

C6349196

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington DU PONT REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6349196
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6349196

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349196

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT 3 31	90	RW
600	Proof		90	RW
607	Check Headspace		90	RW
610	Dis-assemble Gun		90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		SL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TJA
	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		5/3/90	RL

BARBER - M24 0109933

BARBER - M24 0109933							
op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	4	4	4	5/7/90	RM	
	G) Safety Off Force	3	3	3	5/7/90	RM	
	H) Trigger Pull Test & Retainability				5/3/90	RM	
	I) Firing Pin Indent	.020	.020	.0205	5/7/90	RM	
	J) Assemble Stock				5/8/90	RW	
	K) Assemble Swivel Studs				5/10/90	WB	
	L) Attach Front and Rear Sight Assemblies				5/8/90	RW	
	M) Iron Sight Alignment				5/8/90	RW	
	N) Detach Front & Rear Sights & place in numbered container				5/8/90	RW	
	O) Attach Scope to Rifle				5/8/90	WB	
	P) Detach & Attach Scope 20 Times				5/8/90	WB	
640	Gallery Target & Test				5-8-90	DAH	
	A) Time				5-8-90	DAH	
	B) Malfunctions				5-8-90	DAH	
	C) Pierced Primers				5-8-90	DAH	
	D) Optical Clarity of Scope				5-8-90	DAH	
645	Inspect for Live Ammo				5-8-90	DAH	
655	Final Inspection				5/10/90	WB	
	A) Headspace						
	B) Trigger Pull	2.46	2.50	2.60	2.38	2.65	5/9/90
	C) Function				5/10/90	WB	
660	Pack				4/29/90	Kef.	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6349196

DATE 5/2/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.38	2.43	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.36	2.40	2.50	
PULL #3	2.32	2.43	2.26	2.60	
PULL #4	2.17	2.28	2.32	2.38	
PULL #5	2.27	2.33	2.35	2.65	
TOTAL	11.54	11.78	11.76		
AVG.	2.308	2.356	2.352		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.26		
PULL #2	3.47	3.19		
PULL #3	3.32	3.18		
PULL #4	3.19	3.26		
PULL #5	3.21	3.12		
TOTAL	16.70	16.01		
AVG.	3.34	3.202		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.35		4.46
PULL #2	4.53	4.42		4.30
PULL #3	4.21	4.47		4.31
PULL #4	4.38	4.33		4.29
PULL #5	4.42	4.40		4.23
TOTAL	21.86	21.97		21.59
AVG.	4.372	4.394		4.318

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349196
9 May 1990

CENTROIDAL DISTANCES

0 TO	1	.0850941
1 TO	2	.11183
1 TO	3	.347071
1 TO	4	.309584
1 TO	5	.165324

POI <----POI

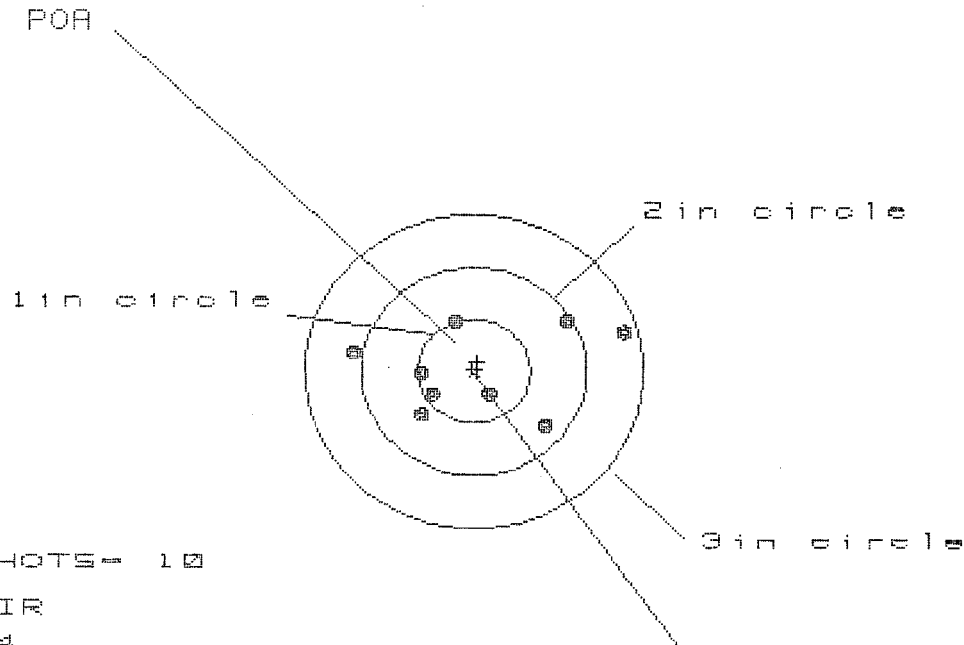
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .142
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0334
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145875
THE AMR FOR THIS RIFLE IS: .7024

9 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349196

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.402

VS= 1.010

GS= 2.415

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.355	.958	.846
MINIMUM X	:	-1.047	-.896	-.442
MAXIMUM Y	:	.514	.559	.582
MINIMUM Y	:	-.496	-.451	-.428
CENTROID X	:	-.029	-.180	-.068
CENTROID Y	:	-.080	-.125	-.148
POA TO CENTROID in.	:	.086	.219	.163
MIN RADIUS	:	.256	.278	.225
MEAN RADIUS	:	.703	.580	.551
MAX RADIUS	:	1.412	1.108	1.026
HORIZONTAL SPREAD	:	2.402	1.854	1.288
VERTICAL SPREAD	:	1.010	1.010	1.010
EXTREME SPREAD	:	2.415	1.890	1.599
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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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 = 4

2 in = 9

3 in = 9

HS= 2.147

VS= 1.172

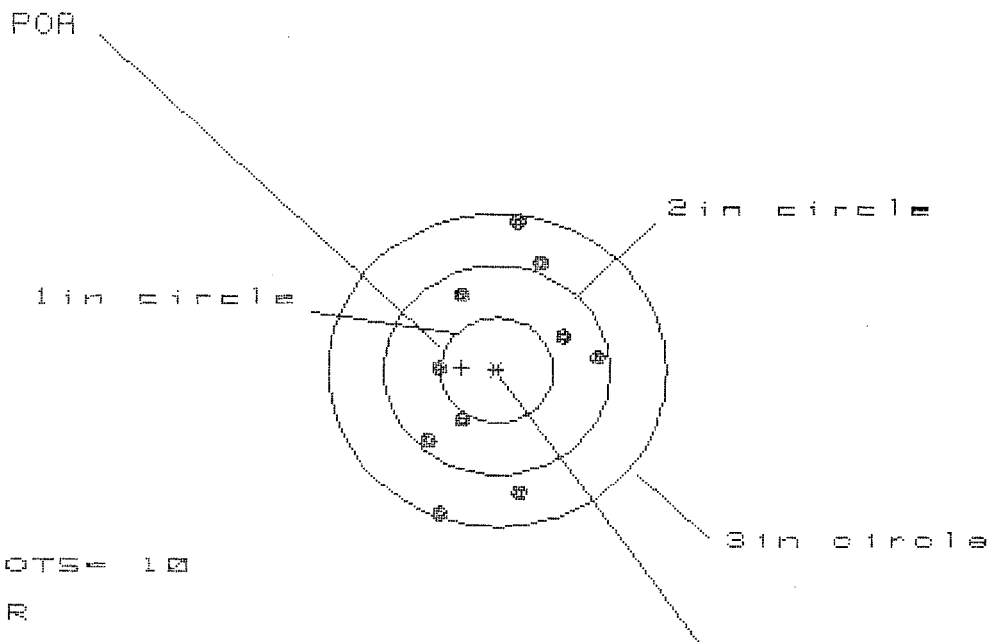
GS= 2.310

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.412	.769	.697
MINIMUM X	-.735	-.579	-.465
MAXIMUM Y	.712	.770	.735
MINIMUM Y	-.460	-.402	-.437
CENTROID X	.080	-.076	-.004
CENTROID Y	-.055	-.113	-.078
POA TO CENTROID in.	.097	.136	.078
MIN RADIUS	.086	.118	.055
MEAN RADIUS	.607	.483	.455
MAX RADIUS	1.504	.829	.787
HORIZONTAL SPREAD	2.147	1.348	1.162
VERTICAL SPREAD	1.172	1.172	1.172
EXTREME SPREAD	2.310	1.455	1.455
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 1.497

VS = 2.793

GS = 2.903

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.915	.849
MINIMUM X	-.608	-.582	-.648
MAXIMUM Y	1.447	1.205	1.056
MINIMUM Y	-1.346	-1.185	-1.170
CENTROID X	.314	.288	.354
CENTROID Y	-.027	-.188	-.040
POA TO CENTROID in.	.315	.344	.356
MIN RADIUS	.493	.448	.533
MEAN RADIUS	.963	.894	.840
MAX RADIUS	1.466	1.298	1.180
HORIZONTAL SPREAD	1.497	1.497	1.497
VERTICAL SPREAD	2.793	2.390	2.227
EXTREME SPREAD	2.903	2.573	2.236
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6349196

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.704

VS= 1.493

GS= 1.941

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.594	.471	.527
MINIMUM X	-1.110	-.786	-.730
MAXIMUM Y	.630	.643	.536
MINIMUM Y	-.863	-.850	-.556
CENTROID X	.280	.403	.347
CENTROID Y	-.061	-.074	.033
POA TO CENTROID in.	.286	.410	.349
MIN RADIUS	.275	.342	.224
MEAN RADIUS	.689	.628	.574
MAX RADIUS	1.115	.961	.917
HORIZONTAL SPREAD	1.704	1.257	1.257
VERTICAL SPREAD	1.493	1.493	1.092
EXTREME SPREAD	1.941	1.753	1.466
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 10

HS = 1.186

VS = 1.931

GS = 1.935

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.518	.529	.527
MINIMUM X	-.668	-.657	-.659
MAXIMUM Y	1.076	.638	.546
MINIMUM Y	-.855	-.736	-.481
CENTROID X	.065	.054	.056
CENTROID Y	.056	-.063	.029
POA TO CENTROID in.	.086	.083	.063
MIN RADIUS	.069	.114	.058
MEAN RADIUS	.550	.503	.449
MAX RADIUS	1.080	.736	.774
HORIZONTAL SPREAD	1.186	1.186	1.186
VERTICAL SPREAD	1.931	1.374	1.027
EXTREME SPREAD	1.935	1.399	1.313
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	