

C6611463

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

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

REMINGTON-UMC
 REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO.
 C6611463

ORDER NO.
 5716

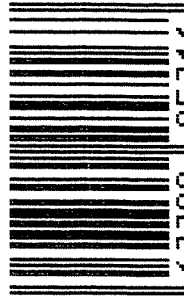
46

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



5716 C6611463

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611463

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	GB
617	Drill and Tap Sight Holes	APR	3 1991	EB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	ICS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	ICS
	C) Inspect Ejector Hole for Chamfer		4/18/91	ICS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	AK

op. NAME	BARBER - M24 0077345	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-22-91	DH
	G) Safety Off Force	3	3	3			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	921
	I) Firing Pin Indent	.021	.021	.021			4-22-91	DH
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						4-2-91	DH
	L) Attach Front and Rear Sight Assemblies						4/24/91	KS
	M) Iron Sight Alignment						4/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/24/91	KS
	O) Attach Scope to Rifle						4/24/91	KS
	P) Detach & Attach Scope 20 Times						4/24/91	KS
640	Gallery Target & Test						4-25-91	AC
	A) Time						4-25-91	AC
	B) Malfunctions						4-25-91	AC
	C) Pierced Primers						4-25-91	AC
	D) Optical Clarity of Scope						4-25-91	AC
645	Inspect for Live Ammo						4-25-91	AC
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.48	2.41	2.40	2.41	2.44	4/26/91	921
	C) Function						5-2-91	DH
660	Pack						6-19-91	VF

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

SERIAL NO. C6611463DATE 4/19/97TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS (1)
PULL #1	2.31	2.42	2.38	2.48	MIN. SETTING
PULL #2	2.28	2.50	2.46	2.41	NO AVG. OF 5
PULL #3	2.50	2.44	2.49	2.40	READINGS ACCEPT-
PULL #4	2.49	2.41	2.43	2.41	ABLE LESS THAN 2#
PULL #5	2.33	2.28	2.33	2.44	COIL (M)
TOTAL					1.00 (M)
AVG.					1.00

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS (4)
PULL #1	3.54	3.60			
PULL #2	3.29	3.62			
PULL #3	3.52	3.58			
PULL #4	3.57	3.59			
PULL #5	3.45	3.55			
TOTAL					
AVG.					2.2

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.40		4.40
PULL #2	4.53	4.59		4.40
PULL #3	4.31	4.36		4.39
PULL #4	4.11	4.39		4.18
PULL #5	4.44	4.41		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611463
25 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.298464
1 TO	2	.454252
1 TO	3	.559519
1 TO	4	.533434
1 TO	5	.251859

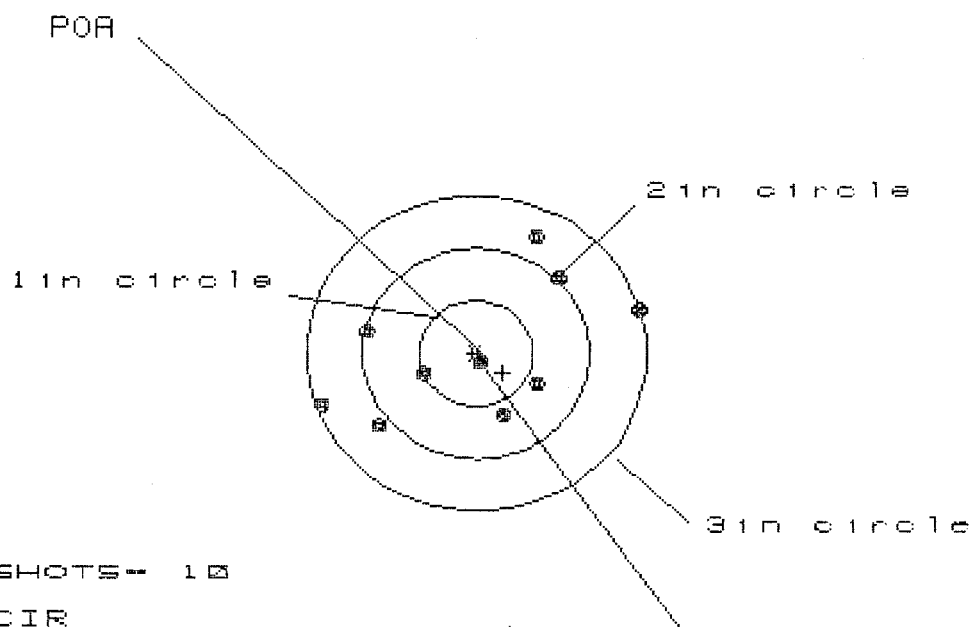
5/2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0216
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0524
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .056670
THE AMR FOR THIS RIFLE IS: .9748

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611463

CENTERFIRE PATTERNS # 1



OF SHOTS-- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.722

VS= 1.805

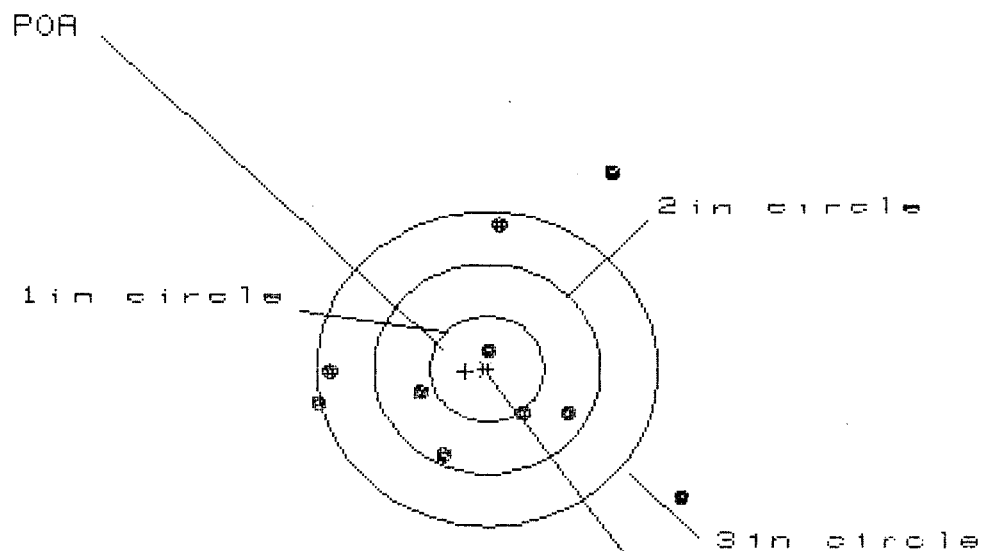
GS= 2.853

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.385	.925	.778
MINIMUM X	-1.337	-1.183	-.988
MAXIMUM Y	1.086	1.130	1.079
MINIMUM Y	-.719	-.675	-.726
CENTROID X	-.235	-.389	-.242
CENTROID Y	.184	.140	.191
POA TO CENTROID in.	.299	.414	.308
MIN RADIUS	.078	.216	.087
MEAN RADIUS	.912	.849	.785
MAX RADIUS	1.442	1.330	1.212
HORIZONTAL SPREAD	2.722	2.108	1.766
VERTICAL SPREAD	1.805	1.805	1.805
EXTREME SPREAD	2.853	2.433	2.276
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611463

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in - 7

HS - 3.191

VS - 3.088

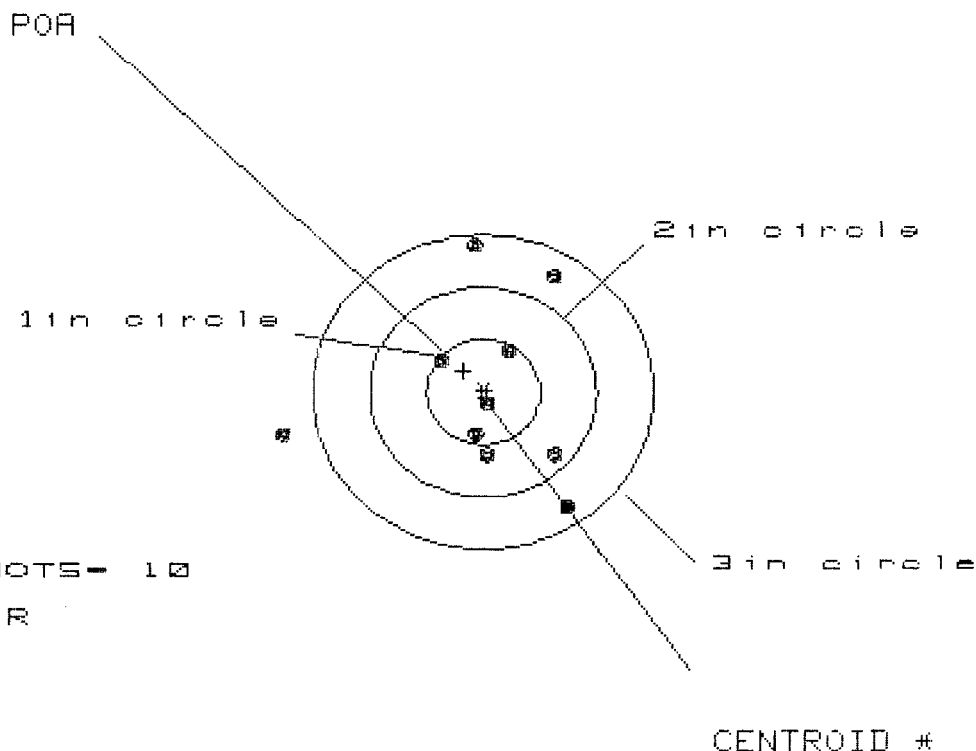
GS - 3.406

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.681	1.801	1.033
MINIMUM X	:	-1.510	-1.390	-1.165
MAXIMUM Y	:	1.871	1.568	1.442
MINIMUM Y	:	-1.217	-1.009	-0.740
CENTROID X	:	.189	.069	-.156
CENTROID Y	:	.021	-.187	-.061
POA TO CENTROID in.	:	.190	.199	.167
MIN RADIUS	:	.189	.427	.276
MEAN RADIUS	:	1.167	1.033	.893
MAX RADIUS	:	2.159	2.064	1.500
HORIZONTAL SPREAD	:	3.191	3.191	2.198
VERTICAL SPREAD	:	3.088	2.577	2.182
EXTREME SPREAD	:	3.406	3.340	2.323
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611463

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.471

VS = 2.412

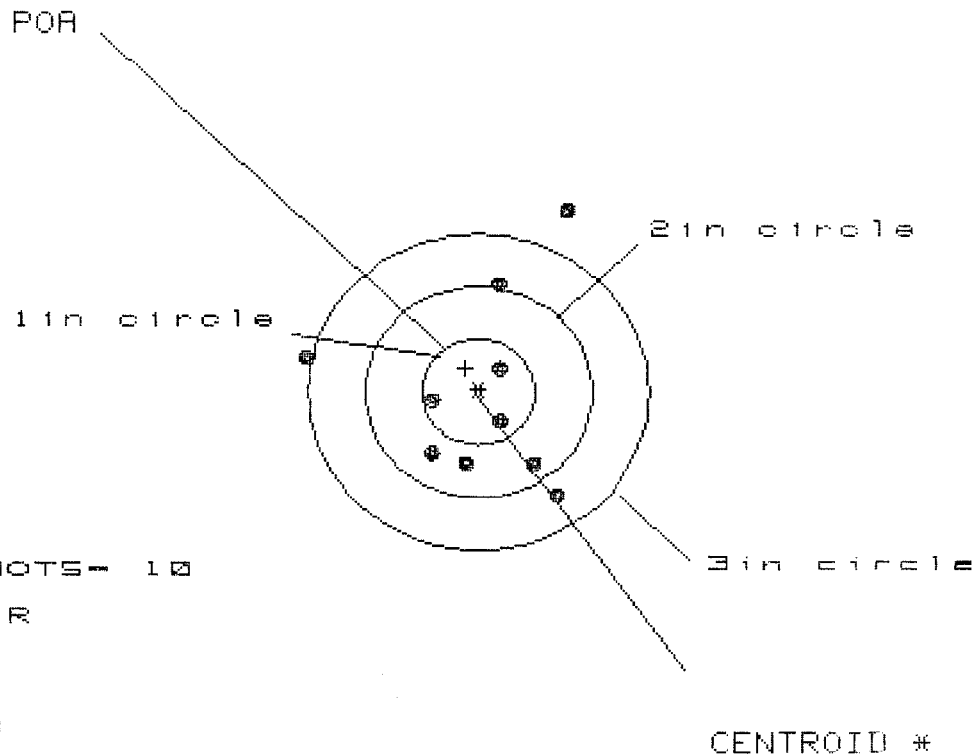
GS = 2.834

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.688	.490	.452
MINIMUM X	:	-1.783	-.562	-.600
MAXIMUM Y	:	1.357	1.312	1.205
MINIMUM Y	:	-1.055	-1.100	-.936
CENTROID X	:	.171	.369	.407
CENTROID Y	:	-.201	-.156	-.320
POA TO CENTROID in.	:	.264	.400	.517
MIN RADIUS	:	.124	.212	.181
MEAN RADIUS	:	.875	.769	.675
MAX RADIUS	:	1.829	1.346	1.266
HORIZONTAL SPREAD	:	2.471	1.052	1.052
VERTICAL SPREAD	:	2.412	2.412	2.141
EXTREME SPREAD	:	2.834	2.538	2.142
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611463

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.262

VS= 2.625

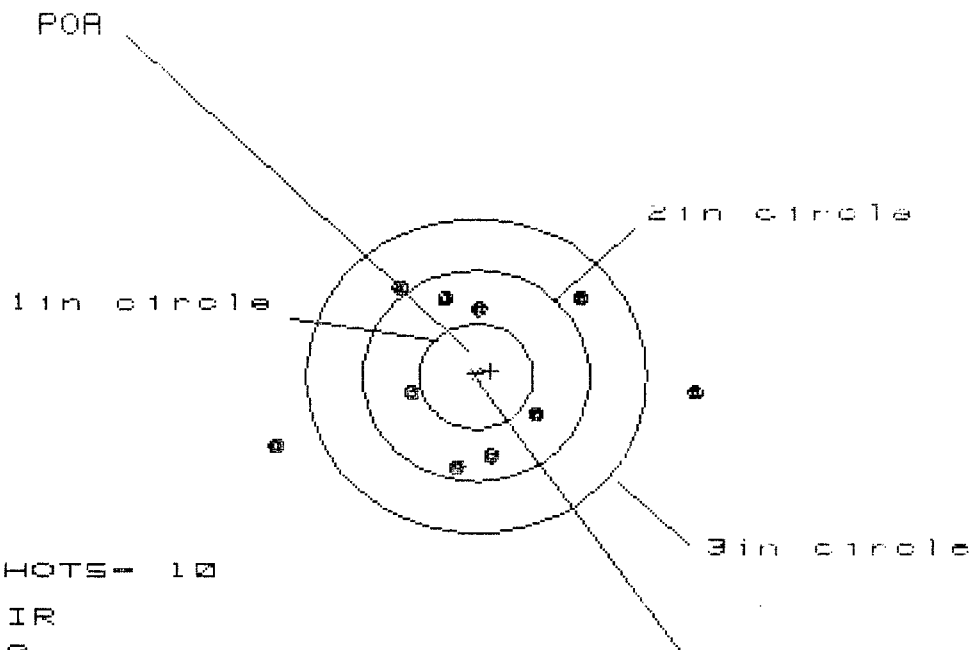
GS= 2.661

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.761	.728	.551
MINIMUM X	:	-1.501	-1.416	-.550
MAXIMUM Y	:	1.685	1.232	1.291
MINIMUM Y	:	-.940	-.753	-.694
CENTROID X	:	.111	.026	.203
CENTROID Y	:	-.222	-.409	-.468
POA TO CENTROID in.	:	.248	.410	.510
MIN RADIUS	:	.332	.294	.110
MEAN RADIUS	:	.886	.738	.616
MAX RADIUS	:	1.849	1.492	1.294
HORIZONTAL SPREAD	:	2.262	2.144	1.101
VERTICAL SPREAD	:	2.625	1.985	1.985
EXTREME SPREAD	:	2.661	2.468	2.040
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611463

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 6

3 in - 8

HS= 3.690

VS= 1.664

GS= 3.735

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.930	1.113	.919
MINIMUM X	:	-1.760	-1.545	-.647
MAXIMUM Y	:	.844	.830	.741
MINIMUM Y	:	-.820	-.834	-.923
CENTROID X	:	-.128	-.343	-.149
CENTROID Y	:	-.044	-.030	.059
POA TO CENTROID in.	:	.135	.344	.161
MIN RADIUS	:	.593	.400	.570
MEAN RADIUS	:	1.034	.919	.809
MAX RADIUS	:	1.934	1.704	1.099
HORIZONTAL SPREAD	:	3.690	2.653	1.566
VERTICAL SPREAD	:	1.664	1.664	1.664
EXTREME SPREAD	:	3.735	3.006	1.852
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	