

C6611386

MODEL 700™ M24

Model **SWS**™

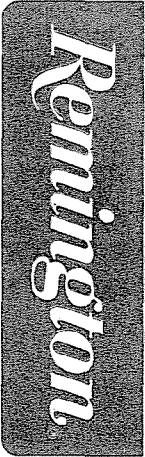
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®
 REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

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

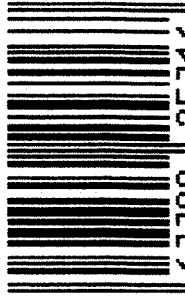
SERIAL NO. C6611386	ORDER NO. 5716
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20



5716 C6611386

UPC



0 47700 25716 7

CFM

120

GUN SERIAL # C6611386

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1 25 91	RW
600	Proof		1 25 91	RW
607	Check Headspace		1 25 91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action			KR
	Magnaflux Bolt			KR
615	Rollmark Caliber		1 25 91	YB
617	Drill and Tap Sight Holes		1 30 91	FB
618	Polish Barrel <i>RWB</i>		1 30 91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TJ
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/13/91	JH

op. #	BARBER - M24 0075941 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/13/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/13/91	JH
	I) Firing Pin Indent	.0217	.0223	.022			2/13/91	WB
	J) Assemble Stock						2/13/91	RW
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/13/91	RW
	M) Iron Sight Alignment						2/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/13/91	RW
	O) Attach Scope to Rifle						2/13/91	RW
	P) Detach & Attach Scope 20 Times						2/13/91	RW
640	Gallery Target & Test						2/13/91	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clarity of Scope						"	KJ
645	Inspect for Live Ammo						2/13/91	KJ
655	Final Inspection							
	A) Headspace						2-25-91	AC
	B) Trigger Pull	2.35	2.44	2.39	2.47	2.46	2/25/91	JH
	C) Function						2-25-91	AC
660	Pack						3-20-91	D/H

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

SERIAL NO. C6611386
DATE 2/13/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.26	2.35	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.22	2.44	2.40	
PULL #3	2.19	2.25	2.39	2.22	
PULL #4	2.28	2.29	2.47	2.20	
PULL #5	2.26	2.42	2.46	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.27		
PULL #2	3.38	3.27		
PULL #3	3.31	3.32		
PULL #4	3.31	3.27		
PULL #5	3.33	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.35		4.27
PULL #2	4.45	4.28		4.13
PULL #3	4.37	4.37		4.35
PULL #4	4.44	4.35		4.30
PULL #5	4.32	4.42		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611386
14 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.507295
1 TO	2	.456939
1 TO	3	.372249
1 TO	4	.755292
1 TO	5	.462088

$\bar{x}_0$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0982
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .130534
THE AMR FOR THIS RIFLE IS: 1.193

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511386

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 3.951

VS = 2.793

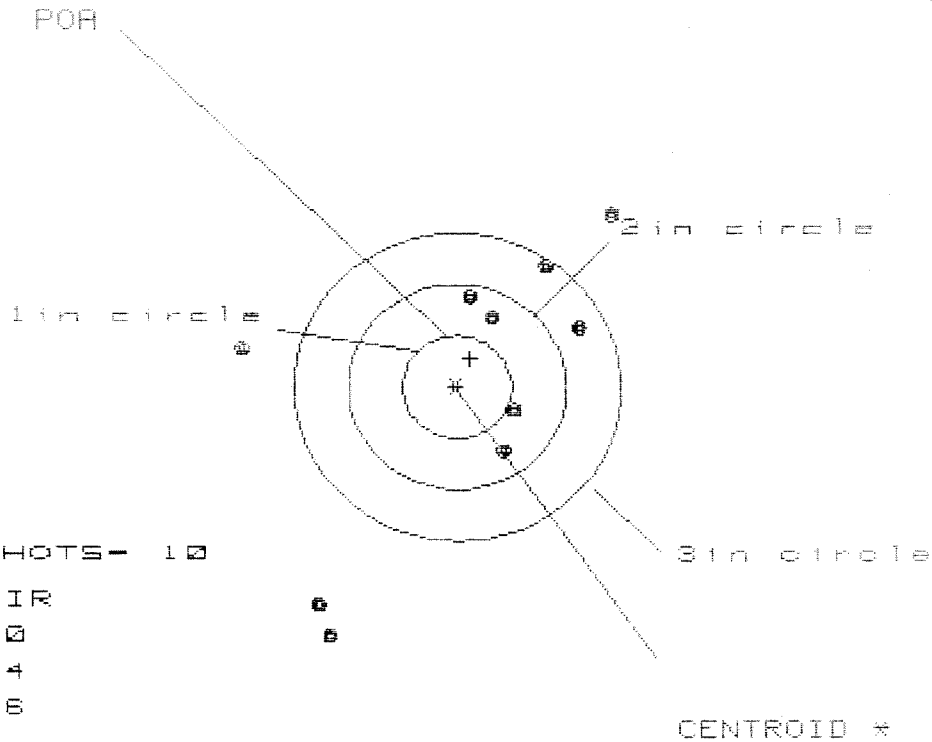
GS = 4.026

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.008	2.149	1.924
MINIMUM X	-1.943	-1.802	-1.122
MAXIMUM Y	.932	.725	.770
MINIMUM Y	-1.861	-.768	-.723
CENTROID X	.322	.181	.466
CENTROID Y	-.392	-.185	-.230
POA TO CENTROID in.	.507	.259	.467
MIN RADIUS	.227	.249	.045
MEAN RADIUS	1.235	1.080	.984
MAX RADIUS	2.253	2.166	1.937
HORIZONTAL SPREAD	3.951	3.951	3.046
VERTICAL SPREAD	2.793	1.493	1.493
EXTREME SPREAD	4.026	4.001	3.205
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

14 Feb 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 3.402

VS= 4.185

GS= 4.917

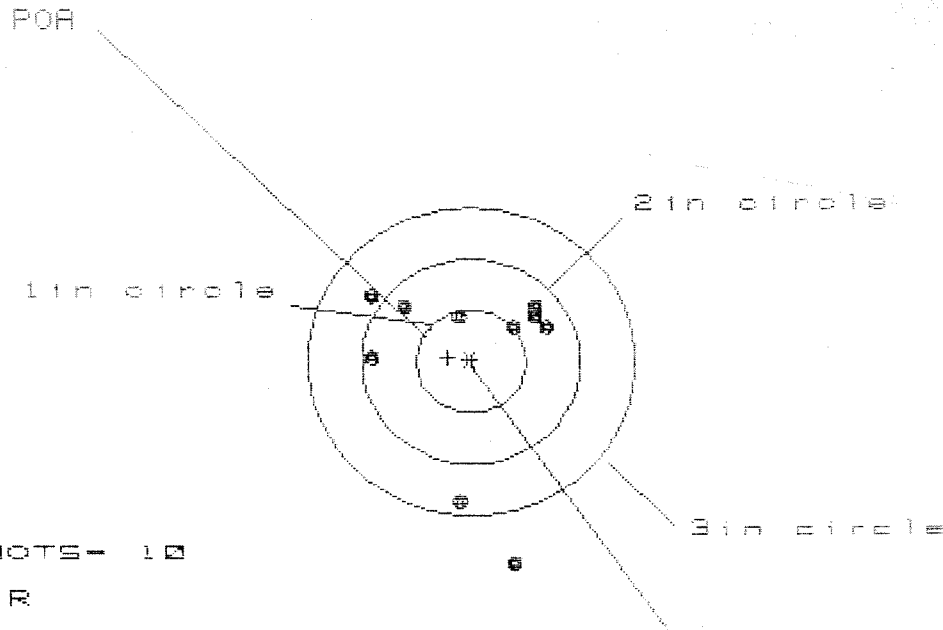
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.243	1.061
MINIMUM X	:	-2.025	-2.159	-2.341
MAXIMUM Y	:	1.716	1.441	1.147
MINIMUM Y	:	-2.470	-2.352	-1.150
CENTROID X	:	-.121	.013	.195
CENTROID Y	:	-.280	-.005	.289
POA TO CENTROID in.	:	.305	.014	.348
MIN RADIUS	:	.568	.426	.112
MEAN RADIUS	:	1.493	1.268	.976
MAX RADIUS	:	2.748	2.766	2.347
HORIZONTAL SPREAD	:	3.402	3.402	3.402
VERTICAL SPREAD	:	4.185	3.793	2.297
EXTREME SPREAD	:	4.917	4.656	3.650
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.615

VS= 2.598

GS= 2.935

CENTROID *

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.670	.717	.711
MINIMUM X	-.945	-.898	-.904
MAXIMUM Y	.657	.442	.242
MINIMUM Y	-1.941	-1.595	-.333
CENTROID X	.210	.163	.169
CENTROID Y	-.037	.178	.378
POA TO CENTROID in.	.213	.242	.414
MIN RADIUS	.446	.226	.076
MEAN RADIUS	.952	.772	.625
MAX RADIUS	1.986	1.596	.958
HORIZONTAL SPREAD	1.615	1.615	1.615
VERTICAL SPREAD	2.598	2.037	.575
EXTREME SPREAD	2.935	2.208	1.647
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 1.739

VS = 3.390

GS = 3.470

CENTROID *

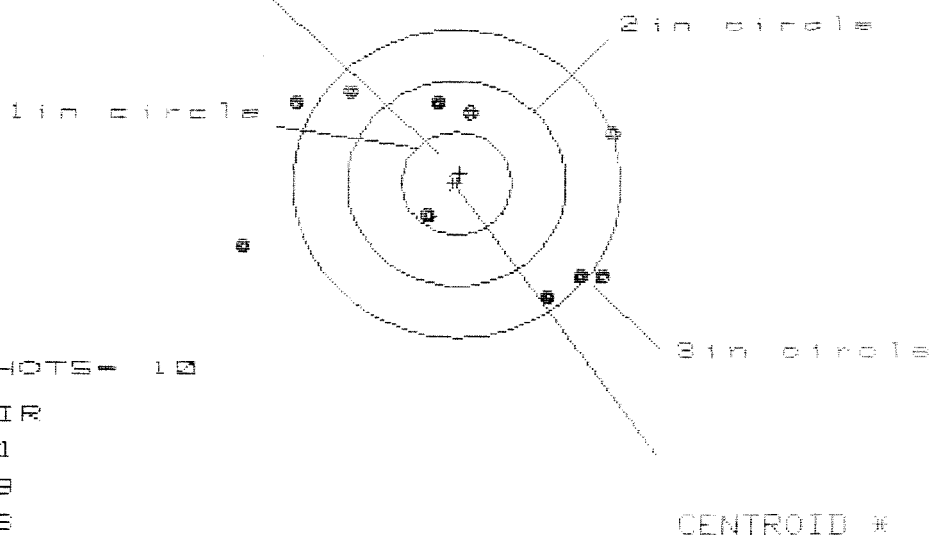
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.674	.747	.747
MINIMUM X	-1.065	-.992	-.992
MAXIMUM Y	1.983	.786	.637
MINIMUM Y	-1.407	-1.186	-.985
CENTROID X	.051	-.022	-.022
CENTROID Y	.313	.092	.240
POA TO CENTROID in.	.317	.095	.241
MIN RADIUS	.416	.364	.370
MEAN RADIUS	.948	.808	.743
MAX RADIUS	2.091	1.265	1.179
HORIZONTAL SPREAD	1.739	1.739	1.739
VERTICAL SPREAD	3.390	1.972	1.543
EXTREME SPREAD	3.470	2.261	2.261
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5

POR



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 3.389

VS = 2.000

GS = 3.548

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.458	1.244	1.027
MINIMUM X	-1.931	-1.731	-1.383
MAXIMUM Y	.922	.857	.953
MINIMUM Y	-1.078	-1.143	-1.047
CENTROID X	-.032	.182	.399
CENTROID Y	-.095	-.030	-.126
POR TO CENTROID in.	.100	.185	.418
MIN RADIUS	.377	.577	.718
MEAN RADIUS	1.286	1.195	1.100
MAX RADIUS	2.016	1.894	1.680
HORIZONTAL SPREAD	3.389	2.975	2.411
VERTICAL SPREAD	2.000	2.000	2.000
EXTREME SPREAD	3.548	3.321	2.904
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		