

C6349025

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

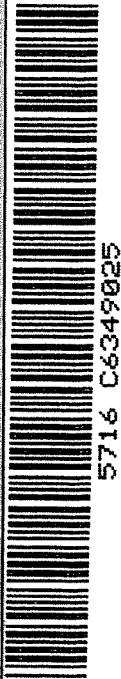
MODEL 700™ H24

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

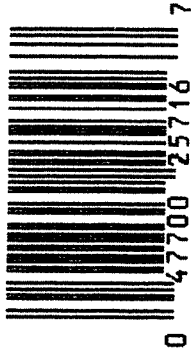
SERIAL NO.
C6349025

ORDER NO.
5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349025

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	3 31	90	RW
607	Check Headspace	3 31	90	RW
610	Dis-assemble Gun	3 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		h.f.
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RW		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/90	JH

BARBER - M24 0106016		READINGS			DATE	INIT
op. #	OP. NAME					
625 cont.	F) Safety On Force	4	4	4	5/2/90	JH
	G) Safety Off Force	2	2	2	5/2/90	JH
	H) Trigger Pull Test & Retainability				5/1/90	JH
	I) Firing Pin Indent	.020	.020	.020	5/2/90	JH
	J) Assemble Stock				5/2/90	RW
	K) Assemble Swivel Studs				5/8/90	WB
	L) Attach Front and Rear Sight Assemblies				5/2/90	RW
	M) Iron Sight Alignment				5/2/90	RW
	N) Detach Front & Rear Sights & place in numbered container				5/2/90	RW
	O) Attach Scope to Rifle				5/2/90	JH
	P) Detach & Attach Scope 20 Times				5/2/90	JH
640	Gallery Target & Test				5-30-90	DH
	A) Time				5-3-90	DH
	B) Malfunctions				5-3-90	DH
	C) Pierced Primers				5-3-90	DH
	D) Optical Clarity of Scope				5-3-90	DH
645	Inspect for Live Ammo				5-3-90	DH
655	Final Inspection				5/8/90	WB
	A) Headspace					
	B) Trigger Pull	2.42	2.38	2.46	2.48	2.31
	C) Function				5/8/90	WB
660	Pack				6-19-90	DH

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

SERIAL NO. C6349025DATE 5/1/90TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.35	2.44	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.46	2.38	2.38	
PULL #3	2.21	2.46	2.32	2.46	
PULL #4	2.48	2.55	2.38	2.48	
PULL #5	2.40	2.37	2.41	2.31	
TOTAL	11.91	12.19	11.93		
AVG.	2.382	2.438	2.386		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.53		
PULL #2	3.52	3.52		
PULL #3	3.36	3.28		
PULL #4	3.51	3.42		
PULL #5	3.42	3.51		
TOTAL	17.33	17.26		
AVG.	3.466	3.452		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.25		4.39
PULL #2	4.21	4.31		4.44
PULL #3	4.21	4.47		4.43
PULL #4	4.18	4.43		4.47
PULL #5	4.11	4.48		4.39
TOTAL	20.92	21.94		22.12
AVG.	4.184	4.388		4.424

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349825
4 May 1990

CENTROIDAL DISTANCES

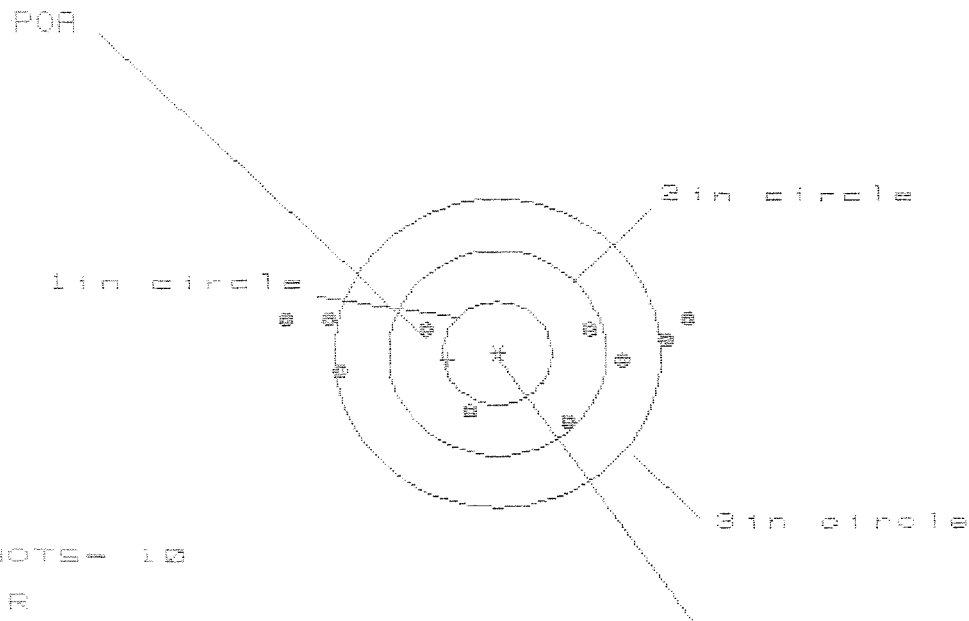
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4 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349025

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 3.643

VS= 1.027

GS= 3.643

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.697	1.481	1.526
MINIMUM X	-1.946	-1.775	-1.590
MAXIMUM Y	.329	.336	.378
MINIMUM Y	-.698	-.661	-.619
CENTROID X	.455	.671	.486
CENTROID Y	.065	.028	-.014
POA TO CENTROID in.	.480	.672	.488
MIN RADIUS	.652	.654	.599
MEAN RADIUS	1.268	1.162	1.116
MAX RADIUS	1.974	1.807	1.634
HORIZONTAL SPREAD	3.643	3.256	3.116
VERTICAL SPREAD	1.027	.997	.997
EXTREME SPREAD	3.643	3.256	3.119
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		6	

4 May 1998

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.530

VS= 2.116

GS= 2.554

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.623

.523

.575

MINIMUM X

:

-.907

-.610

-.558

MAXIMUM Y

:

1.040

.920

.978

MINIMUM Y

:

-1.076

-.925

-.809

CENTROID X

:

.337

.437

.385

CENTROID Y

:

-.246

-.126

-.241

POA TO CENTROID in.

:

.417

.455

.454

MIN RADIUS

:

.457

.382

.409

MEAN RADIUS

:

.766

.679

.631

MAX RADIUS

:

1.407

1.013

.990

HORIZONTAL SPREAD

:

1.530

1.133

1.133

VERTICAL SPREAD

:

2.116

1.845

1.787

EXTREME SPREAD

:

2.554

1.915

1.791

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

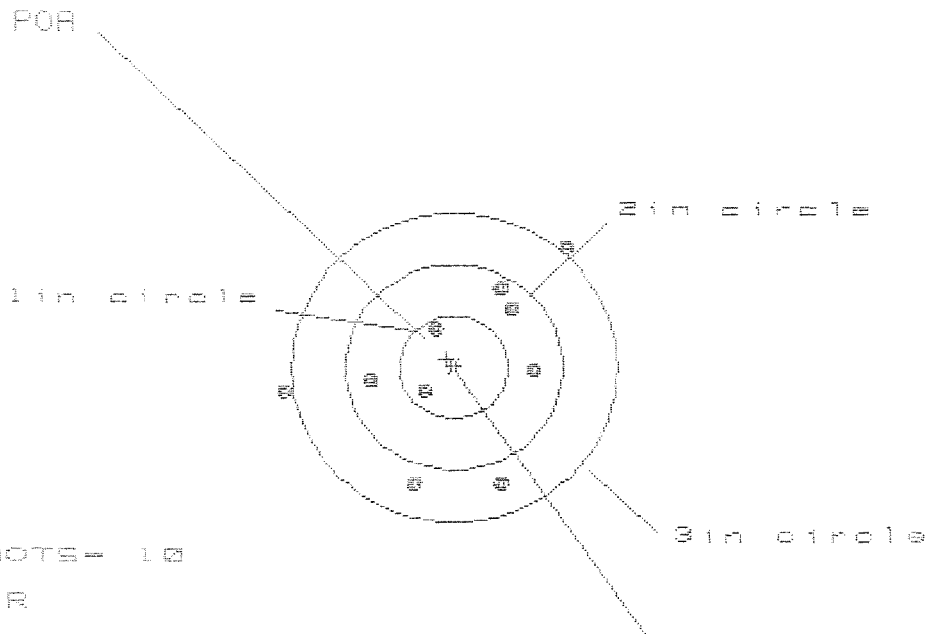
NUMBER IN THREE INCH CIRCLE =

10

4 May 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

ME = 0.500

VSE = 0.326

GSE = 0.854

CENTROID #

PATTERN #	1	3	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.986	.816	.694
MINIMUM X	-1.523	-.901	-.798
MAXIMUM Y	1.154	1.131	.921
MINIMUM Y	-1.172	-1.195	-1.054
CENTROID X	.069	.239	.137
CENTROID Y	-.076	-.053	-.194
POA TO CENTROID (in.)	.183	.244	.237
MIN RADIUS	.387	.489	.387
MEAN RADIUS	.950	.883	.812
MAX RADIUS	1.537	1.395	1.135
HORIZONTAL SPREAD	2.509	1.717	1.493
VERTICAL SPREAD	2.326	2.326	1.975
EXTREME SPREAD	2.854	2.684	2.132
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

4 May 1990

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HG= 2.584

VS= 1.566

GS= 2.702

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.174	1.006	1.088
MINIMUM X	:	-1.510	-1.292	-1.210
MAXIMUM Y	:	.972	.938	.532
MINIMUM Y	:	-.594	-.628	-.511
CENTROID X	:	.225	.393	.311
CENTROID Y	:	.032	.066	-.051
POA TO CENTROID in.	:	.227	.398	.315
MIN RADIUS	:	.410	.306	.327
MEAN RADIUS	:	.890	.812	.752
MAX RADIUS	:	1.541	1.341	1.234
HORIZONTAL SPREAD	:	2.684	2.298	2.298
VERTICAL SPREAD	:	1.566	1.566	1.043
EXTREME SPREAD	:	2.702	2.341	2.339
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

4 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8349025

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.825

VS= 2.257

GS= 2.453

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.743
MINIMUM X	-1.083
MAXIMUM Y	1.294
MINIMUM Y	-.963
CENTROID X	.018
CENTROID Y	-.259
POA TO CENTROID in.	.260
MIN RADIUS	.083
MEAN RADIUS	.843
MAX RADIUS	1.492
HORIZONTAL SPREAD	1.825
VERTICAL SPREAD	2.257
EXTREME SPREAD	2.453
NUMBER IN ONE INCH CIRCLE	= 2
NUMBER IN TWO INCH CIRCLE	= 7
NUMBER IN THREE INCH CIRCLE	= 10