

C6611570

MODEL 700™ M24

Model **SWS**

™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

MODEL 700™ H24

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

20

SERIAL NO.
C6611570

ORDER NO.
5716


5716 C6611570

UPC


0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611570

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KJ
600	Proof		2/1/91	KJ
607	Check Headspace		2/1/91	KJ
610	Dis-assemble Gun		2/1/91	KJ
612	Magnaflux Barrel Action	2 11 91		KCR
	Magnaflux Bolt	2 11 91		KCR
615	Rollmark Caliber	2 11 91		CS
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		2/2/91	JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4-29-91	DH

op. #	BARBER - M24 0078965	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	6	6	6			4-2-91	DH
	G) Safety Off Force	2 1/2	2	2 1/2			4-2-91	DH
	H) Trigger Pull Test & Retainability						4-2-91	DH
	I) Firing Pin Indent	.021	.021	.021			4-2-91	DH
	J) Assemble Stock						4/8/91	KS
	K) Assemble Swivel Studs						4-10-91	DH
	L) Attach Front and Rear Sight Assemblies						4/8/91	KS
	M) Iron Sight Alignment						4/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/8/91	KS
	O) Attach Scope to Rifle						4/8/91	KS
	P) Detach & Attach Scope 20 Times						4/8/91	KS
640	Gallery Target & Test						4-9-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-9-91	AF
655	Final Inspection							
	A) Headspace						4-10-91	DH
	B) Trigger Pull	2.50	2.41	2.38	2.40	2.36	4/10/91	AF
	C) Function						4-10-91	DH
660	Pack						6-17-91	AF

MOD. _____ GA. _____ GUN # 1570
 CAL. _____ # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
<i>✓</i>	<i>4/9</i>	<i>Bolt Handle hits Stock & Safe binds</i>	<i>KS</i>
	2nd		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

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

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611570

DATE 4-2-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.48	2.411	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.56	2.49	2.41	
PULL #3	2.48	2.50	2.54	2.38	
PULL #4	2.49	2.52	2.50	2.40	
PULL #5	2.51	2.48	2.46	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.13		
PULL #2	3.19	3.11		
PULL #3	3.06	3.12		
PULL #4	3.15	3.09		
PULL #5	3.05	3.14		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.28		4.05
PULL #2	4.37	4.26		4.09
PULL #3	4.38	4.26		4.08
PULL #4	4.29	4.29		4.09
PULL #5	4.31	4.34		4.12
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611570
9 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.162336
1 TO	2	.375405
1 TO	3	.191254
1 TO	4	.272443
1 TO	5	.126491

0.000000 <----POA

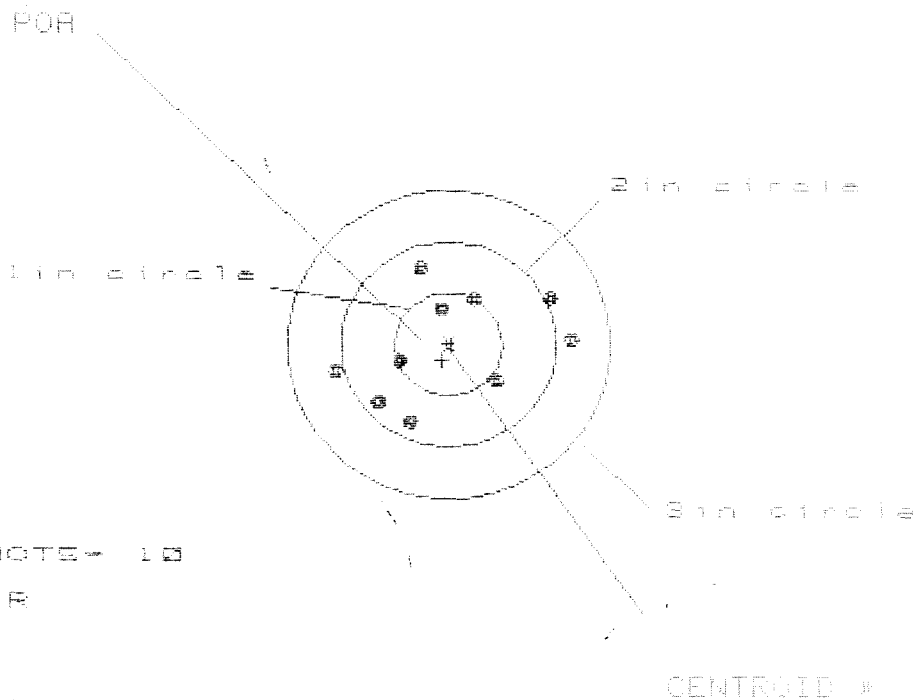
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0244
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0146
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0284345
THE AMR FOR THIS RIFLE IS: .7494

APR 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611570

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.180

VS = 1.560

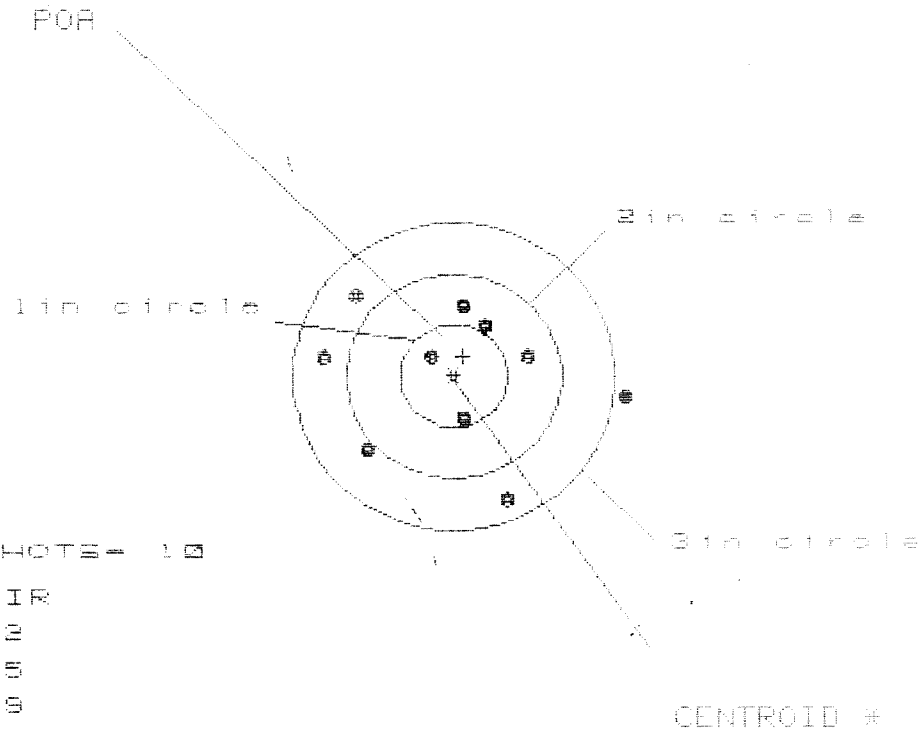
GS = 2.212

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.134	1.111	1.086
MINIMUM X	-1.046	-0.920	-0.856
MAXIMUM Y	.766	.775	.740
MINIMUM Y	-.794	-.785	-.820
CENTROID X	.057	-.069	.046
CENTROID Y	.152	.143	.178
POR TO CENTROID in.	.163	.159	.184
MIN RADIUS	.346	.319	.318
MEAN RADIUS	.763	.709	.673
MAX RADIUS	1.137	1.199	1.080
HORIZONTAL SPREAD	2.180	2.031	1.652
VERTICAL SPREAD	1.560	1.560	1.560
EXTREME SPREAD	2.212	2.159	1.912
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

5 Apr 1991

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CENTERFIRE PATTERNS # 2

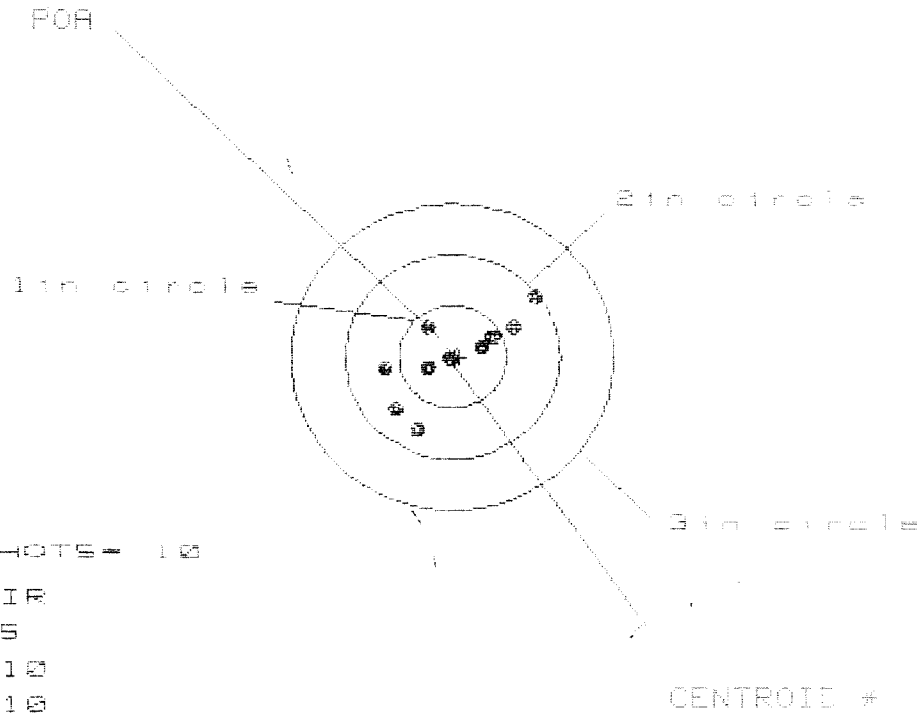


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.614	.856	.936
MINIMUM X	-1.171	-.992	-.986
MAXIMUM Y	.748	.730	.573
MINIMUM Y	-1.239	-1.257	-.854
CENTROID X	-.091	-.278	-.356
CENTROID Y	-.193	-.175	-.018
POA TO CENTROID in.	.214	.322	.356
MIN RADIUS	.280	.159	.039
MEAN RADIUS	.914	.820	.717
MAX RADIUS	1.622	1.432	1.008
HORIZONTAL SPREAD	2.785	1.042	1.042
VERTICAL SPREAD	1.987	1.987	1.427
EXTREME SPREAD	2.866	2.466	1.842
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Apr 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 5

2in = 10

3in = 10

IS = 1.356

VS = 1.227

GS = 1.659

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.761	.674	.640
MINIMUM X	-.595	-.510	-.544
MAXIMUM Y	.552	.356	.280
MINIMUM Y	-.675	-.614	-.511
CENTROID X	-.070	-.155	-.121
CENTROID Y	.009	-.052	.024
POA TO CENTROID in.	.071	.163	.123
MIN RADIUS	.018	.122	.063
MEAN RADIUS	.502	.457	.417
MAX RADIUS	.940	.754	.691
HORIZONTAL SPREAD	1.356	1.184	1.184
VERTICAL SPREAD	1.227	.970	.791
EXTREME SPREAD	1.659	1.343	1.343
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	

9 Apr 1981

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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 = 3

2 in = 6

3 in = 10

HS = 2.356

VS = 2.269

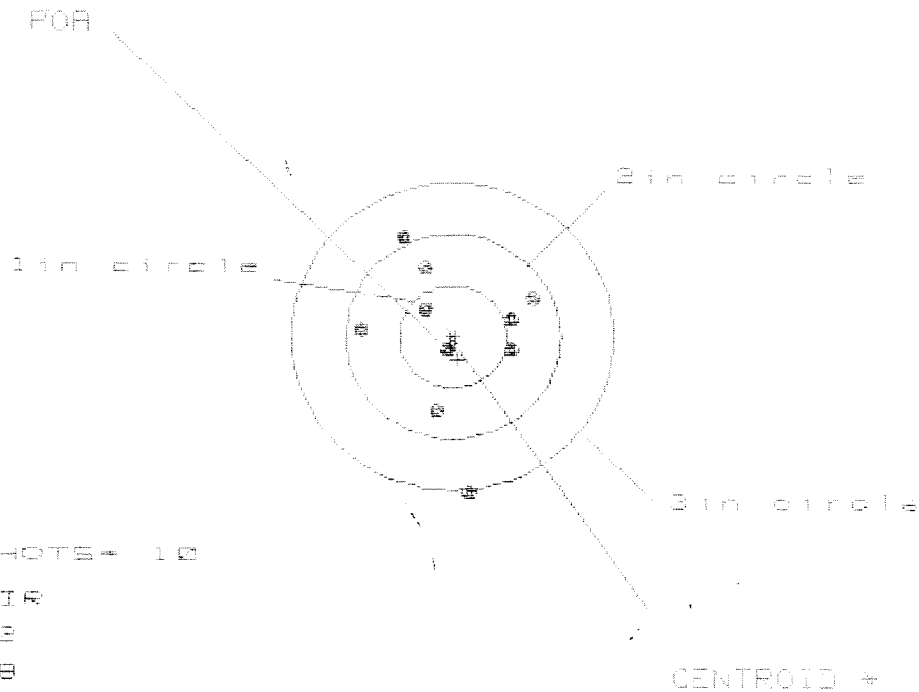
GS = 2.464

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.282	.722	.636
MINIMUM X	-1.084	-.941	-.851
MAXIMUM Y	1.153	1.080	.932
MINIMUM Y	-1.116	-1.189	-.708
CENTROID X	.029	-.113	-.283
CENTROID Y	-.119	-.046	.102
POA TO CENTROID in.	.123	.122	.228
MIN RADIUS	.233	.316	.291
MEAN RADIUS	.828	.740	.645
MAX RADIUS	1.441	1.391	1.128
HORIZONTAL SPREAD	2.366	1.663	1.487
VERTICAL SPREAD	2.269	2.269	1.640
EXTREME SPREAD	2.464	2.276	1.862
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

9 Apr 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

ME = 1.5900

VE = 2.542

CE = 2.604

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.746	.762	.711
MINIMUM X	-.844	-.828	-.879
MAXIMUM Y	1.003	.832	.682
MINIMUM Y	-1.539	-1.908	-1.796
CENTROID X	-.047	-.063	-.012
CENTROID Y	.224	.395	.291
FOR TO CENTROID in.	.229	.400	.291
MIN RADIUS	.146	.224	.221
MEAN RADIUS	.740	.639	.594
MAX RADIUS	1.545	.927	.879
HORIZONTAL SPREAD	1.590	1.590	1.590
VERTICAL SPREAD	2.542	1.732	1.398
EXTREME SPREAD	2.604	1.747	1.525
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		