

C6611464

MODEL 700™ M24

Model **SWS**™

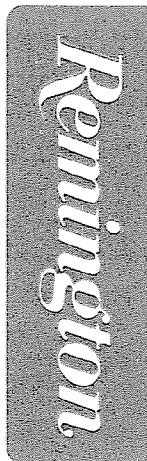
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

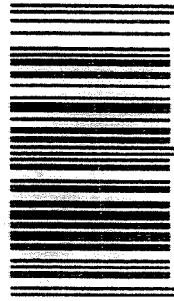


Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700TM H24		SERIAL NO. C6611464	ORDER NO. 5716
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20	



5716 C6611464

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611464**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	XR
615	Rollmark Caliber		3/27/91	LS
617	Drill and Tap Sight Holes		APR 3 1991	KB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/29/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/29/91	KS
	C) Inspect Ejector Hole for Chamfer		4/29/91	KS
	D) Oil Firing Pin Ass'y		4/29/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	Off

op. NAME	BARBER - M24 0077356	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/7/91	SL
	G) Safety Off Force	4	4	4			5/7/91	SL
	H) Trigger Pull Test & Retainability						5/7/91	SL
	I) Firing Pin Indent	.0225	.022	.0225			5/7/91	SL
	J) Assemble Stock						5/7/91	KS
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/7/91	KS
	M) Iron Sight Alignment						5/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	KS
	O) Attach Scope to Rifle						5/7/91	KS
	P) Detach & Attach Scope 20 Times						5/7/91	KS
640	Gallery Target & Test						5-9-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-9-91	AF
655	Final Inspection							
	A) Headspace						5/1/91	D/H
	B) Trigger Pull	2.60	2.38	2.42	2.44	2.53	5/10/91	SL
	C) Function						5-1-91	D/H
660	Pack						6-18-91	AF

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

SERIAL NO. C6611464DATE 5/7/97 (G)TESTER JM (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.39	2.32	2.60	MIN. SETTING,
PULL #2	2.33	2.42	2.39	2.38	NO AVG. OF 5
PULL #3	2.30	2.38	2.44	2.42	READINGS ACCEPT-
PULL #4	2.37	2.43	2.40	2.44	ABLE LESS THAN 2#
PULL #5	2.36	2.34	2.40	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.36	3.21			
PULL #2	3.17	3.18			
PULL #3	3.28	3.20			
PULL #4	3.34	3.25			
PULL #5	3.22	3.20			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX-SETTING GREATER THAN 4#	RESET-TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.28		4.27
PULL #2	4.31	4.25		4.26
PULL #3	4.29	4.28		4.23
PULL #4	4.28	4.26		4.23
PULL #5	4.27	4.22		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611464
9 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0631506
1 TO	2	.192094
1 TO	3	.409575
1 TO	4	.149683
1 TO	5	.244377

5
3-PE <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.000
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 0.000
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.000

THE AMR FOR THIS RIFLE IS: .9534

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611464

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.171

VS= 4.415

GS= 4.636

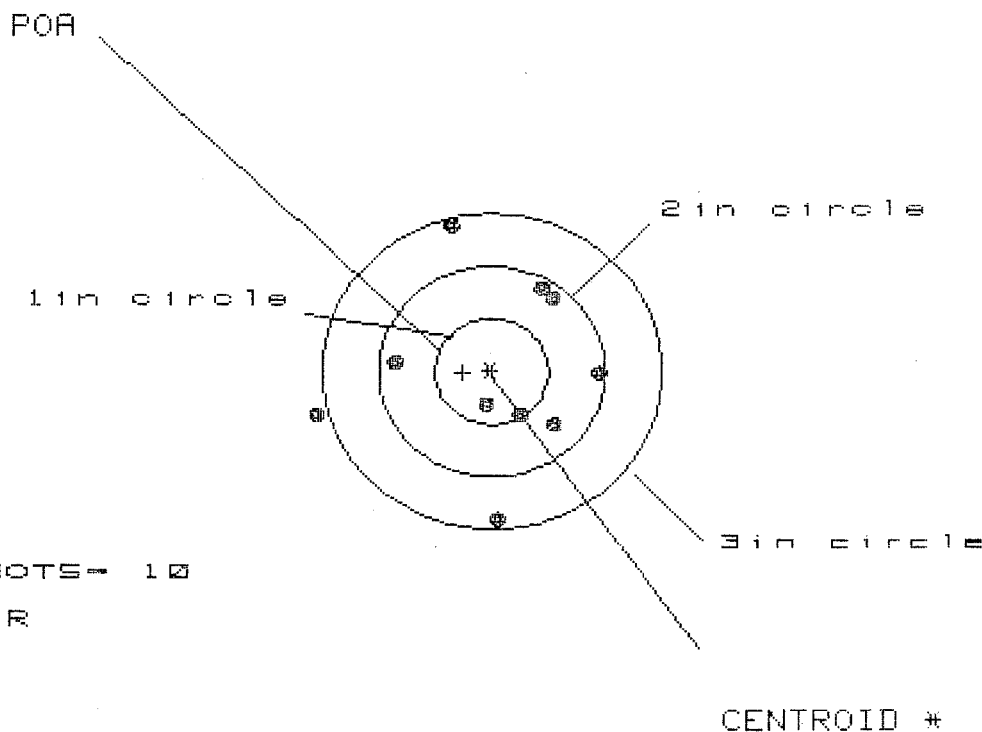
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.006	.884	1.006
MINIMUM X	:	-1.165	-1.287	-1.165
MAXIMUM Y	:	1.771	1.477	1.771
MINIMUM Y	:	-2.644	-1.205	-2.644
CENTROID X	:	.062	.134	.062
CENTROID Y	:	.012	.307	.012
POA TO CENTROID in.	:	.063	.357	.063
MIN RADIUS	:	.495	.177	.495
MEAN RADIUS	:	1.251	1.311	1.251
MAX RADIUS	:	2.864	1.500	2.864
HORIZONTAL SPREAD	:	2.171	2.171	2.171
VERTICAL SPREAD	:	4.415	2.702	4.415
EXTREME SPREAD	:	4.636	2.843	4.636
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	4	4	4
NUMBER IN THREE INCH CIRCLE	=	7	7	7

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in - 2

2in - 7

3in - 9

HS - 2.466

VS - 2.788

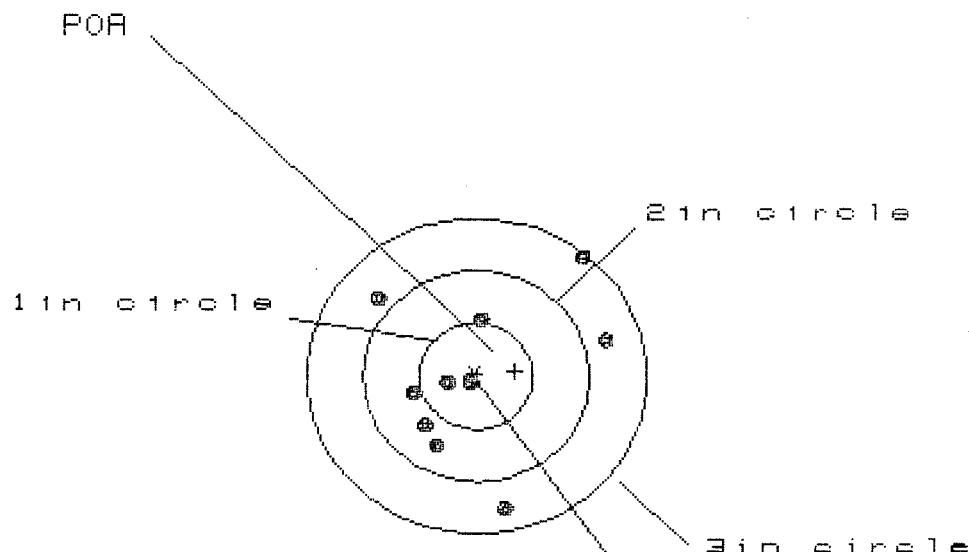
GS - 2.824

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	.794	.723
MINIMUM X	:	-1.505	-.996	-1.067
MAXIMUM Y	:	1.425	1.375	1.277
MINIMUM Y	:	-1.363	-1.413	-1.241
CENTROID X	:	.254	.421	.445
CENTROID Y	:	.006	.057	.115
POA TO CENTROID in.	:	.254	.425	.505
MIN RADIUS	:	.311	.427	.247
MEAN RADIUS	:	.947	.858	.744
MAX RADIUS	:	1.572	1.488	1.255
HORIZONTAL SPREAD	:	2.466	1.790	1.790
VERTICAL SPREAD	:	2.788	2.788	2.110
EXTREME SPREAD	:	2.824	2.824	2.140
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.038

VS= 2.432

GS= 2.538

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.259	1.306
MINIMUM X	:	-.889	-.779	-.732
MAXIMUM Y	:	1.128	.892	.745
MINIMUM Y	:	-1.304	-1.179	-.689
CENTROID X	:	-.344	-.454	-.501
CENTROID Y	:	-.042	-.167	-.020
POA TO CENTROID in.	:	.347	.484	.502
MIN RADIUS	:	.103	.091	.093
MEAN RADIUS	:	.798	.680	.611
MAX RADIUS	:	1.500	1.333	1.338
HORIZONTAL SPREAD	:	2.038	2.038	2.038
VERTICAL SPREAD	:	2.432	2.071	1.434
EXTREME SPREAD	:	2.538	2.370	2.088
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

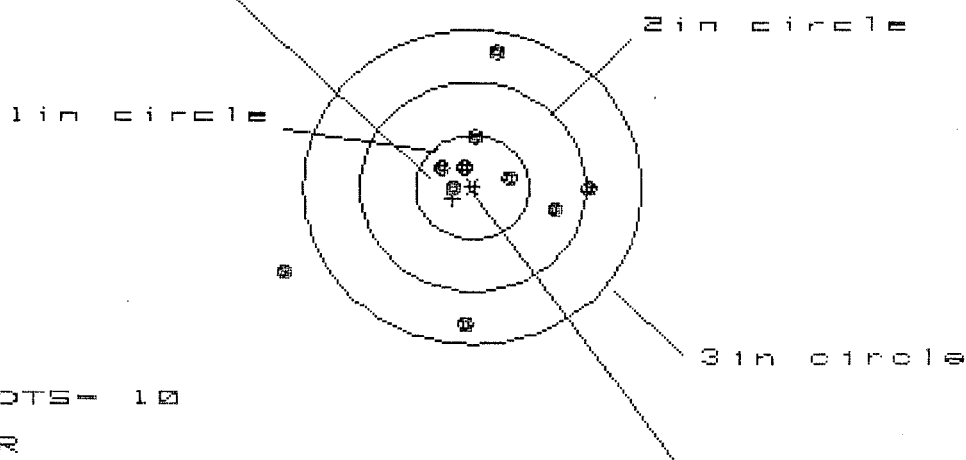
9 May 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 6

3 in = 9

HS= 2.769

VS= 2.621

GS= 2.879

CENTROID #

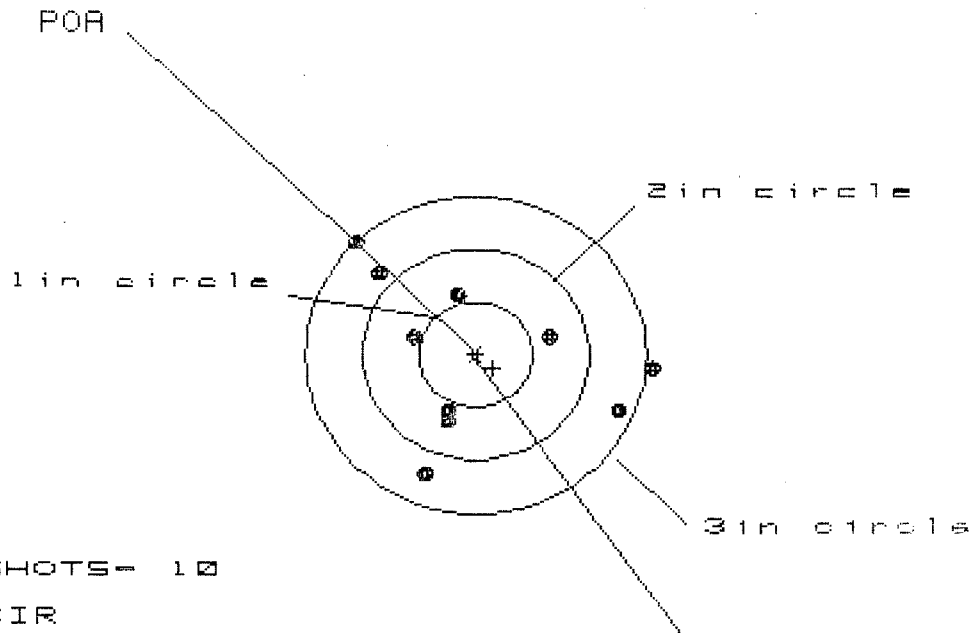
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.058	.868	.870
MINIMUM X	:	-1.711	-.506	-.504
MAXIMUM Y	:	1.327	1.241	.515
MINIMUM Y	:	-1.294	-1.380	-1.225
CENTROID X	:	.176	.366	.364
CENTROID Y	:	.109	.195	.040
POA TO CENTROID in.	:	.207	.415	.367
MIN RADIUS	:	.178	.115	.199
MEAN RADIUS	:	.788	.648	.594
MAX RADIUS	:	1.877	1.402	1.249
HORIZONTAL SPREAD	:	2.769	1.374	1.374
VERTICAL SPREAD	:	2.621	2.621	1.740
EXTREME SPREAD	:	2.879	2.634	1.743
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.552

VS= 2.214

GS= 2.823

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.551	1.467	1.363
MINIMUM X	-1.001	-0.828	-0.781
MAXIMUM Y	1.105	1.093	0.857
MINIMUM Y	-1.109	-1.121	-0.984
CENTROID X	-0.152	-0.325	-0.231
CENTROID Y	0.130	0.142	0.006
POA TO CENTROID in.	0.200	0.354	0.221
MIN RADIUS	0.540	0.415	0.367
MEAN RADIUS	0.983	0.894	0.770
MAX RADIUS	1.555	1.547	1.419
HORIZONTAL SPREAD	2.552	2.295	2.144
VERTICAL SPREAD	2.214	2.214	1.041
EXTREME SPREAD	2.823	2.790	2.464
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		