C634705

MODEL 700™ M24

Model SWS™

Action

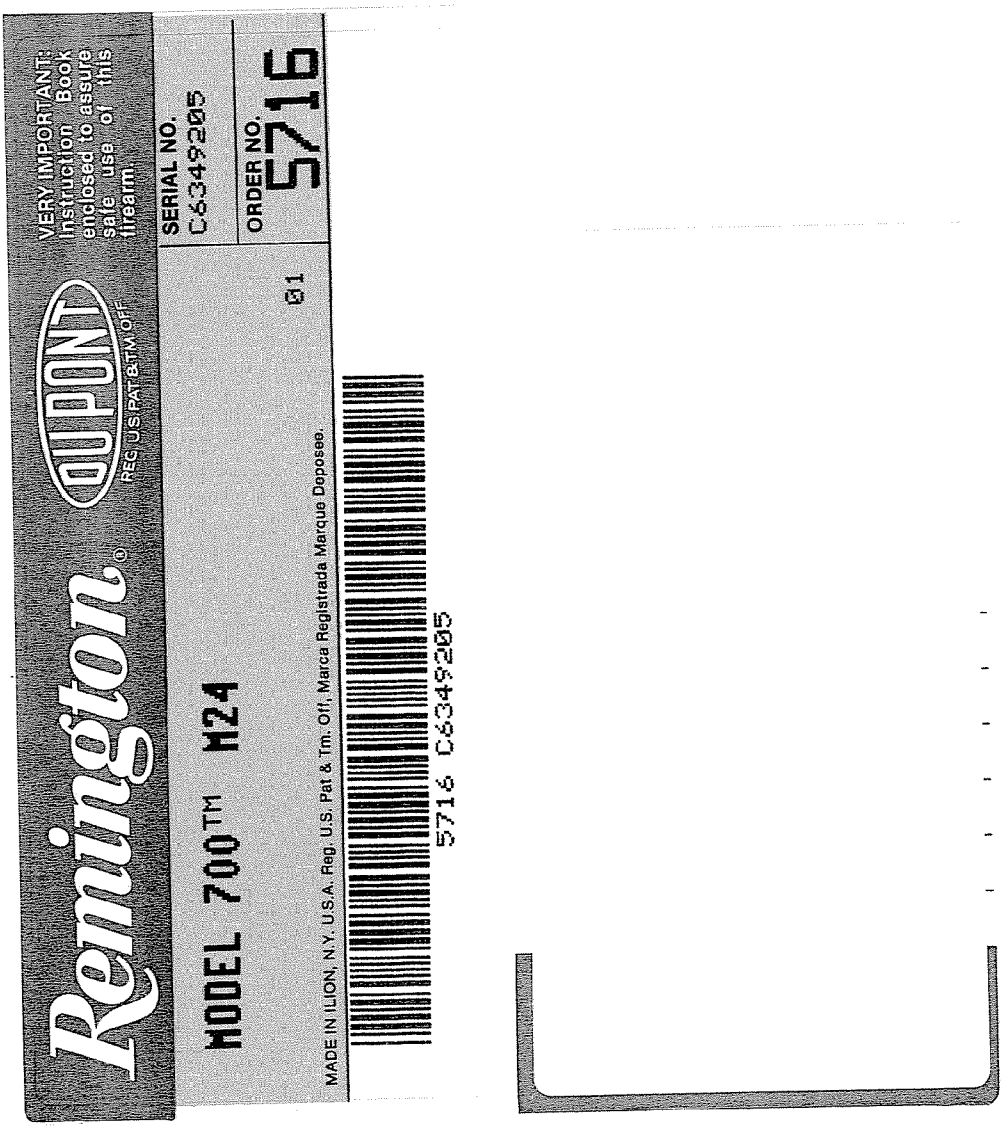
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®


UPC
0 47700 25716 7
Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24
SERIAL NO. C6349205
ORDER NO. 5716
01
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.
5716 C6349205

R Barber 2 Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349205

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20	89	RW
600	Proof	12-20	89	
607	Check Headspace	12-20	89	
610	Dis-assemble Gun	12-[illegible]	89	RW
612	Magnaflux Barrel Action	1-5-90		KeR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/5/90	GS
617	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		22 Jan 90	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-22-90	JH
	G) Safety Off Force	4	4	4			1-22-90	JH
	H) Trigger Pull Test & Retainability						22 Jan 90	JH
	I) Firing Pin Indent	.021	.021	.021			1-22-90	JH
	J) Assemble Stock						1-29-90	AC
	K) Assemble Swivel Studs						2/25/90	WB
	L) Attach Front and Rear Sight Assemblies						1-29-90	AC
	M) Iron Sight Alignment						1-29-90	AC
	N) Detach Front & Rear Sights & place in numbered container						1-29-90	AC
	O) Attach Scope to Rifle						2/26/90	WB
	P) Detach & Attach Scope 20 Times						2/26/90	WB
640	Gallery Target & Test						2-26-90	AC
	A) Time						11	AC
	B) Malfunctions						11	AC
	C) Pierced Primers						11	AC
	D) Optical Clearity of Scope						11	AC
645	Inspect for Live Ammo						2-26-90	AC
655	Final Inspection A) Headspace						2/28/90	WB
	B) Trigger Pull	2.54	2.58	2.54	2.53	2.52	2/27/90	WB
	C) Function						2/28/90	WB
660	Pack						20 Mar 90	JH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349205
DATE 22 Jan 90
TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.17	2.46	2.55	MIN. SETTING,
PULL #2	2.32	2.40	2.26	2.61	NO AVG. OF 5
PULL #3	2.37	2.34	2.36	2.52	READINGS ACCEPT-
PULL #4	2.25	2.32	2.40	2.55	ABLE LESS THAN 2#
PULL #5	2.32	2.37	2.49	2.47	
TOTAL	11.61	11.60	11.97	12.70	
AVG.	2.322	2.32	2.394	2.54	

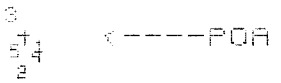
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.95	3.10		
PULL #2	2.91	3.12		
PULL #3	2.59	2.99		
PULL #4	2.85	3.12		
PULL #5	2.81	3.15		
TOTAL	14.11	15.48		
AVG.	2.822	3.096		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.03		3.97
PULL #2	4.16	3.91		3.88
PULL #3	3.65	4.28		3.66
PULL #4	4.26	4.16		3.94
PULL #5	4.21	4.13		3.90
TOTAL	20.64	20.51		19.34
AVG.	4.148	4.102		3.868

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349205
27 Feb 1990

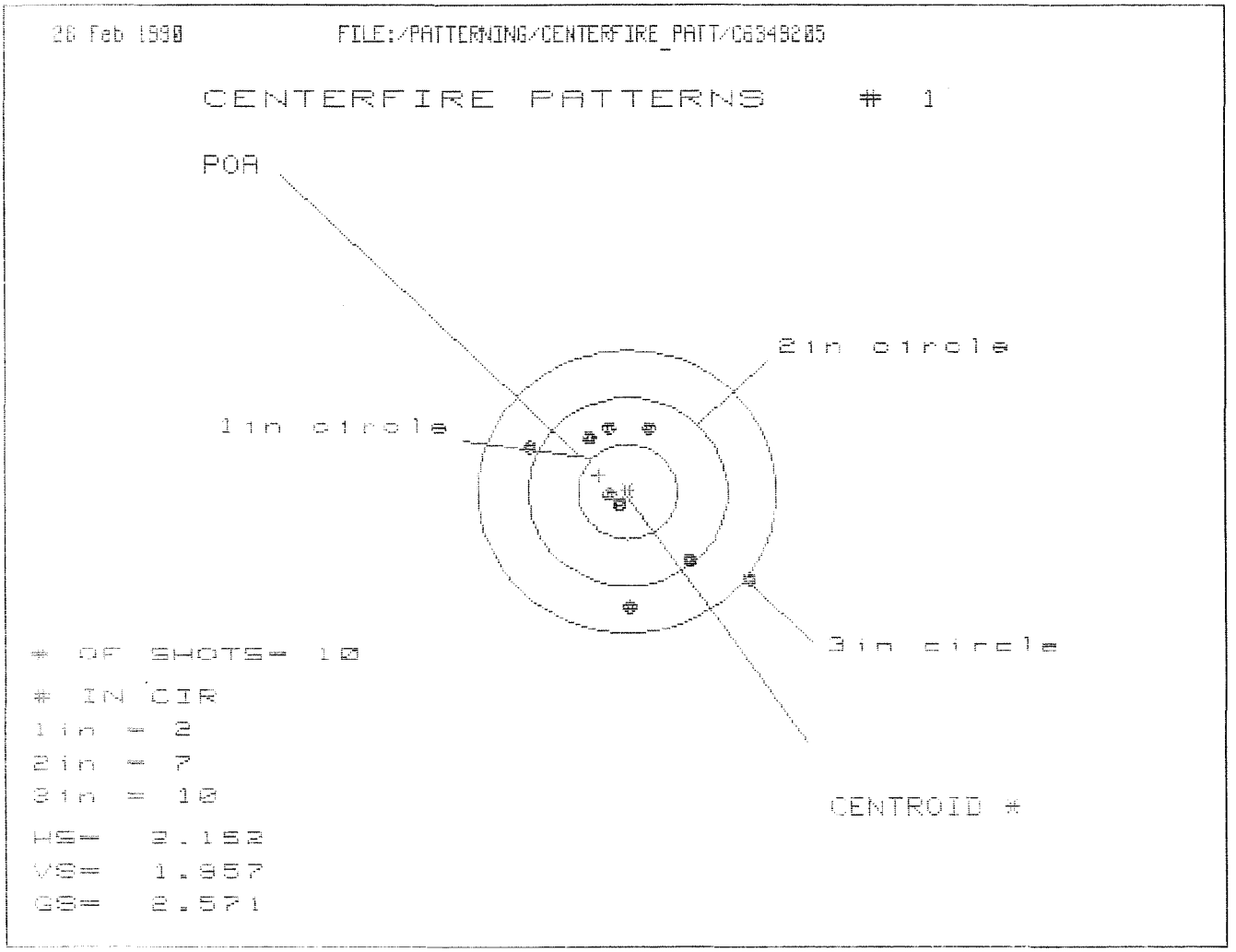
CENTROIDAL DISTANCES

0	TO	1	.332737
1	TO	2	.586121
1	TO	3	.792881
1	TO	4	.165082
1	TO	5	.478357

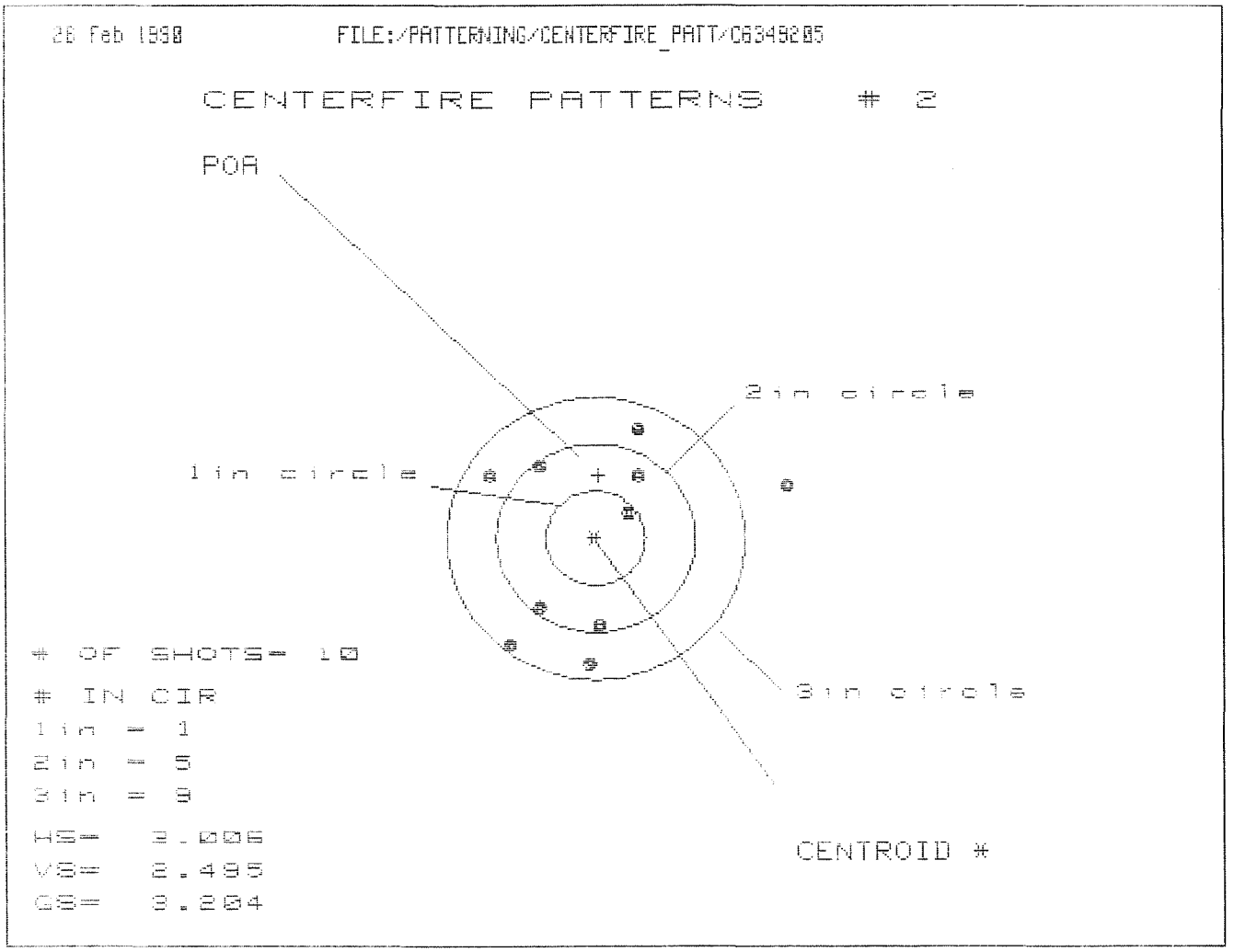


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .012
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204353

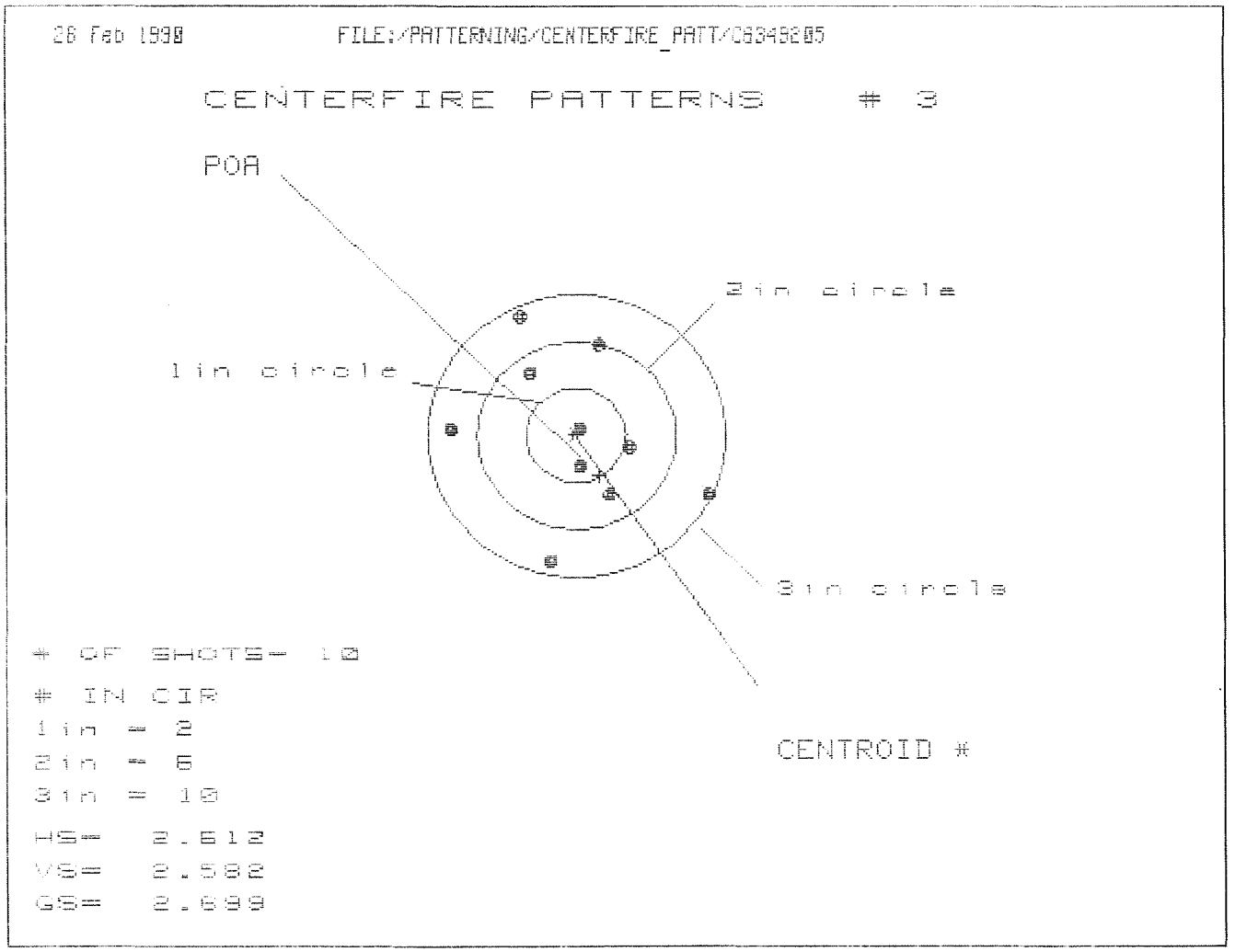
THE AMR FOR THIS RIFLE IS: .9454



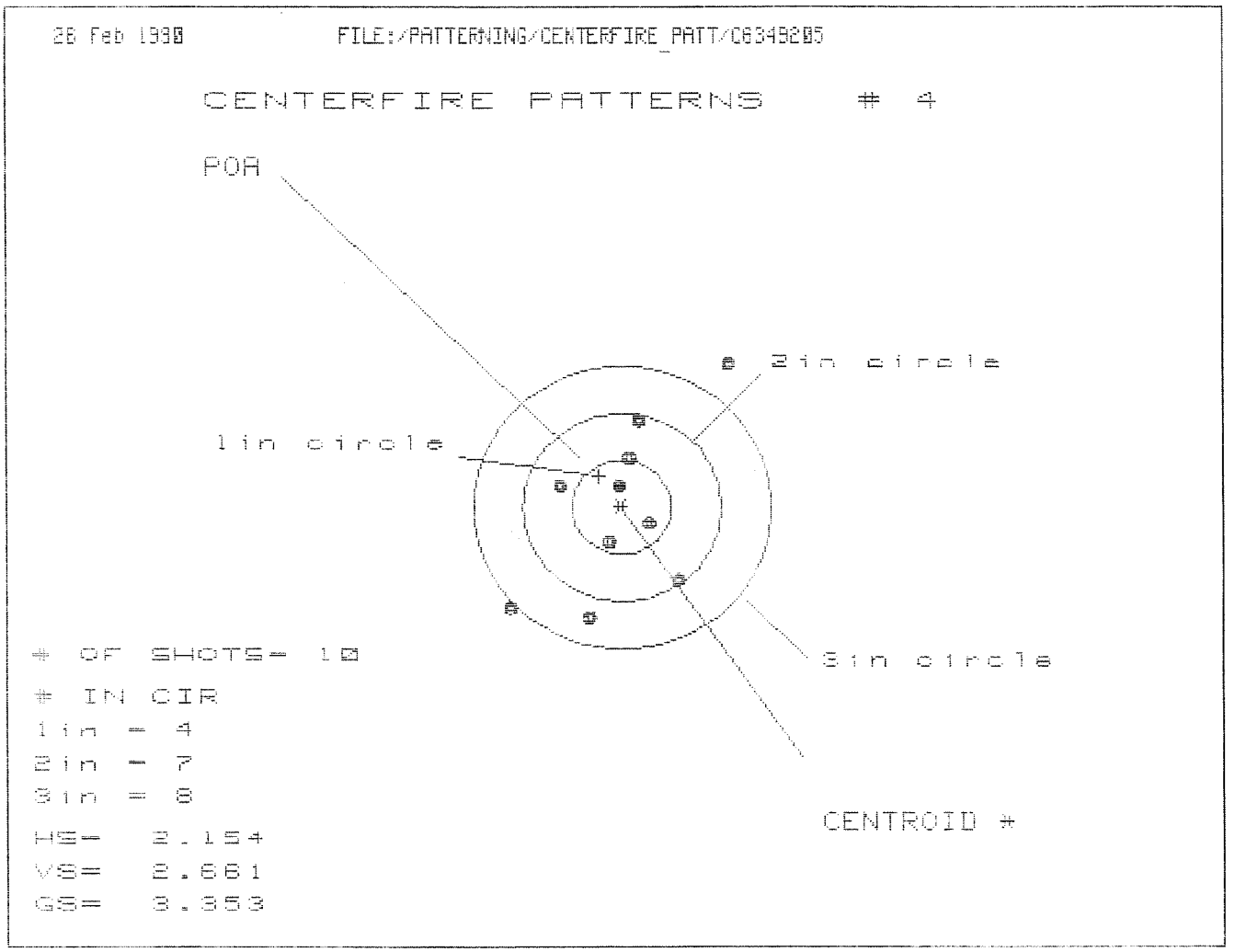
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.184	.757	.775
MINIMUM X	:	-.968	-.837	-.820
MAXIMUM Y	:	.703	.601	.432
MINIMUM Y	:	-1.254	-1.356	-.962
CENTROID X	:	.283	.152	.134
CENTROID Y	:	-.175	-.073	.096
POA TO CENTROID in.	:	.333	.169	.165
MIN RADIUS	:	.190	.185	.335
MEAN RADIUS	:	.793	.679	.564
MAX RADIUS	:	1.498	1.363	1.235
HORIZONTAL SPREAD	:	2.152	1.594	1.594
VERTICAL SPREAD	:	1.957	1.957	1.394
EXTREME SPREAD	:	2.571	1.997	1.983
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



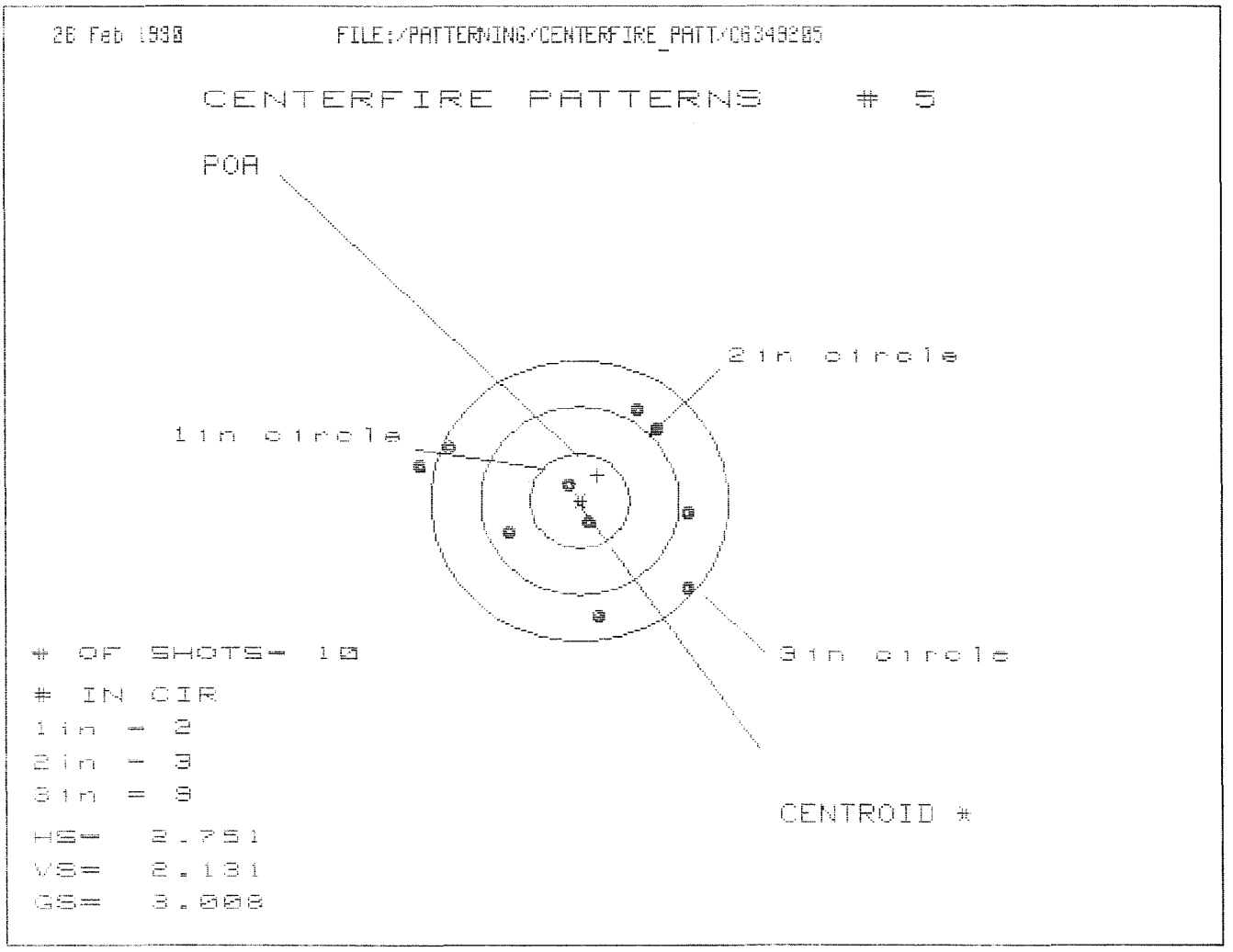
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.899	.630	.552
MINIMUM X	:	-1.107	-.896	-.974
MAXIMUM Y	:	1.200	1.262	1.132
MINIMUM Y	:	-1.295	-1.233	-1.363
CENTROID X	:	-.034	-.245	-.167
CENTROID Y	:	-.668	-.730	-.600
POA TO CENTROID in.	:	.669	.771	.623
MIN RADIUS	:	.489	.697	.566
MEAN RADIUS	:	1.139	1.036	.996
MAX RADIUS	:	1.980	1.411	1.367
HORIZONTAL SPREAD	:	3.006	1.526	1.526
VERTICAL SPREAD	:	2.495	2.495	2.495
EXTREME SPREAD	:	3.204	2.628	2.537
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	.668	.614
MINIMUM X	:	-1.277	-1.129	-1.183
MAXIMUM Y	:	1.258	1.193	1.037
MINIMUM Y	:	-1.324	-1.389	-1.240
CENTROID X	:	-.233	-.381	-.327
CENTROID Y	:	.427	.492	.343
POA TO CENTROID in.	:	.487	.622	.474
MIN RADIUS	:	.056	.190	.182
MEAN RADIUS	:	.889	.845	.768
MAX RADIUS	:	1.457	1.396	1.255
HORIZONTAL SPREAD	:	2.612	1.797	1.797
VERTICAL SPREAD	:	2.582	2.582	2.277
EXTREME SPREAD	:	2.699	2.599	2.340
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.736	.612
MINIMUM X	:	-1.112	-.996	-.662
MAXIMUM Y	:	1.532	1.111	1.002
MINIMUM Y	:	-1.129	-.959	-1.068
CENTROID X	:	.229	.113	.237
CENTROID Y	:	-.331	-.501	-.392
POA TO CENTROID in.	:	.402	.513	.459
MIN RADIUS	:	.276	.201	.323
MEAN RADIUS	:	.871	.758	.668
MAX RADIUS	:	1.853	1.321	1.114
HORIZONTAL SPREAD	:	2.154	1.732	1.274
VERTICAL SPREAD	:	2.661	2.070	2.070
EXTREME SPREAD	:	3.353	2.379	2.135
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.111	.929	.738
MINIMUM X	:	-1.640	-1.526	-1.133
MAXIMUM Y	:	.926	.963	1.034
MINIMUM Y	:	-1.205	-1.168	-1.097
CENTROID X	:	-.185	-.003	.188
CENTROID Y	:	-.274	-.311	-.383
POA TO CENTROID in.	:	.331	.311	.426
MIN RADIUS	:	.210	.219	.287
MEAN RADIUS	:	1.035	.952	.865
MAX RADIUS	:	1.674	1.629	1.153
HORIZONTAL SPREAD	:	2.751	2.455	1.871
VERTICAL SPREAD	:	2.131	2.131	2.131
EXTREME SPREAD	:	3.008	2.832	2.137
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	