

C5611393

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

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

DUPONT

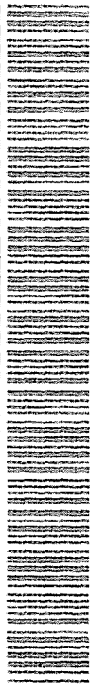
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM M24

SERIAL NO. C6611393

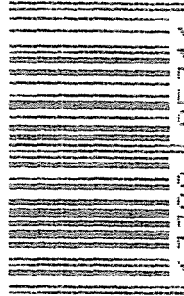
ORDER NO. 5716

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



5716 C6611393

UPC



0 47700 25716 7

MOD.		GA. CAL.	GUN #
			1393
INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	2/21	Bolt Handle Hit Stock	RW
	2nd		
		FILED BOLT HDL SLOT	K.S. 2/21/91
	3rd		
	4th		
		FINAL INSPECTION	RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611393

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 27	91	RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	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	LB
620	Apply Coatings (Barrel Action)		2-10-91	TA
	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		2/15/91	GL

op. #	BARBER M24 0076078	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			2/19/91	WLB
	G) Safety Off Force	2 3/4	2 1/2	2 1/2			2/19/91	WLB
	H) Trigger Pull Test & Retainability						2/19/91	WLB
	I) Firing Pin Indent	.0225	.023	.023			2/19/91	WLB
	J) Assemble Stock						2/19/91	RW
	K) Assemble Swivel Studs						2-22-91	AC
	L) Attach Front and Rear Sight Assemblies						2/19/91	RW
	M) Iron Sight Alignment						2/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	RW
	O) Attach Scope to Rifle						2/19/91	RW
	P) Detach & Attach Scope 20 Times						2/19/91	RW
640	Gallery Target & Test						2-21-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-21-91	NF
655	Final Inspection							
	A) Headspace						2-22-91	AC
	B) Trigger Pull	2.32	2.39	2.39	2.27	2.28	2/22/91	WLB
	C) Function						2-22-91	AC
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. C6611393DATE 2/18/91TESTER JCU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.27	2.32	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.34	2.33	2.39	
PULL #3	2.24	2.23	2.26	2.39	
PULL #4	2.30	2.25	2.30	2.22	
PULL #5	2.20	2.18	2.37	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.40		
PULL #2	3.40	3.40		
PULL #3	3.50	3.48		
PULL #4	3.35	3.38		
PULL #5	3.31	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.32		4.30
PULL #2	4.47	4.54		4.45
PULL #3	4.27	4.45		4.45
PULL #4	4.44	4.46		4.49
PULL #5	4.36	4.38		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611393
21 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.196003
1 TO	2	.137768
1 TO	3	.221199
1 TO	4	.12516
1 TO	5	.178306

448

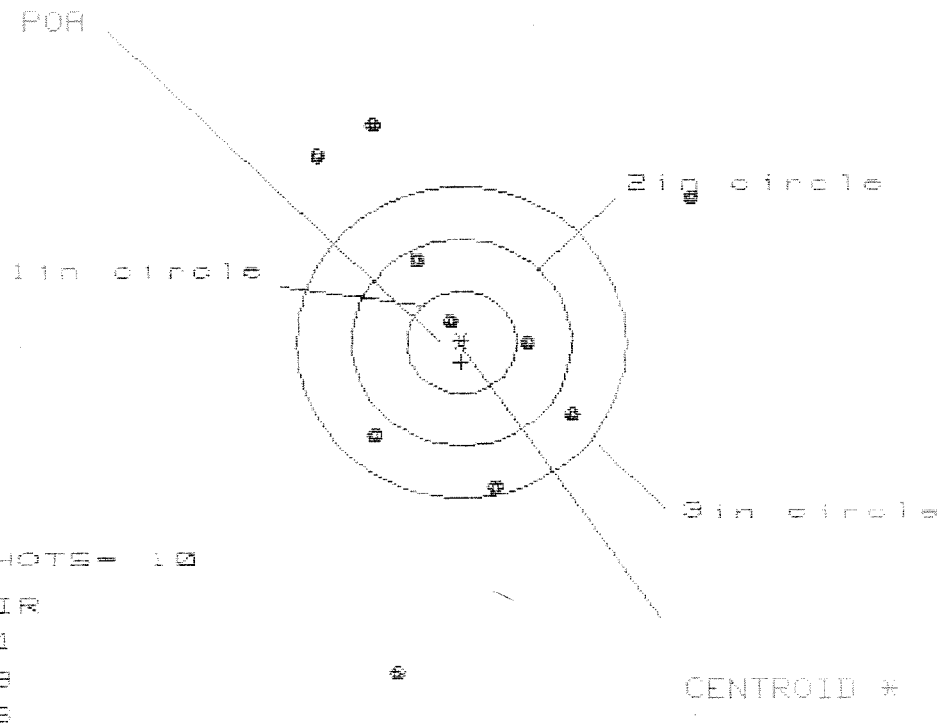
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .175
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .176611
THE AMR FOR THIS RIFLE IS: 1.095

21 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611999

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 3.457

VS = 5.332

GS = 5.411

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.146

2.081

1.155

MINIMUM X

-1.311

-1.376

-1.115

MAXIMUM Y

2.185

1.747

1.883

MINIMUM Y

-3.227

-1.784

-1.648

CENTROID X

.001

.066

-.195

CENTROID Y

.196

.554

.418

POA TO CENTROID in.

.196

.558

.461

MIN RADIUS

.194

.249

.112

MEAN RADIUS

1.582

1.389

1.235

MAX RADIUS

3.278

2.349

1.991

HORIZONTAL SPREAD

3.457

3.457

2.270

VERTICAL SPREAD

5.332

3.531

3.531

EXTREME SPREAD

5.411

3.760

3.700

NUMBER IN ONE

INCH CIRCLE

=

1

NUMBER IN TWO

INCH CIRCLE

=

3

BARBER - M24 0076082

NUMBER IN THREE INCH CIRCLE =

6

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

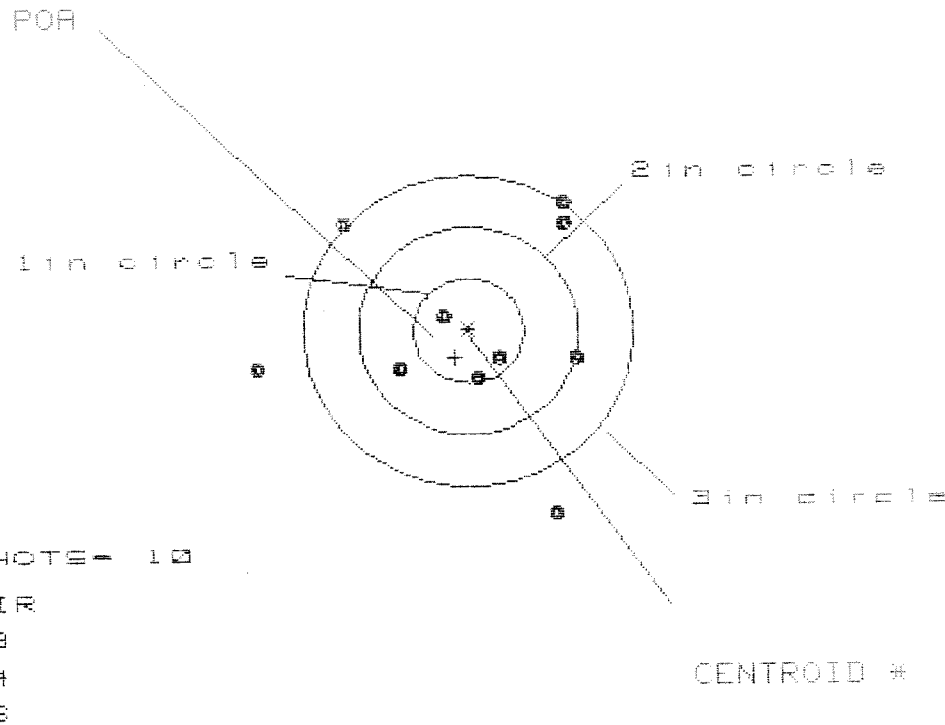
BARBER - M24 0076082

M2400076121

21 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611393

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 6

HS = 2.9006

VS = 3.048

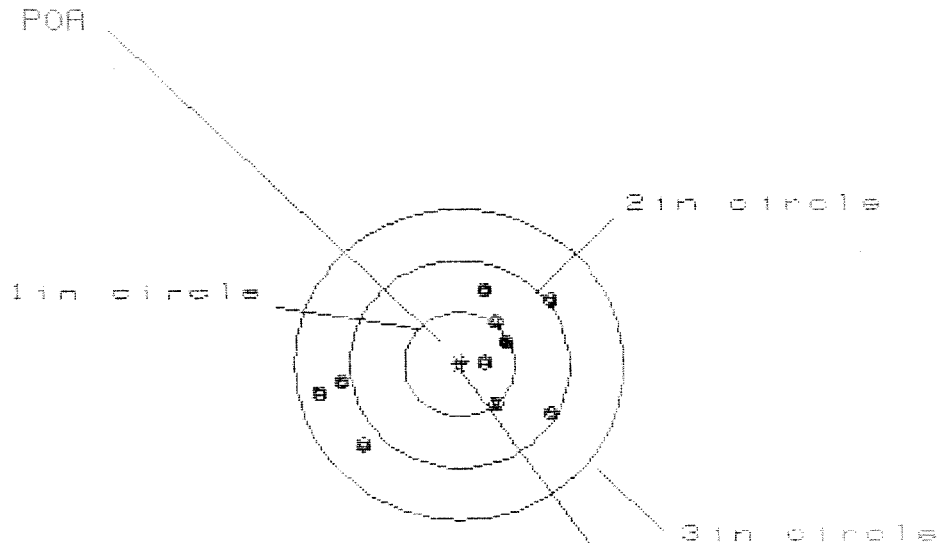
GS = 3.394

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.972	.757	.833
MINIMUM X	-1.934	-1.318	-1.242
MAXIMUM Y	1.279	1.242	1.017
MINIMUM Y	-1.769	-1.806	-1.738
CENTROID X	.123	.338	.262
CENTROID Y	.260	.297	.522
POA TO CENTROID in.	.288	.450	.585
MIN RADIUS	.231	.288	.389
MEAN RADIUS	1.106	1.013	.921
MAX RADIUS	1.962	1.905	1.458
HORIZONTAL SPREAD	2.906	2.075	2.075
VERTICAL SPREAD	3.048	3.048	1.755
EXTREME SPREAD	3.394	3.394	2.454
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

21 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611393

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.133

VS = 1.497

GS = 2.308

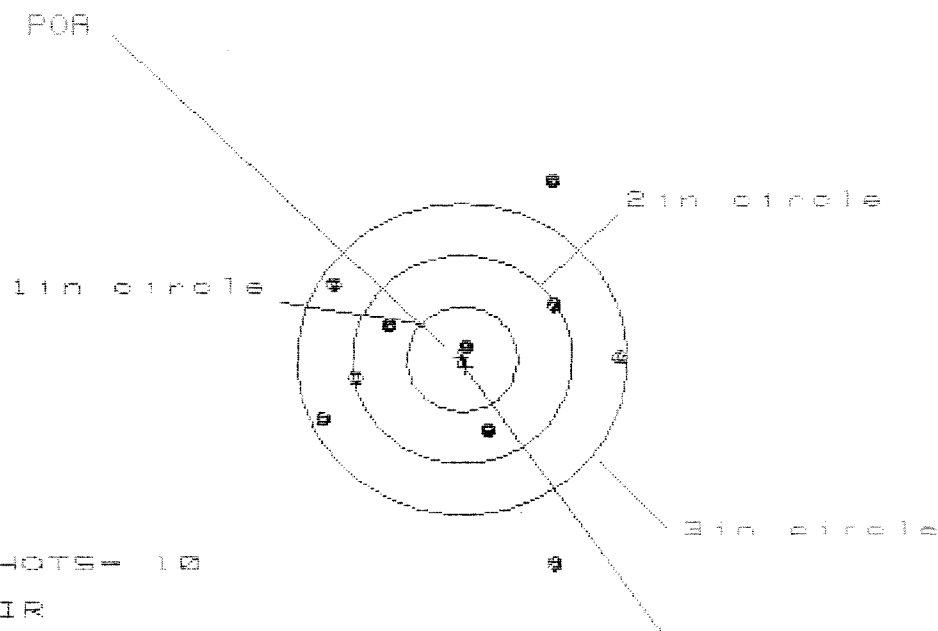
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.869	.729	.602
MINIMUM X	-1.264	-1.168	-1.295
MAXIMUM Y	.741	.715	.617
MINIMUM Y	-.756	-.782	-.568
CENTROID X	-.022	.118	.245
CENTROID Y	-.024	.002	.100
POA TO CENTROID in.	.033	.118	.265
MIN RADIUS	.186	.043	.123
MEAN RADIUS	.798	.695	.583
MAX RADIUS	1.285	1.283	1.324
HORIZONTAL SPREAD	2.133	1.897	1.897
VERTICAL SPREAD	1.497	1.497	1.185
EXTREME SPREAD	2.308	2.240	2.038
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611393

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 8

HE = 3.699

VS = 3.699

GS = 3.699

CENTROID #

PATTERN #	4	5	6
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.391	1.484	1.595
MINIMUM X	-1.247	-1.154	-1.043
MAXIMUM Y	1.728	1.510	.657
MINIMUM Y	-1.970	-.889	-.701
CENTROID X	-.031	-.124	-.235
CENTROID Y	.075	.293	.105
POA TO CENTROID in.	.081	.319	.257
MIN RADIUS	.118	.140	.224
MEAN RADIUS	1.173	1.051	.940
MAX RADIUS	2.141	1.750	1.595
HORIZONTAL SPREAD	2.638	2.638	2.638
VERTICAL SPREAD	3.699	2.399	1.358
EXTREME SPREAD	3.699	3.056	2.691

BARBER - M24 0076086

21 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611393

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 1.751

VS = 3.233

GS = 3.362

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.648

.657

.527

MINIMUM X

-1.113

-1.041

-.408

MAXIMUM Y

2.289

.823

.845

MINIMUM Y

-.944

-.690

-.668

CENTROID X

.048

-.024

.106

CENTROID Y

.368

.114

.092

POA TO CENTROID in.

.371

.116

.140

MIN RADIUS

.195

.072

.120

MEAN RADIUS

.816

.577

.516

MAX RADIUS

2.379

1.055

.938

VERTICAL	SPREAD	:	3.233	1.513	1.513
EX	BARBER - M24 0076087		3.302	1.800	1.695
NUMBER IN ONE	INCH CIRCLE	=		3	
NUMBER IN TWO	INCH CIRCLE	=		7	
NUMBER IN THREE	INCH CIRCLE	=		9	