

C6549246

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700™ M24

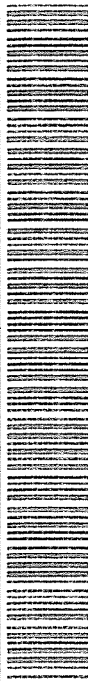
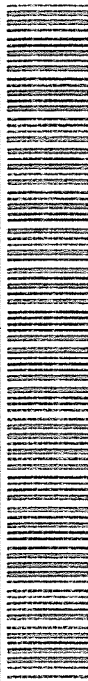
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

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

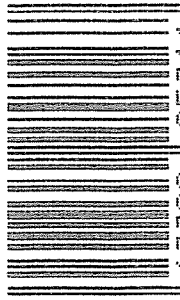
SERIAL NO.
C6649246

ORDER NO.
5716

5716 C6649246

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649246

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	EB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/26/91	JU

op. #	NAME BARBER M24 0066890	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5 1/2			8/26/91	DH
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			8/26/91	DH
	H) Trigger Pull Test & Retainability						8/26/91	JU
	I) Firing Pin Indent	.021	.022	.022			8/26/91	DH
	J) Assemble Stock							
	K) Assemble Swivel Studs						8-28-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/17/91	RW
	M) Iron Sight Alignment						9/17/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/17/91	RW
	O) Attach Scope to Rifle						9/17/91	RW
	P) Detach & Attach Scope 20 Times						9/17/91	RW
640	Gallery Target & Test						9-17-91	AC
	A) Time						9-17-91	AC
	B) Malfunctions						9-17-91	AC
	C) Pierced Primers						9-17-91	AC
	D) Optical Clarity of Scope						9-17-91	AC
645	Inspect for Live Ammo						9-17-91	AC
655	Final Inspection						8-28-91	D/H
	A) Headspace							
	B) Trigger Pull	234	236	236	235	243	8-27-91	DH
	C) Function						8-28-91	DH
660	Pack						9-17-91	DH

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

SERIAL NO. C-6649246DATE 8-26-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.35	2.44	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.40	2.32	2.36	
PULL #3	2.39	2.34	2.36	2.36	
PULL #4	2.43	2.38	2.43	2.35	
PULL #5	2.42	2.37	2.30	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.57		
PULL #2	3.59	3.42		
PULL #3	3.55	3.33		
PULL #4	3.57	3.43		
PULL #5	3.52	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.36		4.32
PULL #2	4.30	4.30		4.29
PULL #3	4.30	4.27		4.40
PULL #4	4.37	4.29		4.39
PULL #5	4.37	4.21		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649246
26 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.245082
1 TO	2	.596454
1 TO	3	.219784
1 TO	4	.147122
1 TO	5	.242852

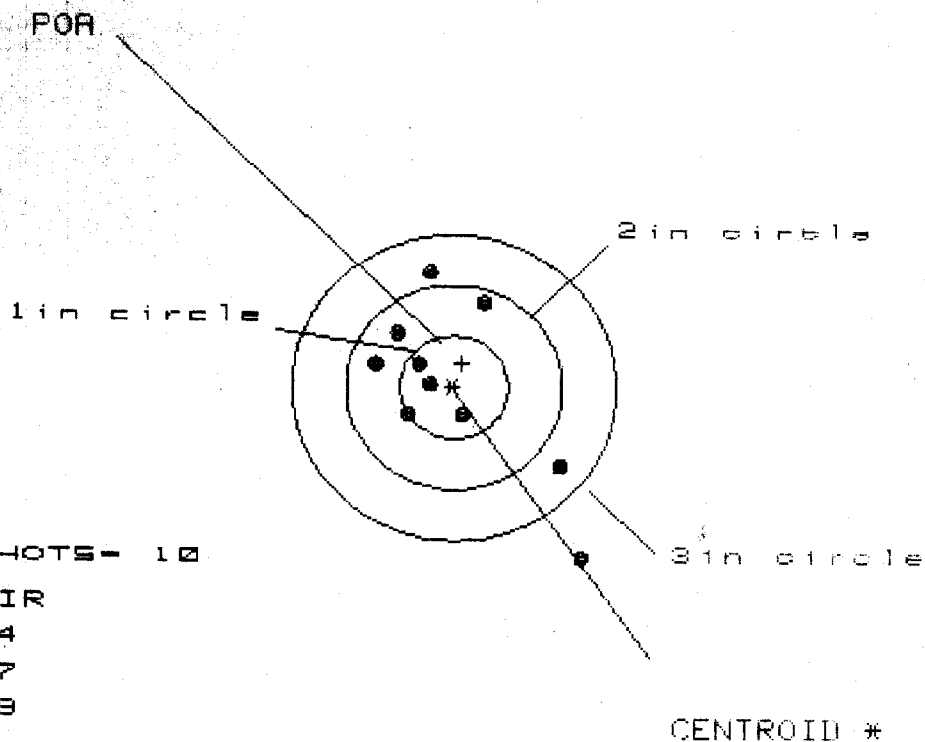
5 2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0506
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.206
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212123
THE AMR FOR THIS RIFLE IS: .8702

26 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649246

CENTERFIRE PATTERNS # 1



* OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 1.854

VS = 2.854

GS = 3.143

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.134	1.116	.493
MINIMUM X	:	-.720	-.594	-.455
MAXIMUM Y	:	1.148	.958	.845
MINIMUM Y	:	-1.706	-.908	-.594
CENTROID X	:	-.076	-.202	-.341
CENTROID Y	:	-.233	-.043	.070
POA TO CENTROID in.	:	.245	.206	.348
MIN RADIUS	:	.264	.185	.075
MEAN RADIUS	:	.815	.626	.492
MAX RADIUS	:	2.049	1.438	.849
HORIZONTAL SPREAD	:	1.854	1.710	.948
VERTICAL SPREAD	:	2.854	1.866	1.439
EXTREME SPREAD	:	3.143	2.204	1.454
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Aug 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.604

VS = 2.297

GS = 3.049

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.143	1.260	1.094
MINIMUM X	:	-1.461	-1.334	-1.074
MAXIMUM Y	:	1.033	.903	.938
MINIMUM Y	:	-1.264	-1.394	-1.359
CENTROID X	:	.513	.386	.552
CENTROID Y	:	-.139	-.009	-.044
POA TO CENTROID in.	:	.531	.386	.554
MIN RADIUS	:	.283	.403	.233
MEAN RADIUS	:	1.103	1.027	.972
MAX RADIUS	:	1.638	1.406	1.359
HORIZONTAL SPREAD	:	2.604	2.594	2.168
VERTICAL SPREAD	:	2.297	2.297	2.297
EXTREME SPREAD	:	3.049	2.741	2.312
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.166

VS = 2.934

GS = 3.647

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.035	.909	.786
MINIMUM X	:	-1.131	-1.006	-.892
MAXIMUM Y	:	1.518	1.503	1.347
MINIMUM Y	:	-1.416	-1.247	-1.253
CENTROID X	:	.133	.259	.145
CENTROID Y	:	-.165	-.334	-.178
POA TO CENTROID in.	:	.212	.422	.229
MIN RADIUS	:	.360	.451	.370
MEAN RADIUS	:	1.141	1.046	.971
MAX RADIUS	:	1.893	1.674	1.484
HORIZONTAL SPREAD	:	2.166	1.915	1.678
VERTICAL SPREAD	:	2.934	2.750	2.600
EXTREME SPREAD	:	3.647	3.205	2.958
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	8		

26 Aug 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS - 10

* IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.340

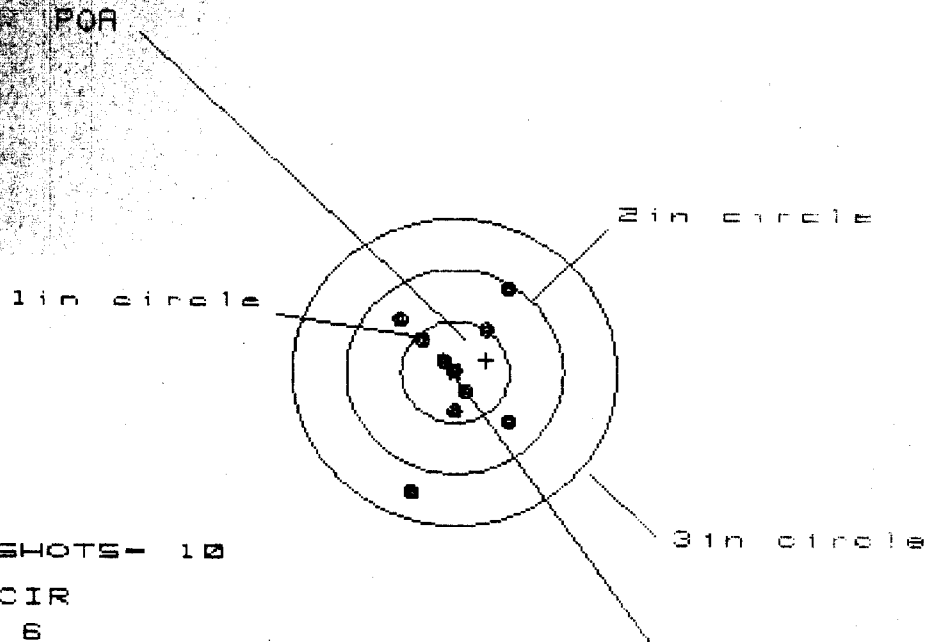
VS = 2.047

GS = 2.331

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.737	.467	.507
MINIMUM X	:	-.603	-.521	-.481
MAXIMUM Y	:	.853	.736	.573
MINIMUM Y	:	-1.194	-1.311	-.884
CENTROID X	:	-.025	-.107	-.147
CENTROID Y	:	-.371	-.254	-.090
POA TO CENTROID in.	:	.372	.276	.173
MIN RADIUS	:	.311	.332	.364
MEAN RADIUS	:	.744	.664	.556
MAX RADIUS	:	1.286	1.350	.887
HORIZONTAL SPREAD	:	1.340	.988	.988
VERTICAL SPREAD	:	2.047	2.047	1.457
EXTREME SPREAD	:	2.331	2.215	1.556
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 6

2 in - 9

3 in - 10

HS - 1.046

VS - 1.986

GS - 2.164

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.520	.478	.533
MINIMUM X	:	-.526	-.568	-.513
MAXIMUM Y	:	.831	.703	.515
MINIMUM Y	:	-1.155	-.654	-.566
CENTROID X	:	-.292	-.250	-.305
CENTROID Y	:	-.122	.006	-.082
POA TO CENTROID in.	:	.316	.250	.316
MIN RADIUS	:	.063	.115	.042
MEAN RADIUS	:	.548	.475	.407
MAX RADIUS	:	1.215	.829	.777
HORIZONTAL SPREAD	:	1.046	1.046	1.046
VERTICAL SPREAD	:	1.986	1.357	1.081
EXTREME SPREAD	:	2.164	1.504	1.504
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	