C664907Z

MODEL 700™ M24

Model SWS

Action TL

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

Remington®
DUPONT
REG U.S.PAT&TM OFF
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.
MODEL 700™ M24
20
SERIAL NO.
C6649072
ORDER NO.
5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.
5716 C6649072
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649072

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KA
600	Proof		6/25/91	KA
607	Check Headspace		6/25/91	KA
610	Dis-assemble Gun		6/25/91	KA
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	DS.
617	Drill and Tap Sight Holes	JUL	1 1991	[illegible]
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	[illegible]
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/91	KA
	C) Inspect Ejector Hole for Chamfer		8/1/91	KA
	D) Oil Firing Pin Ass'y		8/1/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-2-91	[illegible]

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-2-91	
	G) Safety Off Force	4	4	4			8-2-91	
	H) Trigger Pull Test & Retainability						8-2-91	
	I) Firing Pin Indent	.0205	.0205	.0205			8-2-91	
	J) Assemble Stock						8/7/91	KS
	K) Assemble Swivel Studs						8-8-91	DH
	L) Attach Front and Rear Sight Assemblies						8/7/91	KS
	M) Iron Sight Alignment						8/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	KS
	O) Attach Scope to Rifle						8/7/91	KS
	P) Detach & Attach Scope 20 Times						8/7/91	KS
640	Gallery Target & Test						8/8/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clearity of Scope						"	KT
645	Inspect for Live Ammo						8/8/91	KT
655	Final Inspection A) Headspace						8-8-91	DH
	B) Trigger Pull	2.33	2.24	2.35	2.36	2.32	8-9-91	
	C) Function						8-8-91	DH
660	Pack						9-19-91	

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF		shot ok test	
TEST			
TGT		8-9-91	AC
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

MOD. _____ GA. _____ CAL. _____ GUN # 4072

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
1st	1st	Ejector Stick Shim Brass	KS
	2nd		
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649072

DATE 8-2-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.63	2.60	2.33	MIN. SETTING,
PULL #2	2.54	2.53	2.58	2.24	NO AVG. OF 5
PULL #3	2.61	2.54	2.50	2.35	READINGS ACCEPT-
PULL #4	2.57	2.60	2.53	2.36	ABLE LESS THAN 2#
PULL #5	2.57	2.58	2.53	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.38		
PULL #2	3.36	3.43		
PULL #3	3.49	3.42		
PULL #4	3.37	3.38		
PULL #5	3.37	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.68	4.39		4.54
PULL #2	4.41	4.60		4.42
PULL #3	4.35	4.61		4.48
PULL #4	4.45	4.52		4.47
PULL #5	4.37	4.64		4.30
TOTAL				
AVG.				

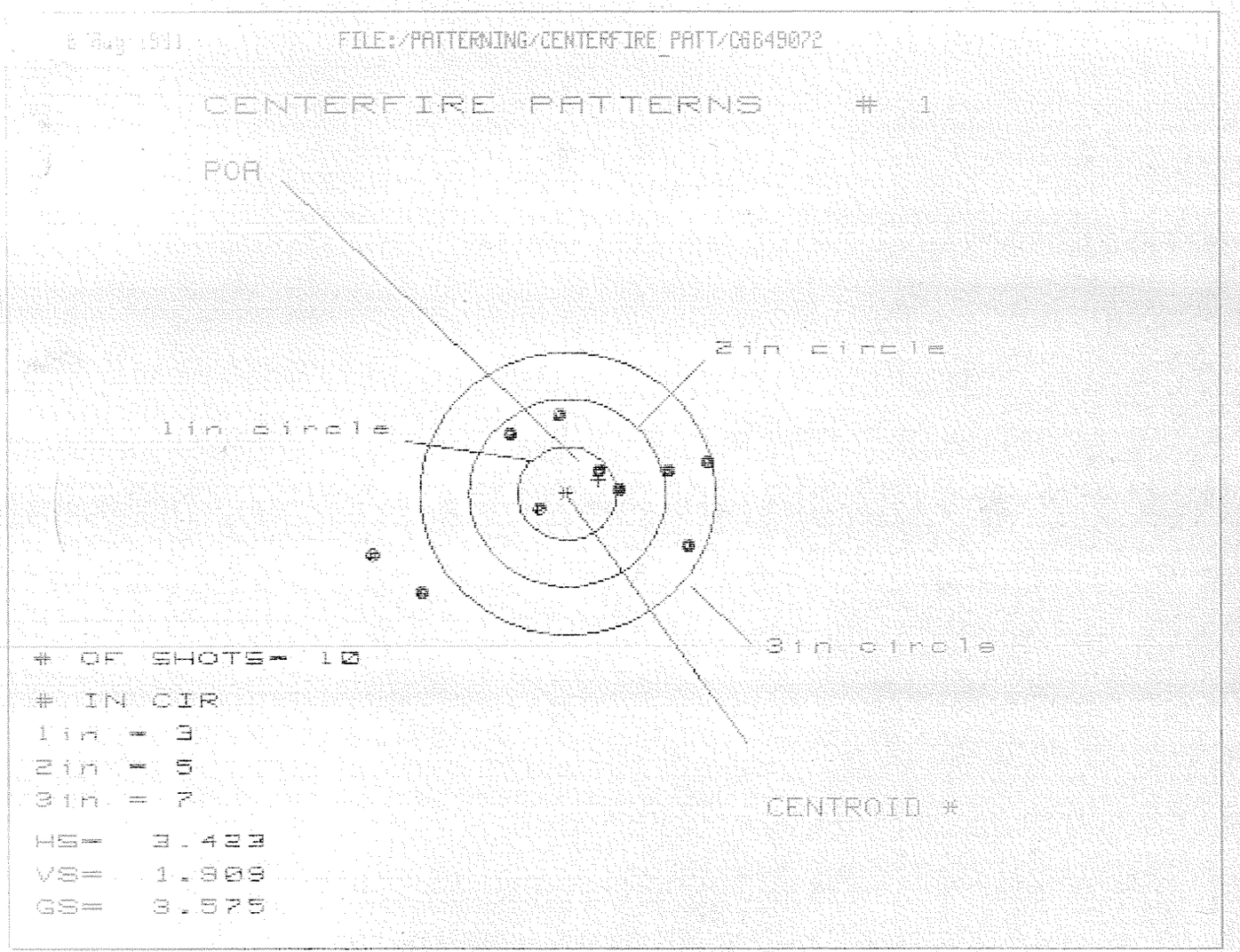
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649072
8 Aug 1991

CENTROIDAL DISTANCES

0	TO	1	.35223
1	TO	2	.0567274
1	TO	3	.441346
1	TO	4	.639088
1	TO	5	.643666

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1243

THE AMP FOR THIS RIFLE IS: .9722



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.458	1.240	1.030
MINIMUM X	:	-1.965	-1.675	-1.034
MAXIMUM Y	:	.809	.737	.590
MINIMUM Y	:	-1.100	-1.172	-.727
CENTROID X	:	-.321	-.103	.107
CENTROID Y	:	-.145	-.073	.074
POA TO CENTROID in.	:	.352	.126	.130
MIN RADIUS	:	.336	.135	.147
MEAN RADIUS	:	1.063	.894	.712
MAX RADIUS	:	2.068	2.045	1.135
HORIZONTAL SPREAD	:	3.423	2.915	2.065
VERTICAL SPREAD	:	1.909	1.909	1.317
EXTREME SPREAD	:	3.575	3.272	2.164
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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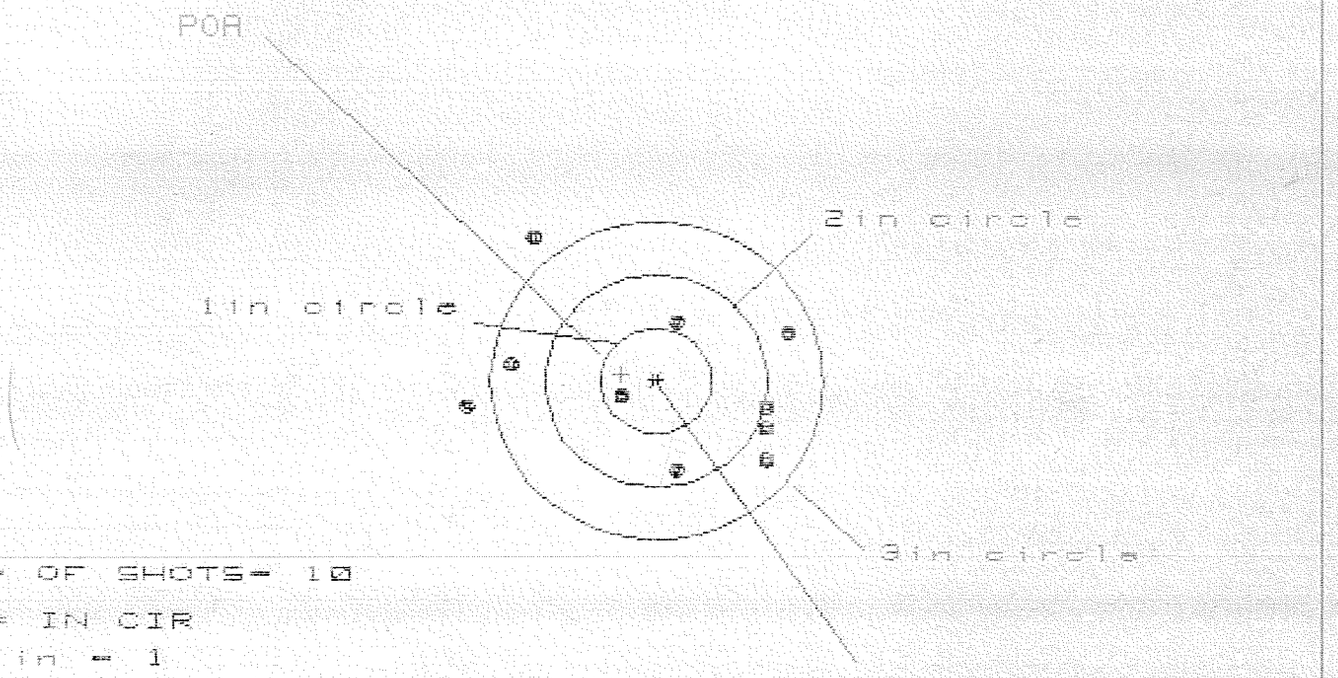
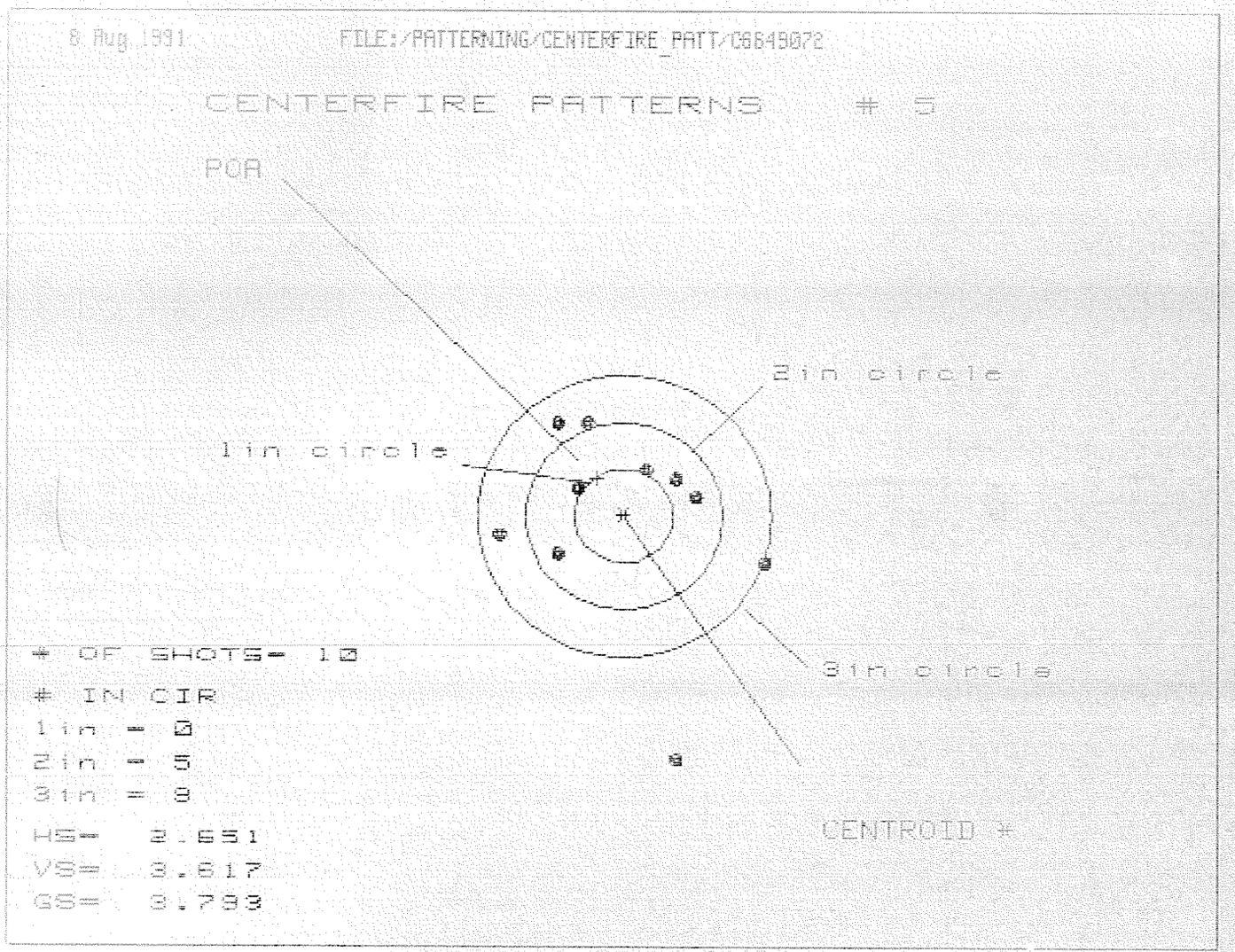
CENTERFIRE PATTERNS # 4



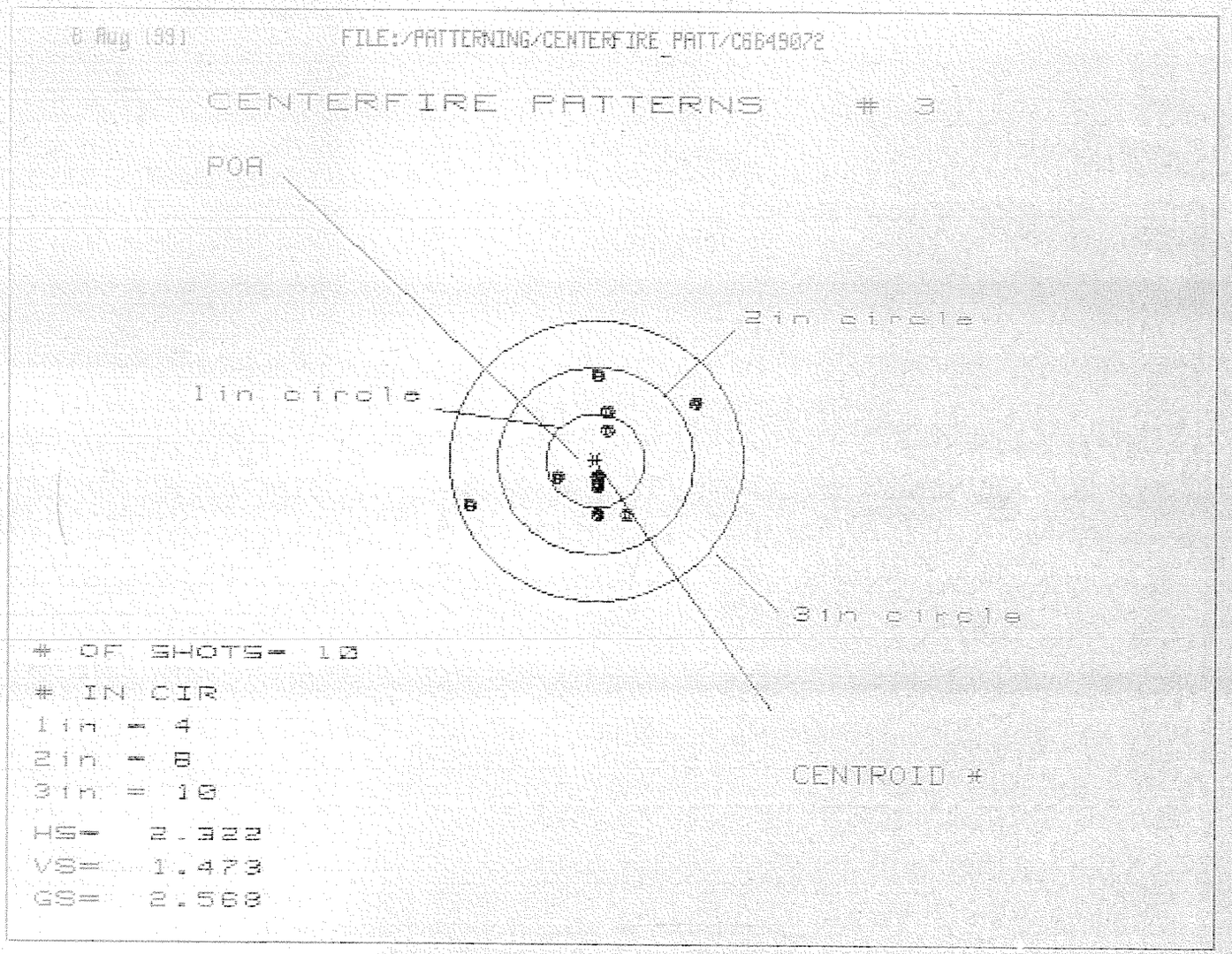
OF SHOTS= 10

# IN CIR	
1in	= 1
2in	= 3
3in	= 8
HS=	2.832
VS=	2.133
GS=	2.947

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.159	1.034	.809
MINIMUM X	:	-1.673	-1.798	-1.623
MAXIMUM Y	:	1.327	.716	.698
MINIMUM Y	:	-.806	-.659	-.677
CENTROID X	:	.312	.438	.663
CENTROID Y	:	-.057	-.204	-.186
POA TO CENTROID in.	:	.318	.483	.688
MIN RADIUS	:	.340	.452	.640
MEAN RADIUS	:	1.101	1.005	.868
MAX RADIUS	:	1.742	1.804	1.657
HORIZONTAL SPREAD	:	2.832	2.832	2.432
VERTICAL SPREAD	:	2.133	1.375	1.375
EXTREME SPREAD	:	2.947	2.938	2.449
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	5	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.391	1.447	.938
MINIMUM X	:	-1.260	-1.204	-1.024
MAXIMUM Y	:	1.042	.756	.663
MINIMUM Y	:	-2.575	-.744	-.747
CENTROID X	:	.270	.214	.034
CENTROID Y	:	-.400	-.114	-.021
POA TO CENTROID in.	:	.483	.243	.040
MIN RADIUS	:	.569	.387	.249
MEAN RADIUS	:	1.094	.853	.737
MAX RADIUS	:	2.623	1.627	1.154
HORIZONTAL SPREAD	:	2.651	2.651	1.961
VERTICAL SPREAD	:	3.617	1.500	1.410
EXTREME SPREAD	:	3.793	2.668	2.002
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.058	.918	.245
MINIMUM X	:	-1.264	-.565	-.451
MAXIMUM Y	:	.882	.829	.899
MINIMUM Y	:	-.591	-.644	-.574
CENTROID X	:	-.016	.124	.010
CENTROID Y	:	.174	.227	.157
POA TO CENTROID in.	:	.174	.259	.157
MIN RADIUS	:	.182	.235	.166
MEAN RADIUS	:	.650	.575	.487
MAX RADIUS	:	1.352	1.076	.899
HORIZONTAL SPREAD	:	2.322	1.483	.696
VERTICAL SPREAD	:	1.473	1.473	1.473
EXTREME SPREAD	:	2.568	1.679	1.491
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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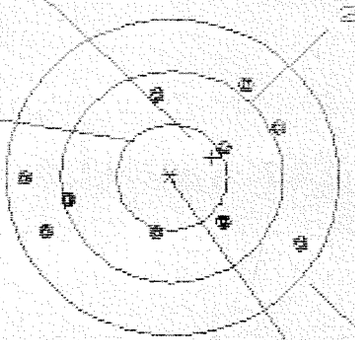
CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.428

VS= 1.491

GS= 2.494

PATTERN #	:	[redacted]	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.134	1.003	.825
MINIMUM X	:	-1.294	-1.425	-1.245
MAXIMUM Y	:	.913	.850	.841
MINIMUM Y	:	-.578	-.641	-.650
CENTROID X	:	-.364	-.233	-.055
CENTROID Y	:	-.182	-.119	-.110
POA TO CENTROID in.	:	.407	.261	.123
MIN RADIUS	:	.493	.347	.203
MEAN RADIUS	:	.953	.892	.791
MAX RADIUS	:	1.312	1.427	1.281
HORIZONTAL SPREAD	:	2.428	2.428	2.070
VERTICAL SPREAD	:	1.491	1.491	1.491
EXTREME SPREAD	:	2.494	2.494	2.099
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	