C6611598

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington
DUPONT
REG. U.S. PAT. & T.M. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24
SERIAL NO.
C6611598
ORDER NO.
5716
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.
46
5716 C6611598
UPC
0 47700 25716 7

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Safe binds	KS
	2nd	Repaired	4/18/91 KS
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

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

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611598

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	
615	Rollmark Caliber	APR	2 1991	
617	Drill and Tap Sight Holes	APR	5 1991	
618	Polish Barrel	APR	5 1991	
620	Apply Coatings (Barrel Action)		4/10/91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/15/91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/15/91	DH
	G) Safety Off Force	3	3	3			4/15/91	DH
	H) Trigger Pull Test & Retainability						4/15/91	DH
	I) Firing Pin Indent	.020	.020	.020			4/15/91	DH
	J) Assemble Stock						4/17/91	KS
	K) Assemble Swivel Studs						4-24-91	DH
	L) Attach Front and Rear Sight Assemblies						4/17/91	KS
	M) Iron Sight Alignment						4/17/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	KS
	O) Attach Scope to Rifle						4/17/91	KS
	P) Detach & Attach Scope 20 Times						4/17/91	KS
640	Gallery Target & Test						4-18-91	DH
	A) Time						4-18-91	DH
	B) Malfunctions						4-18-91	DH
	C) Pierced Primers						4-18-91	DH
	D) Optical Clearity of Scope						4-18-91	DH
645	Inspect for Live Ammo						4-18-91	DH
655	Final Inspection A) Headspace						4-24-91	DH
	B) Trigger Pull	2.16	2.15	2.15	2.18	2.17	4/23/91	DH
	C) Function						4-24-91	DH
660	Pack						6-18-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO C6611598
DATE 4/15/91
TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.36	2.25	2.16	MIN. SETTING,
PULL #2	2.41	2.34	2.20	2.15	NO AVG. OF 5
PULL #3	2.44	2.25	2.36	2.15	READINGS ACCEPT-
PULL #4	2.39	2.18	2.22	2.18	ABLE LESS THAN 2#
PULL #5	2.30	2.23	2.20	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.29		
PULL #2	3.37	3.33		
PULL #3	3.20	3.27		
PULL #4	3.20	3.30		
PULL #5	3.16	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.36		4.28
PULL #2	4.19	4.14		4.13
PULL #3	4.19	4.27		4.26
PULL #4	4.26	4.28		4.16
PULL #5	4.20	4.33		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611598
18 Apr 1991

CENTROIDAL DISTANCES

0	TO	1	.0650692
1	TO	2	.253712
1	TO	3	.191
1	TO	4	.141651
1	TO	5	.330946

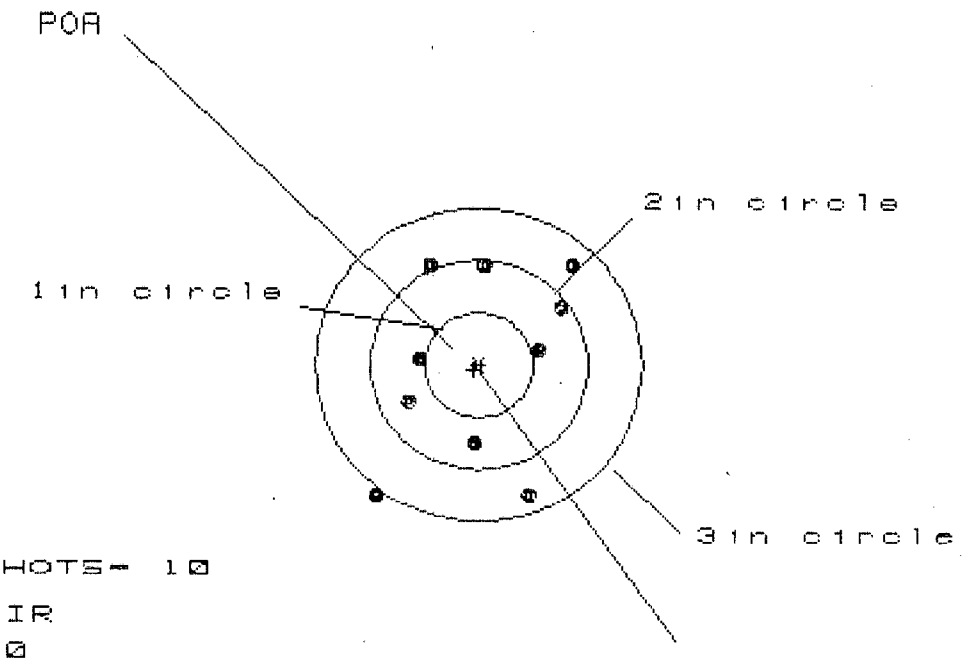
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1352
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .140066

THE AMR FOR THIS RIFLE IS: 1.006

18 Apr 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6811598

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

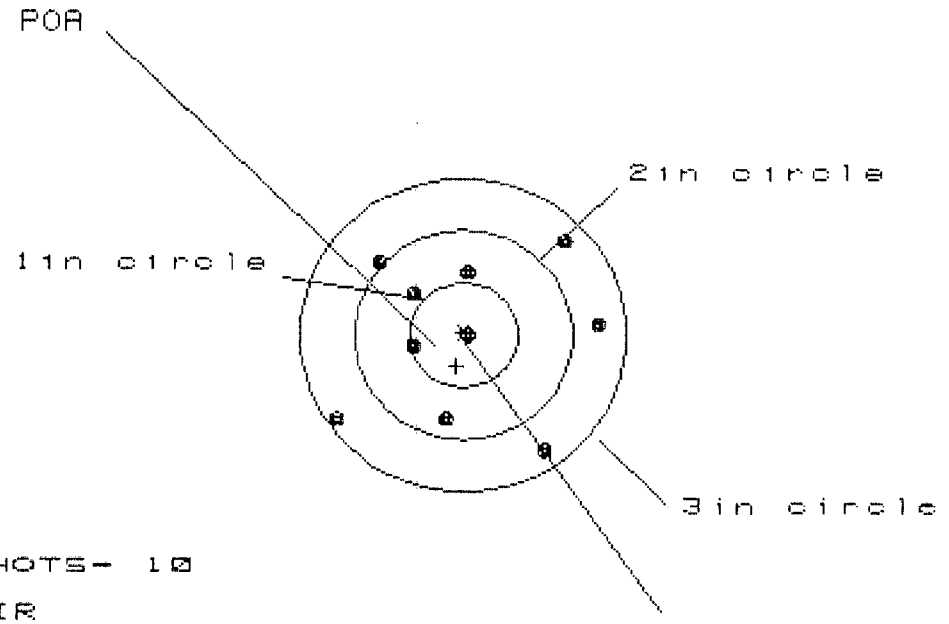
# IN CIR
1in = 0
2in = 6
3in = 9

HS= 1.821
VS= 2.254
GS= 2.893

PATTERN #	:	11		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.838	.729	.770
MINIMUM X	:	-.983	-.713	-.672
MAXIMUM Y	:	.971	.828	.657
MINIMUM Y	:	-1.283	-1.371	-1.063
CENTROID X	:	.045	.154	.113
CENTROID Y	:	.047	.190	.361
POA TO CENTROID in.	:	.065	.244	.378
MIN RADIUS	:	.538	.417	.497
MEAN RADIUS	:	.963	.874	.790
MAX RADIUS	:	1.616	1.408	1.068
HORIZONTAL SPREAD	:	1.821	1.442	1.442
VERTICAL SPREAD	:	2.254	2.199	1.720
EXTREME SPREAD	:	2.893	2.320	1.937
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

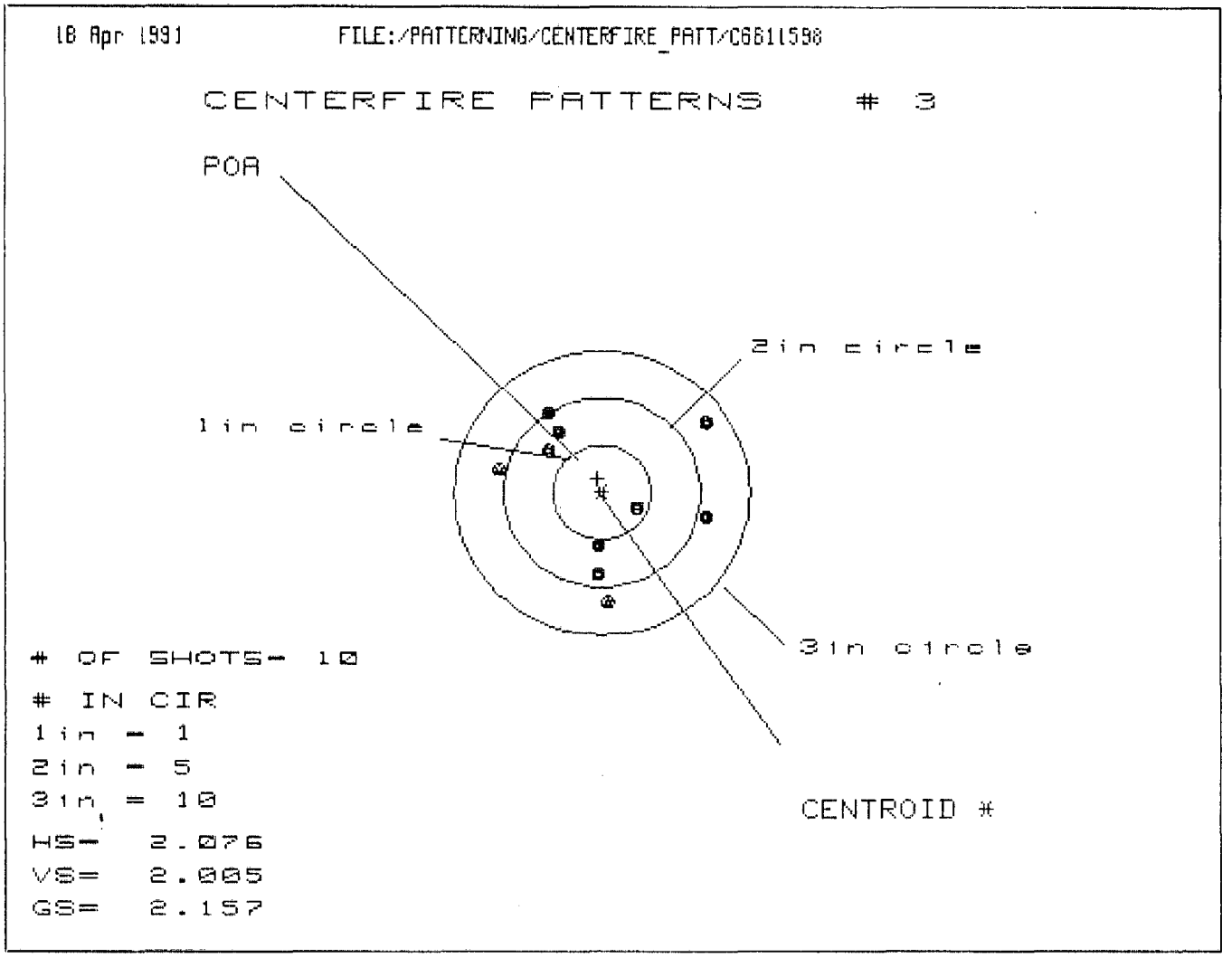
18 Apr 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6611598

CENTERFIRE PATTERNS # 2

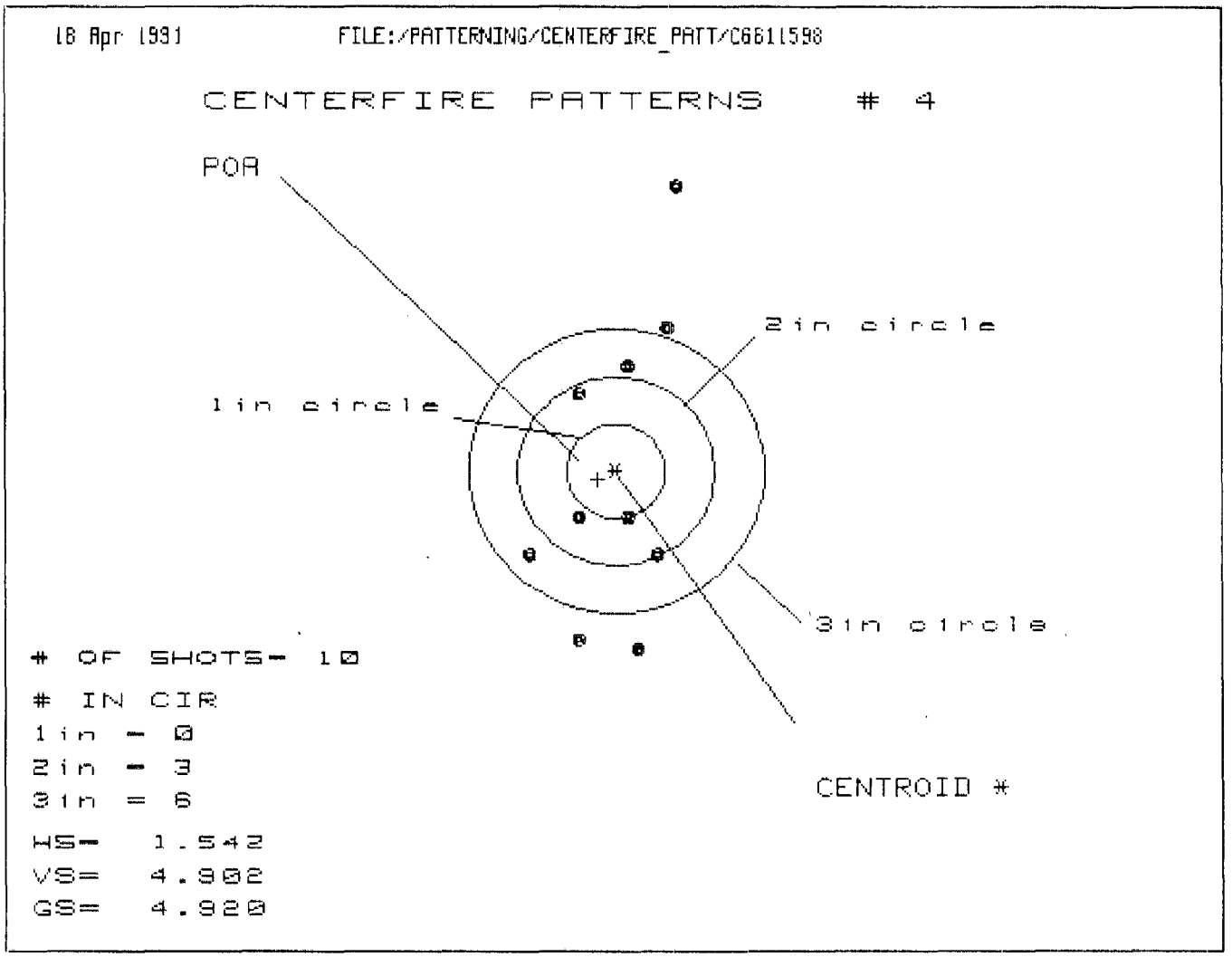


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 5
3in = 10
HS= 2.348
VS= 1.914
GS= 2.677

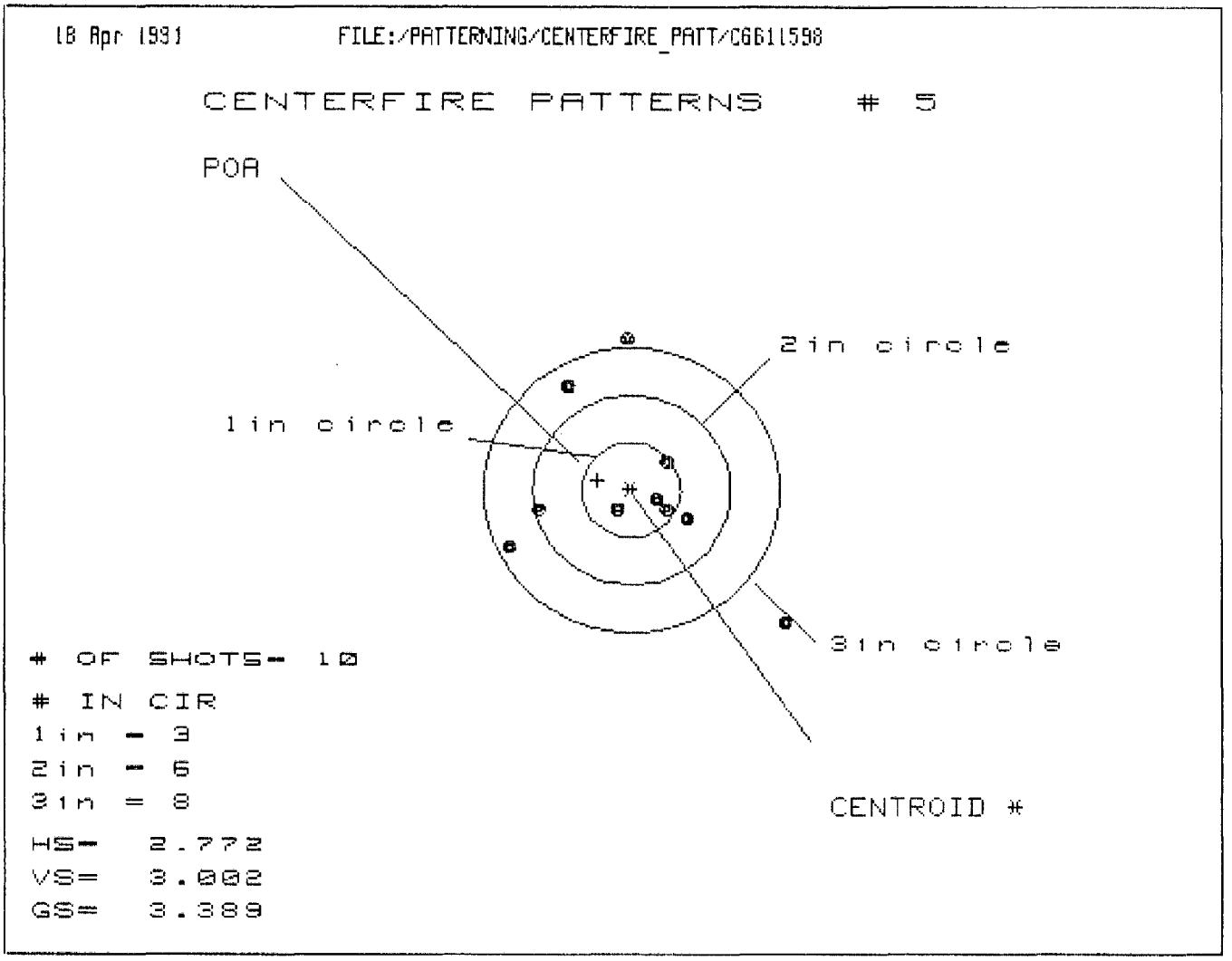
PATTERN #	:	#2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.211	1.084	1.187
MINIMUM X	:	-1.137	-.922	-.819
MAXIMUM Y	:	.860	.769	.750
MINIMUM Y	:	-1.054	-1.145	-1.049
CENTROID X	:	.064	.191	.088
CENTROID Y	:	.300	.391	.295
POA TO CENTROID in.	:	.307	.435	.307
MIN RADIUS	:	.094	.139	.071
MEAN RADIUS	:	.883	.829	.769
MAX RADIUS	:	1.399	1.290	1.259
HORIZONTAL SPREAD	:	2.348	2.006	2.006
VERTICAL SPREAD	:	1.914	1.914	1.799
EXTREME SPREAD	:	2.677	2.353	2.353
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	1.201	1.222
MINIMUM X	:	-.995	-.875	-.854
MAXIMUM Y	:	.876	.961	.831
MINIMUM Y	:	-1.129	-1.044	-.854
CENTROID X	:	.045	-.075	-.096
CENTROID Y	:	-.144	-.229	-.099
POA TO CENTROID in.	:	.151	.241	.137
MIN RADIUS	:	.421	.472	.563
MEAN RADIUS	:	.887	.825	.788
MAX RADIUS	:	1.323	1.217	1.264
HORIZONTAL SPREAD	:	2.076	2.076	2.076
VERTICAL SPREAD	:	2.005	2.005	1.685
EXTREME SPREAD	:	2.157	2.134	2.134
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.638	.563	.599
MINIMUM X	:	-.904	-.833	-.797
MAXIMUM Y	:	2.986	1.829	1.631
MINIMUM Y	:	-1.916	-1.584	-1.612
CENTROID X	:	.182	.111	.075
CENTROID Y	:	.083	-.249	-.051
POA TO CENTROID in.	:	.200	.272	.090
MIN RADIUS	:	.504	.233	.397
MEAN RADIUS	:	1.369	1.101	1.058
MAX RADIUS	:	3.053	1.913	1.737
HORIZONTAL SPREAD	:	1.542	1.396	1.396
VERTICAL SPREAD	:	4.902	3.413	3.243
EXTREME SPREAD	:	4.920	3.424	3.363
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.511	.703	.716
MINIMUM X	:	-1.261	-1.093	-1.080
MAXIMUM Y	:	1.585	1.427	1.099
MINIMUM Y	:	-1.417	-.750	-.571
CENTROID X	:	.340	.172	.159
CENTROID Y	:	-.103	.055	-.123
POA TO CENTROID in.	:	.355	.181	.201
MIN RADIUS	:	.232	.358	.179
MEAN RADIUS	:	.928	.832	.720
MAX RADIUS	:	2.072	1.431	1.222
HORIZONTAL SPREAD	:	2.772	1.796	1.796
VERTICAL SPREAD	:	3.002	2.177	1.670
EXTREME SPREAD	:	3.389	2.485	1.891
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	