331
EXTREME SPREAD	3.057	2.802	2.802
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =			8

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 10

HS = 2.113

VS = 2.212

GS = 2.424

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.029	1.132	1.216
MINIMUM X	-1.004	-0.981	-0.897
MAXIMUM Y	.994	.696	.558
MINIMUM Y	-1.218	-1.108	-0.843
CENTROID X	-.159	-.262	-.346
CENTROID Y	.152	.042	.180
POR TO CENTROID in.	.220	.266	.390
MIN RADIUS	.163	.312	.270
MEAN RADIUS	.846	.790	.699
MAX RADIUS	1.359	1.334	1.480
HORIZONTAL SPREAD	2.113	2.113	2.113
VERTICAL SPREAD	2.212	1.804	1.401
EXTREME SPREAD	2.424	2.424	2.424
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

23 Aug 1991

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CENTERFIRE PATTERNS

4

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.360

VS= 1.391

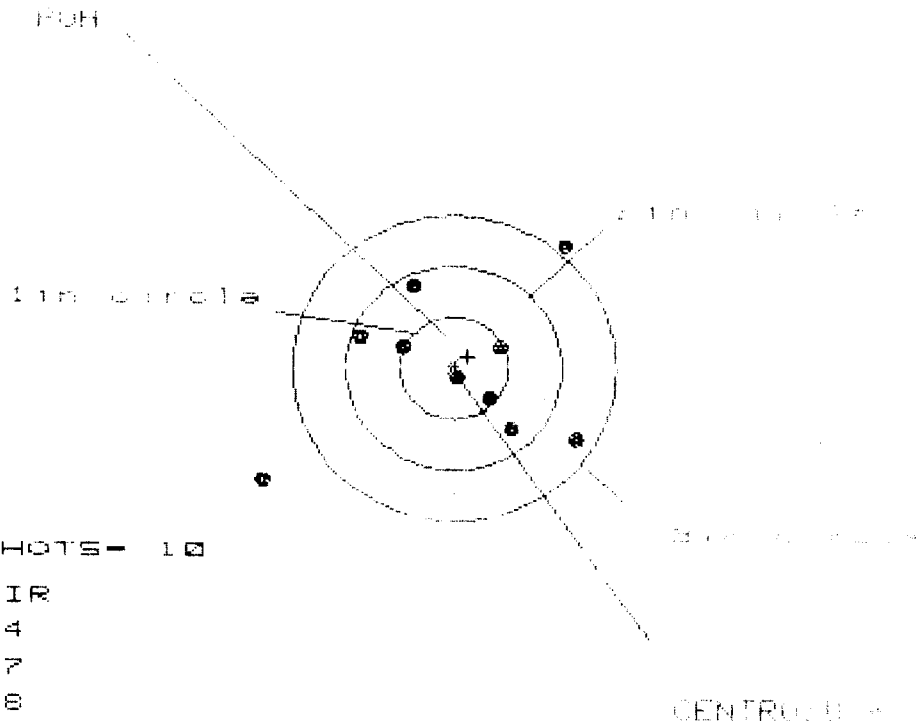
GS= 1.689

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.564	.386	.412
MINIMUM X	-1.056	-.575	-.549
MAXIMUM Y	.832	.817	.598
MINIMUM Y	-.559	-.574	-.472
CENTROID X	.052	.170	.144
CENTROID Y	-.036	-.021	-.123
POB TO CENTROID in.	.064	.171	.189
MIN RADIUS	.217	.143	.140
MEAN RADIUS	.548	.466	.412
MAX RADIUS	1.066	.842	.724
HORIZONTAL SPREAD	1.560	.961	.961
VERTICAL SPREAD	1.391	1.391	1.070
EXTREME SPREAD	1.689	1.595	1.176
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE: PATTERNING CENTERFIRE_PATT.C01.M24

CENTERFIRE PATTERNING



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

RS- 2.855

RS= 2.288

RS= 3.601

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.095	1.900	1.003
MINIMUM X	-1.760	-1.023	-1.920
MAXIMUM Y	1.206	1.066	1.095
MINIMUM Y	-1.090	-1.872	-1.716
CENTROID X	-1.128	1.043	1.135
CENTROID Y	-1.107	1.013	-1.120
POH TO CENTROID in.	1.167	1.069	1.123
MIN RADIUS	1.699	1.230	1.130
MEAN RADIUS	1.897	1.762	1.681
MAX RADIUS	2.065	1.365	1.139
ALPHABETIC SPREAD	2.855	1.923	1.929
NUMERICAL SPREAD	2.288	1.938	1.511
ALPHA SPREAD	3.601	2.209	2.289
DIFF IN ONE INCH CIRCLE	=	4	
DIFF IN TWO INCH CIRCLE	=	7	
DIFF IN THREE INCH CIRCLE	=	8	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649132

DATE 8-10-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.50	2.31	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.41	2.23	2.70	
PULL #3	2.39	2.34	2.19	2.41	
PULL #4	2.36	2.39	2.22	2.33	
PULL #5	2.31	2.28	2.22	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.52		
PULL #2	3.24	3.30		
PULL #3	3.34	3.20		
PULL #4	3.01	3.44		
PULL #5	3.37	3.31		
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	4.29		4.38
PULL #2	4.14	4.35		4.26
PULL #3	4.25	4.03		4.39
PULL #4	4.11	4.31		4.28
PULL #5	4.20	4.29		4.32
TOTAL				
AVG.				