

C6649305

MODEL 700™ M24

Model **SWS**™

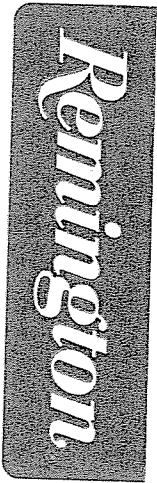
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

Remington®

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

MODEL 700™ H24

SERIAL NO.
C6649305

ORDER NO.
5716

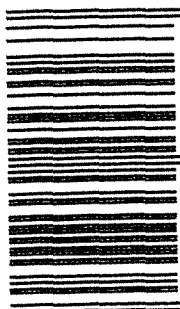
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MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649305

UPC



0 47700 25716 7

9305

MOD. _____ GA. CAL. _____ GUN # ~~9305~~

INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	7/29	Bolt handle hit Stock + Shaver Brows	RW
	2nd		
	7/ 31/ 91	Reamed Ejector hole & Polish Ejector 100 Ed Test	RW
	3rd		
		Crack in Stock A+ Tip Repaired 8/1/91	RW
	4th		
		FINAL INSPECTION	RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 R.D. Test shot OK D/H	
TEST 7/7/91		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649305

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	LS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
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		7/25/91	RW
	C) Inspect Ejector Hole for Chamfer		7/25/91	RW
	D) Oil Firing Pin Ass'y		7/25/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-26-91	JA

op. #	BARBER - M24 0067601 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-26-91	D/H
	G) Safety Off Force	3	3	3			7-26-91	D/H
	H) Trigger Pull Test & Retainability						7-26-91	JH.
	I) Firing Pin Indent	.020	.021	.020			7-26-91	D/H
	J) Assemble Stock						7/29/91	Rw
	K) Assemble Swivel Studs						8-7-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/29/91	Rw
	M) Iron Sight Alignment						7/29/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						7/29/91	Rw
	O) Attach Scope to Rifle						7/29/91	Rw
	P) Detach & Attach Scope 20 Times						7/29/91	Rw
640	Gallery Target & Test						7/29/91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						7-29-91	NF
655	Final Inspection							
	A) Headspace						8-7-91	D/H
	B) Trigger Pull	2.32	2.26	2.25	2.25	2.23	8-6-91	JH
	C) Function						8-7-91	D/H
660	Pack						7-17-91	D/H

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

SERIAL NO C-6649305DATE 7-26-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.20	2.38	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.44	2.48	2.26	
PULL #3	2.44	2.38	2.50	2.25	
PULL #4	2.42	2.43	2.36	2.25	
PULL #5	2.42	2.37	2.32	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.48		
PULL #2	3.37	3.41		
PULL #3	3.38	3.32		
PULL #4	3.47	3.26		
PULL #5	3.48	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.35		4.37
PULL #2	4.17	4.30		4.42
PULL #3	4.52	4.36		4.42
PULL #4	4.31	4.40		4.33
PULL #5	4.44	4.41		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649305
29 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.527873
1 TO 2	.830136
1 TO 3	.745405
1 TO 4	.467472
1 TO 5	.628029

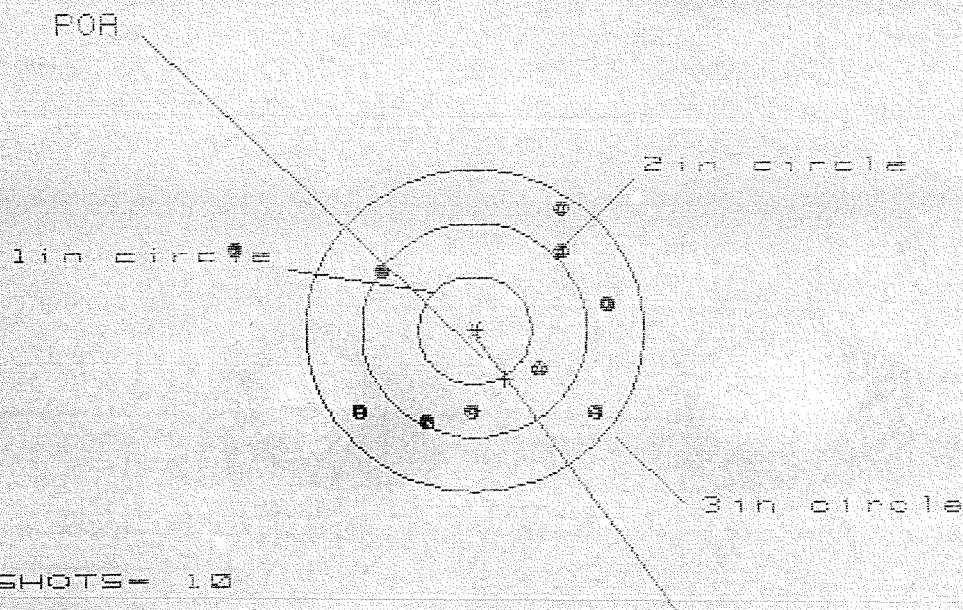
1 5
4 2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0938
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .067
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .127935
THE AMR FOR THIS RIFLE IS: .842

29 Jul 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49305

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 3.359

VS= 2.024

GS= 3.600

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.212	.974	1.046
MINIMUM X	-2.147	-1.221	-1.149
MAXIMUM Y	1.156	1.241	1.000
MINIMUM Y	-.868	-.783	-.628
CENTROID X	-.271	-.033	-.105
CENTROID Y	.453	.368	.213
POA TO CENTROID in.	.528	.369	.237
MIN RADIUS	.666	.425	.409
MEAN RADIUS	1.189	1.026	.960
MAX RADIUS	2.279	1.378	1.268
HORIZONTAL SPREAD	3.359	2.195	2.195
VERTICAL SPREAD	2.024	2.024	1.628
EXTREME SPREAD	3.600	2.601	2.380
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

29 Jul 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.749

VS= 3.572

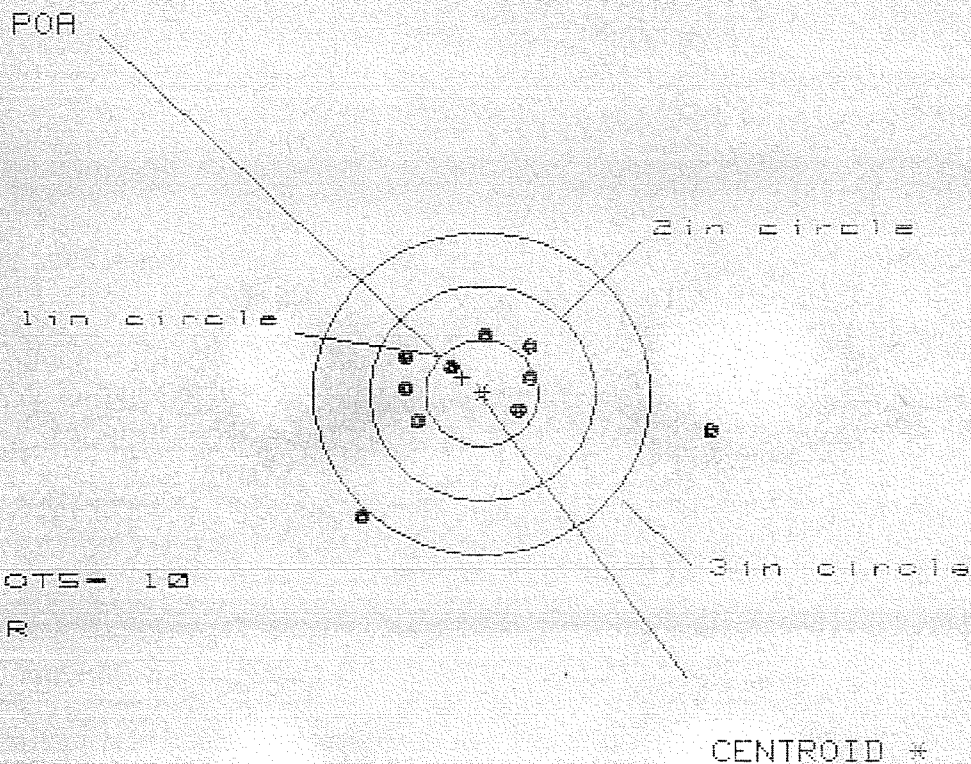
GS= 3.935

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.904	.916	.975
MINIMUM X	:	-.845	-.634	-.576
MAXIMUM Y	:	1.430	1.192	.548
MINIMUM Y	:	-2.142	-1.057	-.908
CENTROID X	:	.215	.004	-.055
CENTROID Y	:	-.220	.018	-.131
POA TO CENTROID in.	:	.308	.019	.142
MIN RADIUS	:	.174	.277	.119
MEAN RADIUS	:	.957	.685	.591
MAX RADIUS	:	2.866	1.279	1.001
HORIZONTAL SPREAD	:	2.749	1.550	1.550
VERTICAL SPREAD	:	3.572	2.249	1.456
EXTREME SPREAD	:	3.935	2.355	1.715
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 3.056

VS= 1.645

GS= 3.161

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.994
MINIMUM X	-1.062
MAXIMUM Y	.499
MINIMUM Y	-1.146
CENTROID X	.174
CENTROID Y	-.145
POA TO CENTROID in.	.227
MIN RADIUS	.370
MEAN RADIUS	.806
MAX RADIUS	2.023
HORIZONTAL SPREAD	3.056
VERTICAL SPREAD	1.645
EXTREME SPREAD	3.161
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 6

2in = 10

3in = 10

HS= 1.309

VS= 1.552

GS= 1.552

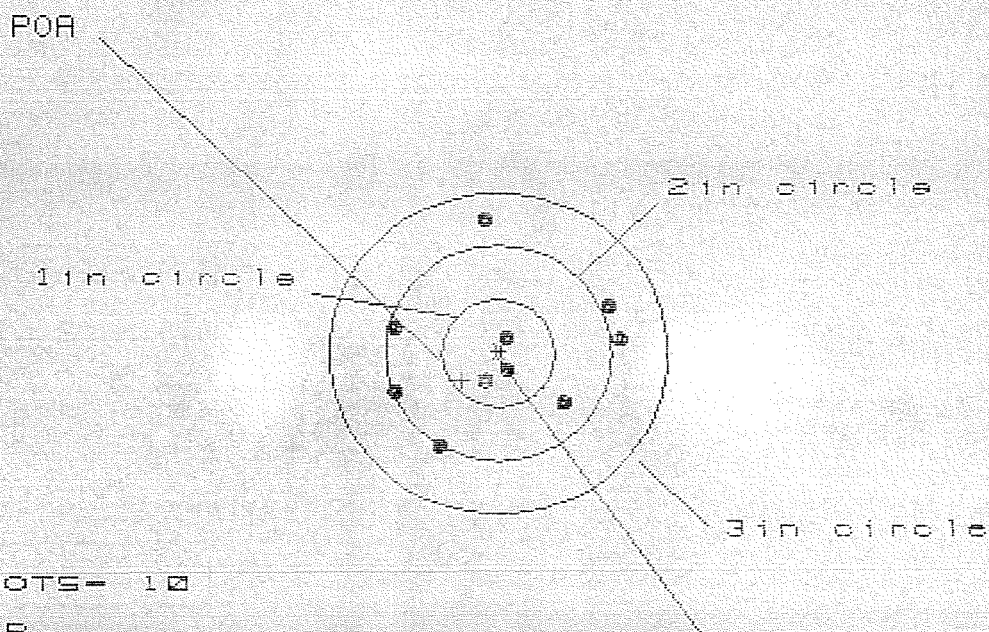
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.863	.425	.421
MINIMUM X	:	-.445	-.350	-.354
MAXIMUM Y	:	.771	.751	.651
MINIMUM Y	:	-.780	-.801	-.571
CENTROID X	:	.026	-.070	-.066
CENTROID Y	:	.092	.112	.212
POA TO CENTROID in.	:	.095	.132	.222
MIN RADIUS	:	.126	.060	.111
MEAN RADIUS	:	.488	.423	.331
MAX RADIUS	:	.883	.802	.651
HORIZONTAL SPREAD	:	1.309	.775	.775
VERTICAL SPREAD	:	1.552	1.552	1.222
EXTREME SPREAD	:	1.552	1.552	1.230
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.007

VS= 2.091

GS= 2.136

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.037	1.022	1.147
MINIMUM X	:	-.970	-.985	-.861
MAXIMUM Y	:	1.236	.533	.420
MINIMUM Y	:	-.855	-.717	-.651
CENTROID X	:	.325	.340	.215
CENTROID Y	:	.255	.117	.051
POA TO CENTROID in.	:	.413	.359	.221
MIN RADIUS	:	.150	.041	.076
MEAN RADIUS	:	.770	.693	.639
MAX RADIUS	:	1.244	1.126	1.190
HORIZONTAL SPREAD	:	2.007	2.007	2.007
VERTICAL SPREAD	:	2.091	1.250	1.071
EXTREME SPREAD	:	2.136	2.074	2.021
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	