

C6611390

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

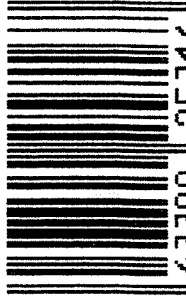
Remington

Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6611390	ORDER NO. 5716
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.			



5716 C6611390

UPC



0 47700 25716 7

GFA

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611390

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		91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GL
617	Drill and Tap Sight Holes	1 30	91	LB
618	Polish Barrel <i>RBB</i>	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	JB
	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		2/18/91	GL

op. #	BARBER M24 0076024	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	2/18/91	WB
	G) Safety Off Force	3	3	3	2/18/91	WB
	H) Trigger Pull Test & Retainability				2/18/91	XL
	I) Firing Pin Indent	.024	.023	.0235	2/18/91	WB
	J) Assemble Stock				2/20/91	RW
	K) Assemble Swivel Studs				2-22-91	A
	L) Attach Front and Rear Sight Assemblies				2/20/91	RW
	M) Iron Sight Alignment				2/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container				2/20/91	RW
	O) Attach Scope to Rifle				2/20/91	RW
	P) Detach & Attach Scope 20 Times				2/20/91	RW
640	Gallery Target & Test				2-20-91	NF
	A) Time				"	NF
	B) Malfunctions				"	NF
	C) Pierced Primers				"	NF
	D) Optical Clarity of Scope				"	NF
645	Inspect for Live Ammo				2-20-91	NF
655	Final Inspection					
	A) Headspace				2-22-91	A
	B) Trigger Pull	2.42	2.41	2.38	2/21/91	XL
	C) Function				2-22-91	A
660	Pack				3-19-91	NF

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

SERIAL NO C6611390DATE 2/18/81TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.41	2.38	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.32	2.40	2.41	
PULL #3	2.24	2.50	2.38	2.38	
PULL #4	2.30	2.39	2.43	2.28	
PULL #5	2.22	2.45	2.48	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.35		
PULL #2	3.31	3.36		
PULL #3	3.29	3.41		
PULL #4	3.29	3.27		
PULL #5	3.37	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.39		4.48
PULL #2	4.38	4.41		4.50
PULL #3	4.39	4.27		4.39
PULL #4	4.35	4.27		4.48
PULL #5	4.35	4.22		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611390
21 Feb 1991

CENTROIDAL DISTANCES

Ø TO	1	.627475
1 TO	2	.795772
1 TO	3	.573761
1 TO	4	.786352
1 TO	5	.823415

4 1
5 2 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1422
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .154108

THE AMR FOR THIS RIFLE IS: 1.148

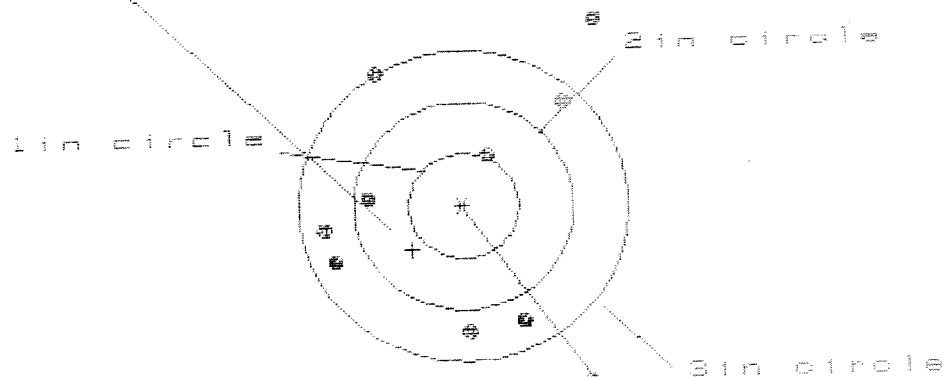
21 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11390

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 2.562

VS= 3.494

GS= 3.496

CENTROID #

PATTERN #

1

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.271	1.284	1.195
MINIMUM X	-1.292	-1.150	-.990
MAXIMUM Y	1.812	1.464	1.279
MINIMUM Y	-1.682	-1.481	-1.161
CENTROID X	.475	.333	.173
CENTROID Y	.410	.209	.394
POA TO CENTROID in.	.627	.393	.430
MIN RADIUS	.513	.758	.611
MEAN RADIUS	1.338	1.219	1.095
MAX RADIUS	2.213	1.960	1.568
HORIZONTAL SPREAD	2.562	2.434	2.185
VERTICAL SPREAD	3.494	2.945	2.440

EXTREME	SPREAD :	3.496	3.487	2.637
NUMBER IN ONE	INCH CIRCLE	=	0	
NUMBER IN TWO	INCH CIRCLE	=	2	
NUMBER IN THREE	INCH CIRCLE	=	8	

21 Feb 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.062

VS = 3.657

GS = 3.717

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.051	1.140	1.168
MINIMUM X	-1.011	-.922	-.894
MAXIMUM Y	1.809	1.604	1.036
MINIMUM Y	-1.848	-1.361	-1.160
CENTROID X	.706	.617	.589
CENTROID Y	-.373	-.168	-.369
POA TO CENTROID in.	.799	.640	.695
MIN RADIUS	.593	.382	.486
MEAN RADIUS	1.237	1.113	1.039
MAX RADIUS	2.014	1.620	1.561
HORIZONTAL SPREAD	2.062	2.062	2.062
VERTICAL SPREAD	3.657	2.965	2.196
EXTREME SPREAD	3.717	3.032	2.570
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

21 Feb 1991

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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 = 6

3 in = 8

HS = 1.500

VS = 3.000

GS = 3.155

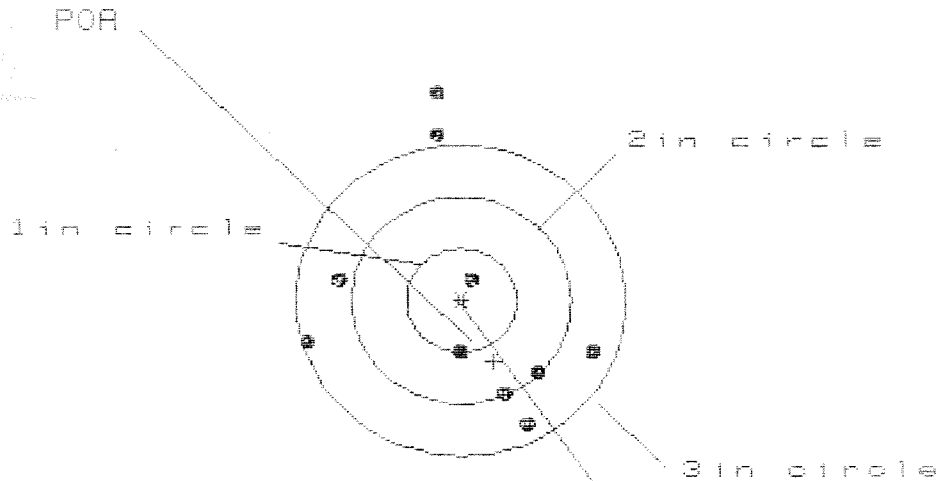
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.653	.604	.479
MINIMUM X	-.947	-.996	-1.071
MAXIMUM Y	1.704	1.604	.841
MINIMUM Y	-1.296	-1.107	-.906
CENTROID X	.046	.095	.220
CENTROID Y	.029	-.160	-.361
POA TO CENTROID in.	.055	.187	.423
MIN RADIUS	.452	.445	.431
MEAN RADIUS	1.014	.902	.740
MAX RADIUS	1.760	1.889	1.103
HORIZONTAL SPREAD	1.600	1.600	1.550
VERTICAL SPREAD	3.000	2.711	1.747
EXTREME SPREAD	3.155	3.091	1.851
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 2.588

VS= 3.224

GS= 3.326

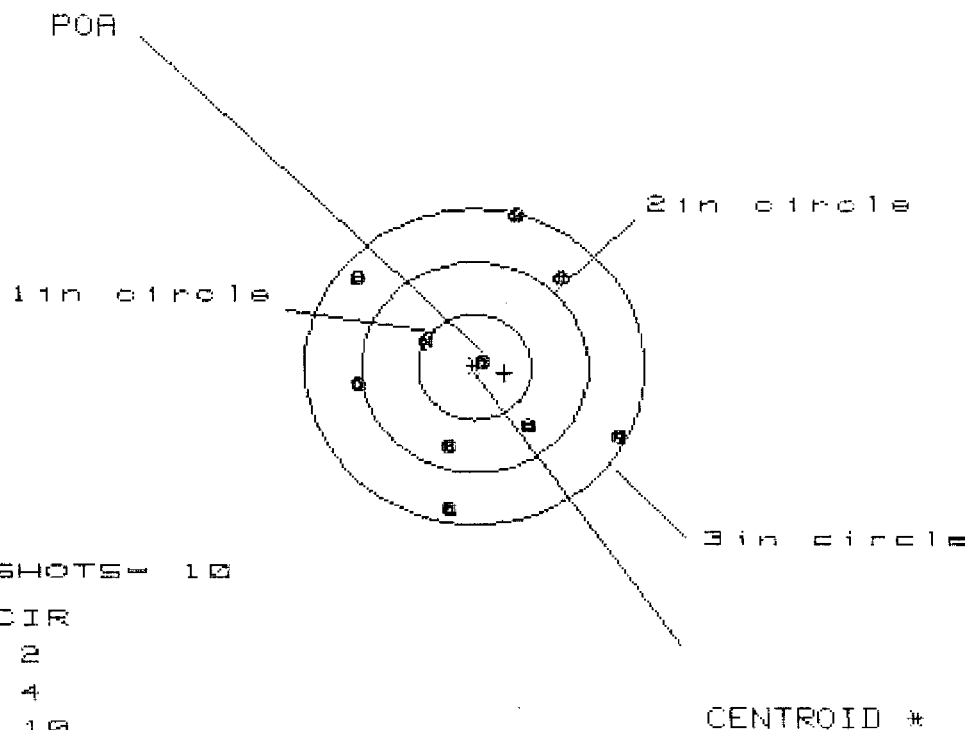
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.191	1.168	1.135
MINIMUM X	-1.397	-1.420	-1.453
MAXIMUM Y	2.055	1.878	.691
MINIMUM Y	-1.169	-.941	-.706
CENTROID X	-.290	-.267	-.234
CENTROID Y	.592	.364	.129
POA TO CENTROID in.	.660	.451	.267
MIN RADIUS	.223	.264	.063
MEAN RADIUS	1.162	1.018	.853
MAX RADIUS	2.065	1.896	1.454
HORIZONTAL SPREAD	2.588	2.588	2.588
VERTICAL SPREAD	3.224	2.819	1.397
EXTREME SPREAD	3.326	2.944	2.589
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

21 Feb 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.325

VS= 2.743

GS= 2.810

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.252	1.296	.971
MINIMUM X	:	-1.074	-1.029	-.867
MAXIMUM Y	:	1.412	1.017	.952
MINIMUM Y	:	-1.331	-1.174	-1.239
CENTROID X	:	-.267	-.311	-.473
CENTROID Y	:	.053	-.104	-.039
POA TO CENTROID in.:	:	.272	.328	.475
MIN RADIUS	:	.125	.280	.345
MEAN RADIUS	:	.988	.929	.859
MAX RADIUS	:	1.469	1.407	1.360
HORIZONTAL SPREAD	:	2.325	2.325	1.838
VERTICAL SPREAD	:	2.743	2.191	2.191
EXTREME SPREAD	:	2.810	2.755	2.396
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	10		