

C5611480

MODEL 700™ M24

Model **SWS**

Action _____™

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.

Remington

Sinclair®

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

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

MODEL 700TM M24

SERIAL NO.
 C6611480

ORDER NO.
5716

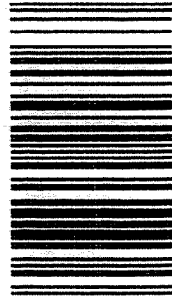
MADE IN ILLION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

46



5716 C6611480

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611480**

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		"	KR
615	Rollmark Caliber		3/27/91	SL
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		3-12-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/18/91	K.S.
	D) Oil Firing Pin Ass'y		4/18/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/22/91	SL

op. NAME	BARBER - M24 0077599	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-22-91	DH
	G) Safety Off Force	2 1/4	2 1/2	3			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/22/91	M
	I) Firing Pin Indent	.020	.021	.020			4-22-91	DH
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						4-30-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4-23-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-23-91	NF
655	Final Inspection							
	A) Headspace						4-30-91	DH
	B) Trigger Pull	2.60	2.63	2.65	2.61	2.58	4/26/91	RC
	C) Function						4-30-91	DH
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO.

C-6611480

DATE

4/22/91

TESTER

J. J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.47	2.43	2.60	MIN. SETTING,
PULL #2	2.35	2.41	2.48	2.63	NO AVG. OF 5
PULL #3	2.33	2.42	2.49	2.65	READINGS ACCEPT-
PULL #4	2.38	2.43	2.36	2.66	ABLE LESS THAN 2#
PULL #5	2.38	2.48	2.43	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.45		
PULL #2	3.25	3.28		
PULL #3	3.22	3.32		
PULL #4	3.33	3.29		
PULL #5	3.32	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	4.55	4.29		4.27
PULL #2	4.48	4.27		4.40
PULL #3	4.56	4.32		4.34
PULL #4	4.25	4.28		4.35
PULL #5	4.29	4.30		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611480
23 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.522946
1 TO	2	.428085
1 TO	3	.426728
1 TO	4	.766984
1 TO	5	.656303

1.4444 <----POR

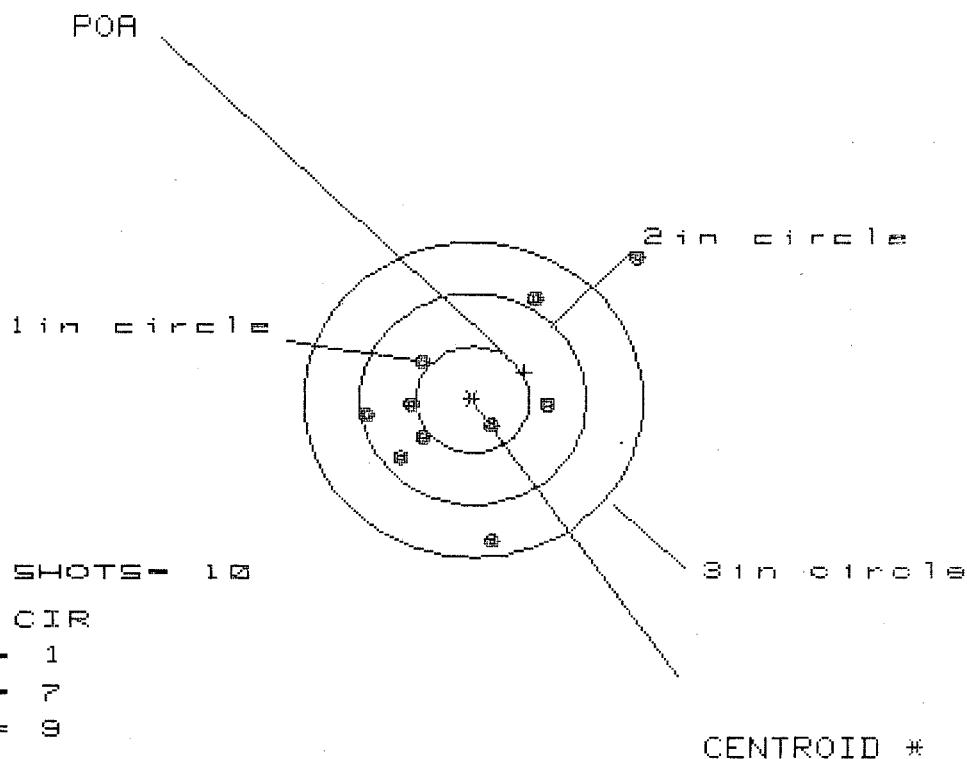
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:

THE AMR FOR THIS RIFLE IS: .9324

23 Apr 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.354

VS= 2.723

GS= 3.021

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.435	.859	.695
MINIMUM X	-.919	-.760	-.724
MAXIMUM Y	1.361	1.129	.943
MINIMUM Y	-1.362	-1.211	-.658
CENTROID X	-.456	-.615	-.651
CENTROID Y	-.256	-.407	-.272
POA TO CENTROID in.	.523	.738	.770
MIN RADIUS	.290	.311	.372
MEAN RADIUS	.893	.723	.655
MAX RADIUS	1.978	1.354	1.253
HORIZONTAL SPREAD	2.354	1.619	1.619
VERTICAL SPREAD	2.723	2.340	1.516
EXTREME SPREAD	3.021	2.385	1.964
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

23 Apr 1991

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CENTERFIRE PATTERNS

2

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= 3.358

VS= 3.348

GS= 3.795

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.310	.947	.944
MINIMUM X	:	-1.048	-.791	-.794
MAXIMUM Y	:	1.906	1.813	1.060
MINIMUM Y	:	-1.442	-1.535	-1.309
CENTROID X	:	-.040	-.297	-.294
CENTROID Y	:	-.155	-.062	-.288
POA TO CENTROID in.	:	.160	.303	.412
MIN RADIUS	:	.348	.075	.258
MEAN RADIUS	:	1.118	.900	.771
MAX RADIUS	:	2.459	1.813	1.559
HORIZONTAL SPREAD	:	3.358	1.738	1.738
VERTICAL SPREAD	:	3.348	3.348	2.369
EXTREME SPREAD	:	3.795	3.459	2.882
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

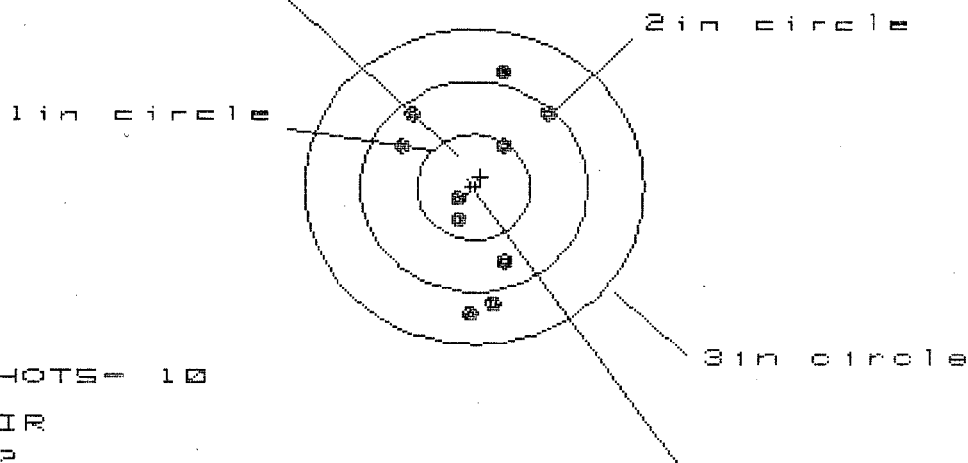
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CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.244

VS= 2.302

GS= 2.324

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.649
MINIMUM X	-.595
MAXIMUM Y	1.143
MINIMUM Y	-1.159
CENTROID X	-.060
CENTROID Y	-.097
POA TO CENTROID in.	.114
MIN RADIUS	.150
MEAN RADIUS	.767
MAX RADIUS	1.169
HORIZONTAL SPREAD	1.244
VERTICAL SPREAD	2.302
EXTREME SPREAD	2.324
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	10

23 Apr 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 4.185

VS = 1.700

GS = 4.189

PATTERN #

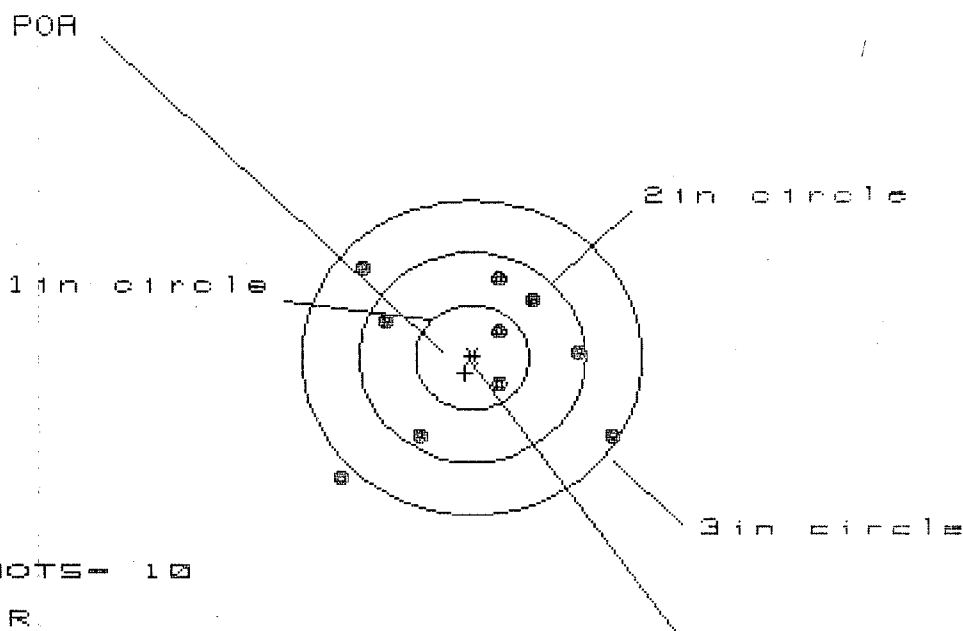
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.199	1.006	.788
MINIMUM X	-1.986	-1.742	-.591
MAXIMUM Y	1.132	1.169	1.194
MINIMUM Y	-.568	-.531	-.506
CENTROID X	.228	-.016	.202
CENTROID Y	.091	.054	.029
POA TO CENTROID in.	.246	.056	.204
MIN RADIUS	.355	.164	.341
MEAN RADIUS	.956	.796	.656
MAX RADIUS	2.224	1.753	1.287
HORIZONTAL SPREAD	4.185	2.748	1.379
VERTICAL SPREAD	1.700	1.700	1.700
EXTREME SPREAD	4.189	2.757	1.817
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

23 Apr 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.391

VS= 1.980

GS= 2.711

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.196	1.063	.934
MINIMUM X	:	-1.195	-1.142	-1.009
MAXIMUM Y	:	.866	.742	.637
MINIMUM Y	:	-1.114	-.904	-1.004
CENTROID X	:	.062	.195	.062
CENTROID Y	:	.147	.271	.376
POA TO CENTROID in.	:	.160	.334	.381
MIN RADIUS	:	.354	.181	.253
MEAN RADIUS	:	.928	.811	.748
MAX RADIUS	:	1.634	1.362	1.193
HORIZONTAL SPREAD	:	2.391	2.205	1.943
VERTICAL SPREAD	:	1.980	1.646	1.646
EXTREME SPREAD	:	2.711	2.711	2.111
NUMBER IN ONE INCH CIRCLE =	:	2	7	9
NUMBER IN TWO INCH CIRCLE =	:	7	9	
NUMBER IN THREE INCH CIRCLE =	:	9		