C6649141

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

BARBER - M24 0065274

BARBER - M24 0065313

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Remington®

DU PONT
REG. U.S. PAT. & TM. OFF.

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

MODEL 700TM M24

SERIAL NO. C6649141

ORDER NO. 5716

20

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

5716 C6649141

UPC

0 47700 25716 7

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M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649141

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		4/26/91	KA
607	Check Headspace		4/26/91	KA
610	Dis-assemble Gun		4/26/91	KA
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	EB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/91	KA
	C) Inspect Ejector Hole for Chamfer		8/13/91	KA
	D) Oil Firing Pin Ass'y		8/13/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/14/91	WB

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op. #	BARBER M24 0065277	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-14-91	[illegible]
	G) Safety Off Force	3	3	3			8-14-91	[illegible]
	H) Trigger Pull Test & Retainability						8/14/91	WB
	I) Firing Pin Indent	.021	.0205	.021			8-14-91	[illegible]
	J) Assemble Stock						8/14/91	KT
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/14/91	KT
	M) Iron Sight Alignment						8/14/91	KT
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	KT
	O) Attach Scope to Rifle						8/14/91	KT
	P) Detach & Attach Scope 20 Times						8/14/91	KT
640	Gallery Target & Test						8-15-91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clearity of Scope							KT
645	Inspect for Live Ammo						8/15/91	KT
655	Final Inspection A) Headspace						8-17-91	DH
	B) Trigger Pull	2.45	2.41	2.45	2.43	2.43	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-19-91	[illegible]

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649141
23 Aug 1991

CENTROIDAL DISTANCES

0	TO	1	.277332
1	TO	2	.271065
1	TO	3	.19461
1	TO	4	.0852115
1	TO	5	.274847

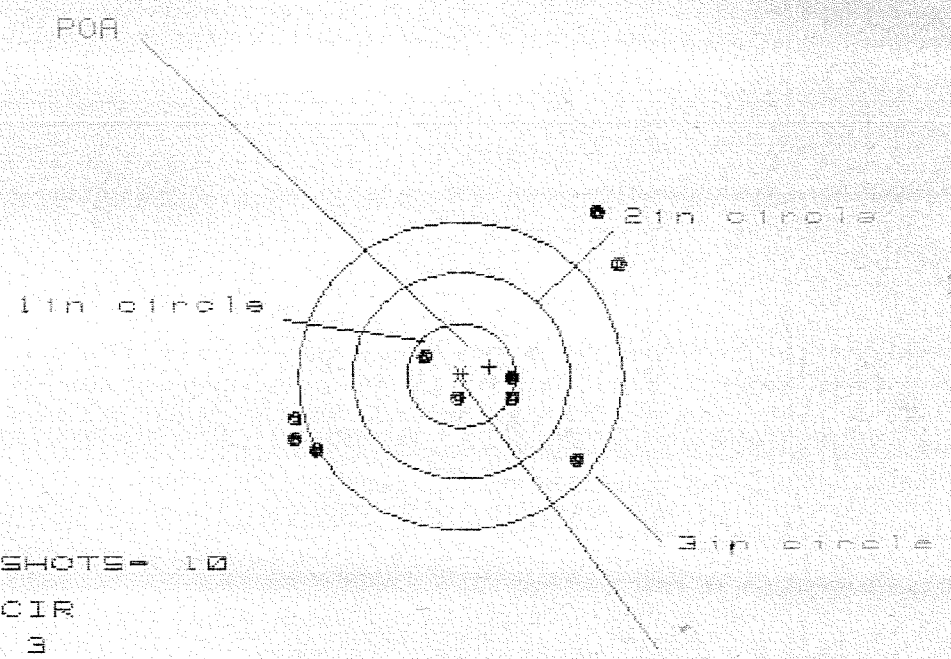
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1196
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .121687

THE AMR FOR THIS RIFLE IS: .8454

23 Aug 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C0849141

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 5

HS= 3.083

VS= 2.423

GS= 3.492

PATTERN #	:	1	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.498	1.635	1.445
MINIMUM X	:	-1.585	-1.448	-1.243
MAXIMUM Y	:	1.600	1.288	.483
MINIMUM Y	:	-.823	-.645	-.484
CENTROID X	:	-.263	-.400	-.605
CENTROID Y	:	-.088	-.266	-.427
POA TO CENTROID in.	:	.278	.480	.740
MIN RADIUS	:	.201	.152	.381
MEAN RADIUS	:	1.158	1.054	.954
MAX RADIUS	:	2.019	2.081	1.524
HORIZONTAL SPREAD	:	3.083	3.083	2.688
VERTICAL SPREAD	:	2.423	1.933	.967
EXTREME SPREAD	:	3.492	3.443	2.720

NUMBER IN ONE INCH CIRCLE = 3

NUMBER IN TWO INCH CIRCLE = 4

NUMBER IN THREE INCH CIRCLE = 5

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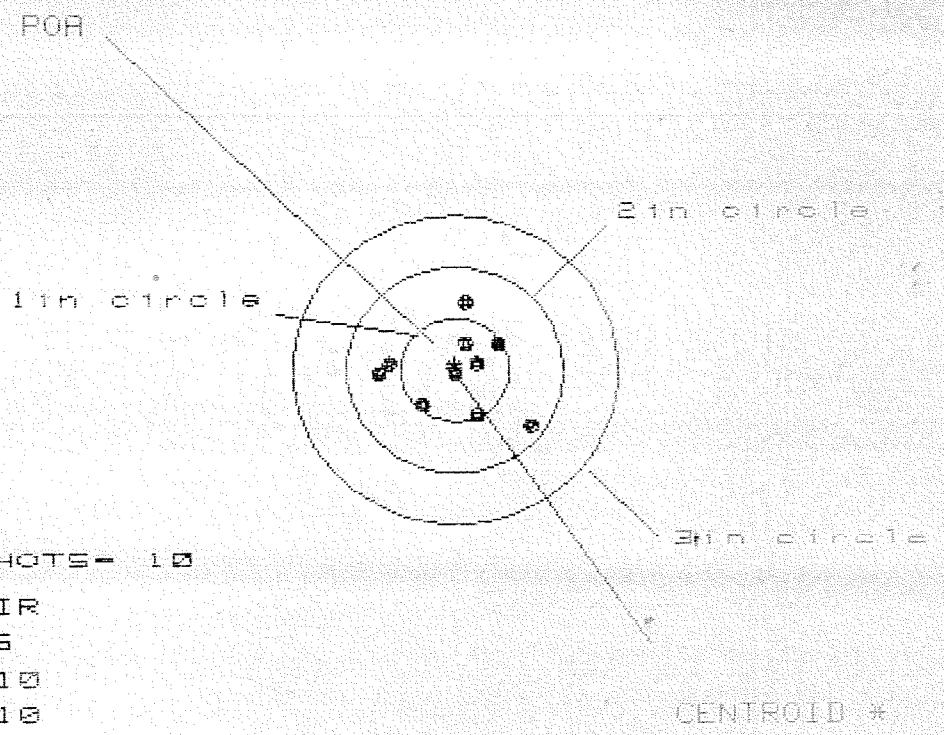
CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 5
2in = 10
3in = 10

HS= 1.442
VS= 1.216
GS= 1.524

PATTERN #	:	2	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.693	.480	.396
MINIMUM X	:	-.749	-.672	-.605
MAXIMUM Y	:	.686	.627	.615
MINIMUM Y	:	-.530	-.513	-.525
CENTROID X	:	.007	-.070	.014
CENTROID Y	:	-.064	-.005	.007
POA TO CENTROID in.	:	.064	.070	.016
MIN RADIUS	:	.021	.083	.079
MEAN RADIUS	:	.489	.451	.406
MAX RADIUS	:	.873	.679	.621
HORIZONTAL SPREAD	:	1.442	1.152	1.001
VERTICAL SPREAD	:	1.216	1.140	1.140
EXTREME SPREAD	:	1.524	1.181	1.147

NUMBER IN ONE INCH CIRCLE = 5
NUMBER IN TWO INCH CIRCLE = 10
NUMBER IN THREE INCH CIRCLE = 10

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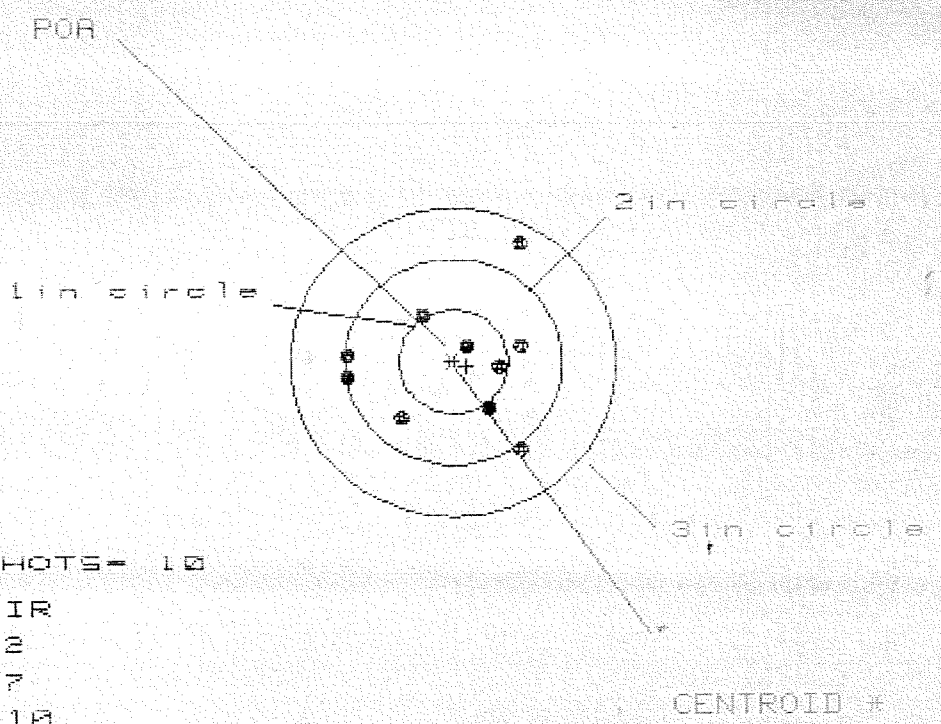
CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR	
1in =	2
2in =	7
3in =	10
HS=	1.682
VS=	2.062
GS=	2.064

PATTERN # :	3		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	.655	.719	.774
MINIMUM X :	-1.027	-.963	-.873
MAXIMUM Y :	1.196	.555	.464
MINIMUM Y :	-.866	-.734	-.535
CENTROID X :	-.120	-.184	-.274
CENTROID Y :	.044	-.089	.002
POA TO CENTROID in.:	.128	.205	.274
MIN RADIUS :	.198	.345	.323
MEAN RADIUS :	.748	.689	.642
MAX RADIUS :	1.327	1.027	.877
HORIZONTAL SPREAD :	1.682	1.682	1.647
VERTICAL SPREAD :	2.062	1.289	.999
EXTREME SPREAD :	2.064	1.913	1.651

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 10

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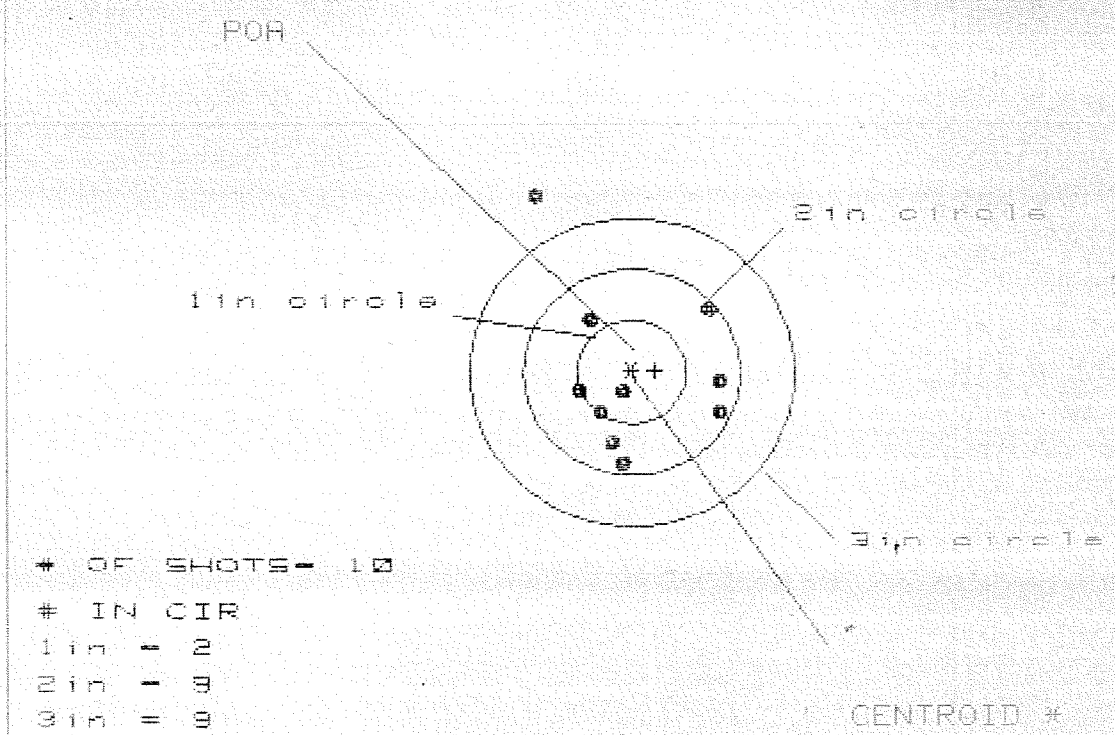
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 2
2in = 8
3in = 9

HS= 1.690
VS= 2.577
GS= 2.692

PATTERN #	:	4	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.844	.750	.831
MINIMUM X	:	-.846	-.542	-.461
MAXIMUM Y	:	1.670	.829	.803
MINIMUM Y	:	-.907	-.722	-.618
CENTROID X	:	-.213	-.119	-.200
CENTROID Y	:	-.019	-.204	-.308
POA TO CENTROID in.	:	.213	.236	.367
MIN RADIUS	:	.209	.197	.158
MEAN RADIUS	:	.804	.655	.572
MAX RADIUS	:	1.872	1.054	.899
HORIZONTAL SPREAD	:	1.690	1.292	1.292
VERTICAL SPREAD	:	2.577	1.551	1.421
EXTREME SPREAD	:	2.692	1.751	1.467
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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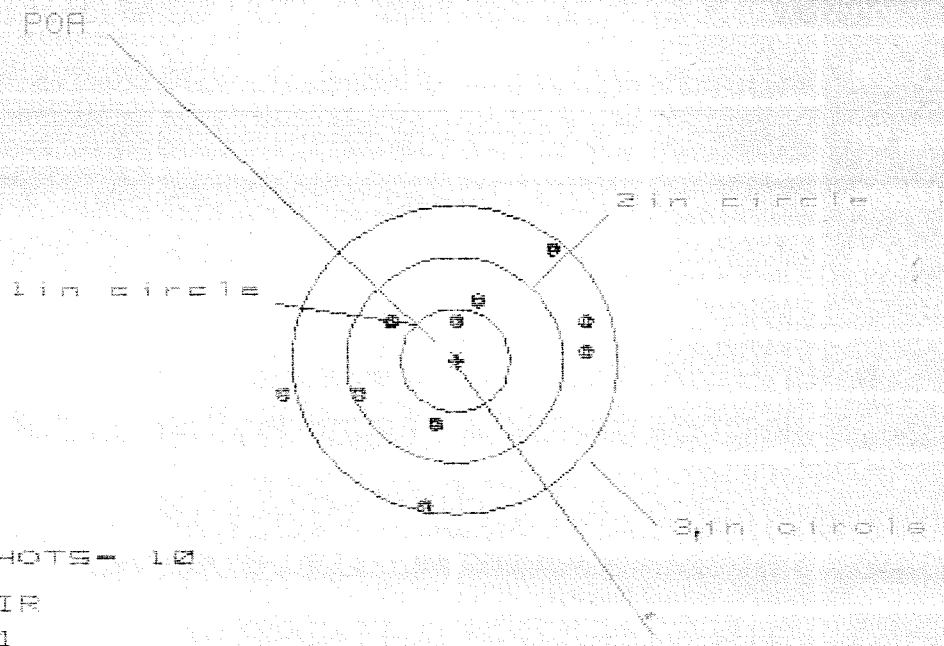
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 9

HS= 2.791
VS= 2.574
GS= 2.865

PATTERN #	:	5	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	1.068	1.013
MINIMUM X	:	-1.550	-1.106	-1.161
MAXIMUM Y	:	1.109	1.075	.887
MINIMUM Y	:	-1.465	-1.499	-.858
CENTROID X	:	-.009	.164	.219
CENTROID Y	:	.017	.051	.239
POA TO CENTROID in.	:	.019	.171	.324
MIN RADIUS	:	.351	.378	.294
MEAN RADIUS	:	1.028	.961	.851
MAX RADIUS	:	1.580	1.563	1.295
HORIZONTAL SPREAD	:	2.791	2.174	2.174
VERTICAL SPREAD	:	2.574	2.574	1.745
EXTREME SPREAD	:	2.865	2.839	2.368

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 9

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649141
DATE 8/14/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.28	2.44	2.45	MIN. SETTING,
PULL #2	2.34	2.25	2.35	2.41	NO AVG. OF 5
PULL #3	2.25	2.28	2.34	2.45	READINGS ACCEPT-
PULL #4	2.30	2.27	2.37	2.43	ABLE LESS THAN 2#
PULL #5	2.32	2.25	2.46	2.43	
TOTAL	11.53	11.33	11.96		
AVG.	2.31	2.27	2.39		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.19		
PULL #2	3.16	3.21		
PULL #3	3.06	3.13		
PULL #4	3.09	3.11		
PULL #5	3.14	3.11		
TOTAL	15.66	15.75		
AVG.	3.13	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.17		4.22
PULL #2	4.09	4.20		4.14
PULL #3	4.11	4.14		4.19
PULL #4	4.15	4.18		4.19
PULL #5	4.08	4.15		3.90
TOTAL	20.65	20.84		20.64
AVG.	4.13	4.17		4.13

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