

C6649275

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

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

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

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

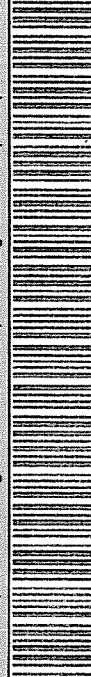
MODEL 700™ M24

SERIAL NO.
C6649275

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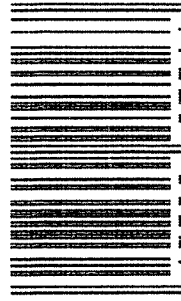
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

20



5716 C6649275

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649275

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	JS
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-8-91	JA

BARBER - M24 0067214

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-8-91	SH
	G) Safety Off Force	3	3	3			8-8-91	SH
	H) Trigger Pull Test & Retainability						8-8-91	SH
	I) Firing Pin Indent	.0205	.021	.021			8-8-91	SH
	J) Assemble Stock						8/9/91	RW
	K) Assemble Swivel Studs						8-10-91	NH
	L) Attach Front and Rear Sight Assemblies						8/9/91	RW
	M) Iron Sight Alignment						8/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	RW
	O) Attach Scope to Rifle						8/9/91	RW
	P) Detach & Attach Scope 20 Times						8/9/91	RW
640	Gallery Target & Test						8-9-91	AC
	A) Time						8-9-91	AC
	B) Malfunctions						8-9-91	AC
	C) Pierced Primers						8-9-91	AC
	D) Optical Clarity of Scope						8-9-91	AC
645	Inspect for Live Ammo						8-9-91	AC
655	Final Inspection							
	A) Headspace						8-10-91	NH
	B) Trigger Pull	2.20	2.18	2.20	2.07	2.20	8-10-91	SH
	C) Function						8-10-91	NH
660	Pack						9-14-91	NH

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

SERIAL NO. C-6649275DATE 8-8-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.26	2.28	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.31	2.38	2.18	
PULL #3	2.40	2.27	2.29	2.20	
PULL #4	2.28	2.26	2.20	2.17	
PULL #5	2.33	2.25	2.28	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.61	3.54		
PULL #2	3.60	3.55		
PULL #3	3.60	3.45		
PULL #4	3.59	3.41		
PULL #5	3.58	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.39		4.30
PULL #2	4.41	4.48		4.33
PULL #3	4.37	4.48		4.34
PULL #4	4.36	4.48		4.39
PULL #5	4.43	4.53		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06649275
 19 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.211123
1 TO	2	.233684
1 TO	3	.45536
1 TO	4	.459619
1 TO	5	.493642

1.2 (---) - POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3638
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .091
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .375009

THE AMR FOR THIS RIFLE IS: .9608

9 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649275

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.377

VS = 2.729

GS = 2.792

CENTROID *

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.311	1.293	1.574
MINIMUM X	-1.066	-1.084	-1.922
MAXIMUM Y	1.160	1.986	1.057
MINIMUM Y	-1.569	-1.954	-1.883
CENTROID X	.098	.116	-.046
CENTROID Y	.187	.361	.298
POA TO CENTROID in.	.211	.379	.293
MIN RADIUS	.329	.341	.259
MEAN RADIUS	.925	.847	.766
MAX RADIUS	1.577	1.414	1.203
HORIZONTAL SPREAD	2.377	2.377	1.496
VERTICAL SPREAD	2.729	1.940	1.940
EXTREME SPREAD	2.792	2.470	2.211
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =			8

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649275

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.662

VS = 2.472

GS = 2.984

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.108

.933

.824

MINIMUM X

-1.574

-1.075

-1.907

MAXIMUM Y

1.169

.818

.672

MINIMUM Y

-1.303

-1.173

-1.110

CENTROID X

.126

.301

.410

CENTROID Y

-.045

-.175

-.029

POA TO CENTROID in.

.134

.348

.411

MIN RADIUS

.428

.203

.255

MEAN RADIUS

.987

.850

.738

MAX RADIUS

1.961

1.463

1.404

HORIZONTAL SPREAD

2.682

1.800

1.731

VERTICAL SPREAD

2.472

1.991

1.702

EXTREME SPREAD

2.984

2.232

2.092

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

9 AUG 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06049275

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.673

VS= 3.364

GS= 3.629

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.550

1.623

.744

MINIMUM X

-1.123

-1.050

-.847

MAXIMUM Y

1.994

1.249

1.243

MINIMUM Y

-1.370

-1.148

-1.154

CENTROID X

.535

.462

.259

CENTROID Y

.315

.093

.099

POA TO CENTROID in.

.621

.471

.278

MIN RADIUS

.033

.227

.090

MEAN RADIUS

.963

.830

.713

MAX RADIUS

2.100

1.624

1.265

HORIZONTAL SPREAD

2.673

2.673

1.591

VERTICAL SPREAD

3.364

2.397

2.397

EXTREME SPREAD

3.629

2.731

2.487

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

7

9 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8649275

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS-- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.885

VS= 2.378

GS= 3.922

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.496	1.358	1.417
MINIMUM X	-1.389	-1.243	-1.176
MAXIMUM Y	1.599	1.401	1.588
MINIMUM Y	-1.779	-1.906	-1.731
CENTROID X	.543	.689	.622
CENTROID Y	.872	.278	.895
POA TO CENTROID in.	.548	.740	.629
MIN RADIUS	.289	.127	.218
MEAN RADIUS	.997	.843	.748
MAX RADIUS	2.209	1.501	1.445
HORIZONTAL SPREAD	2.885	2.593	2.593
VERTICAL SPREAD	3.378	2.367	1.319
EXTREME SPREAD	3.922	2.704	2.696
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	7	

9 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648275

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.385

VS= 1.759

GS= 2.490

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.164	.913	.779
MINIMUM X	-1.201	-1.069	-.852
MAXIMUM Y	.790	.696	.586
MINIMUM Y	-.969	-1.063	-1.173
CENTROID X	.517	.385	.519
CENTROID Y	-.074	.020	.130
POA TO CENTROID IN.	.522	.386	.335
MIN RADIUS	.306	.198	.134
MEAN RADIUS	.322	.246	.241
MAX RADIUS	1.455	1.384	1.322
HORIZONTAL SPREAD	2.385	1.982	1.631
VERTICAL SPREAD	1.759	1.759	1.759
EXTREME SPREAD	2.490	2.188	2.188
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		