

C6636038

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.

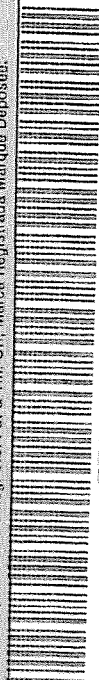
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

MODEL 700™ M24

SERIAL NO.
 C6636038

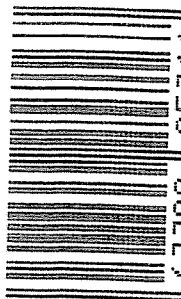
ORDER NO.
 5716

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



5716 C6636038

UPC



0 47700 25716 7

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 RDS test OK	
TEST		
TGT		
PROOF	6-1291 D/H	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 6038

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
N-	6/10	Cyets Very Hard.	RW
	2nd		
	6-29/	100 RDS TEST DH OK	
	3rd		
	4th		
		FUNCTION	RD 5554 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636 038

Stock
Repaired

REPAIR

OK
6/27/91

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	4 8 91		RW
607	Check Headspace	4 8 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action	APR 9 1991		KR
	Magnaflux Bolt	APR 9 1991		K
615	Rollmark Caliber	APR 9 1991		28
617	Drill and Tap Sight Holes	APR 9 1991		EB
618	Polish Barrel	APR 9 1991		WB
620	Apply Coatings (Barrel Action)		5-10-91	THA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/8/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	4			6-10-91	D/H
	G) Safety Off Force	2	2	2			6-10-91	D/H
	H) Trigger Pull Test & Retainability						6/8/91	WB
	I) Firing Pin Indent	.022	.022	.022			6-10-91	D/H
	J) Assemble Stock						6/10/91	RW
	K) Assemble Swivel Studs						6-14-91	JLL
	L) Attach Front and Rear Sight Assemblies						6/10/91	RW
	M) Iron Sight Alignment						6/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/10/91	RW
	O) Attach Scope to Rifle						6/10/91	RW
	P) Detach & Attach Scope 20 Times						6/10/91	RW
640	Gallery Target & Test						6-10-91	AF
	A) Time							AF
	B) Malfunctions							AF
	C) Pierced Primers							AF
	D) Optical Clarity of Scope							AF
645	Inspect for Live Ammo						6-10-91	AF
655	Final Inspection							
	A) Headspace						6-14-91	JLL
	B) Trigger Pull	2.30	2.30	2.24	2.20	2.20	6-13-91	JLL
	C) Function						6-14-91	JLL
660	Pack						6-20-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636038

DATE 6/8/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.31	2.50	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.29	2.37	2.50	
PULL #3	2.56	2.23	2.42	2.24	
PULL #4	2.50	2.30	2.44	2.26	
PULL #5	2.45	2.27	2.49	2.26	
TOTAL	12.47	11.40	12.22		
AVG.	2.49	2.28	2.44		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.03		
PULL #2	3.05	3.04		
PULL #3	3.05	3.09		
PULL #4	3.07	3.04		
PULL #5	3.00	2.99		
TOTAL	15.19	15.19		
AVG.	3.04	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.01		4.13
PULL #2	3.98	4.09		4.13
PULL #3	4.02	4.04		4.08
PULL #4	4.02	4.08		4.08
PULL #5	4.00	4.08		4.14
TOTAL	20.04	20.30		
AVG.	4.01	4.06		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636038
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.153052
1 TO	2	.355383
1 TO	3	.385561
1 TO	4	.301281
1 TO	5	.674818

5
ft² <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1062
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1348
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .171009
THE AMR FOR THIS RIFLE IS: .9022

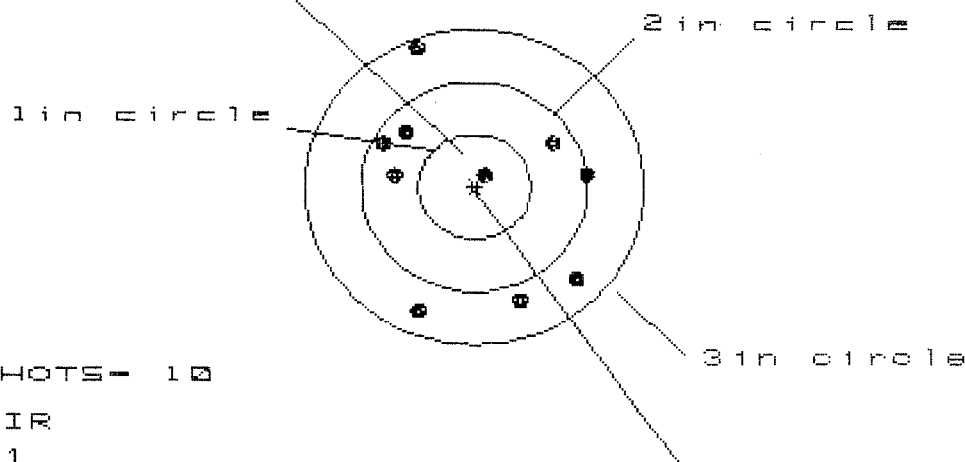
18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636038

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.853

VS= 2.518

GS= 2.658

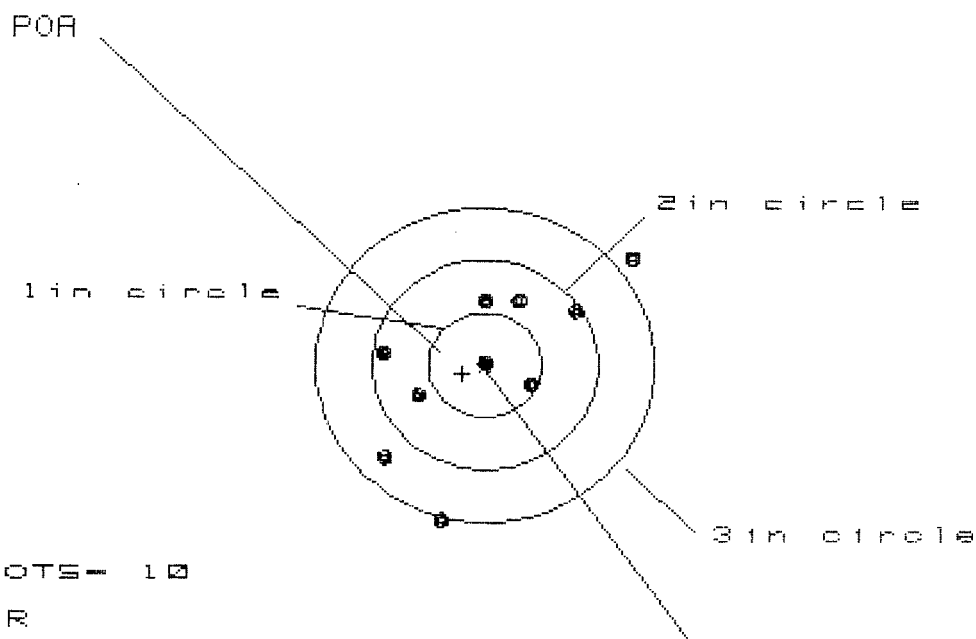
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.032	.975	.904
MINIMUM X	:	-.821	-.878	-.949
MAXIMUM Y	:	1.363	.657	.532
MINIMUM Y	:	-1.155	-1.004	-1.070
CENTROID X	:	-.095	-.038	.033
CENTROID Y	:	-.120	-.271	-.146
POA TO CENTROID in.	:	.153	.274	.150
MIN RADIUS	:	.132	.263	.148
MEAN RADIUS	:	.959	.915	.860
MAX RADIUS	:	1.457	1.152	1.154
HORIZONTAL SPREAD	:	1.853	1.853	1.853
VERTICAL SPREAD	:	2.518	1.661	1.602
EXTREME SPREAD	:	2.658	2.169	2.169
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

18 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.198

VS= 2.577

GS= 3.047

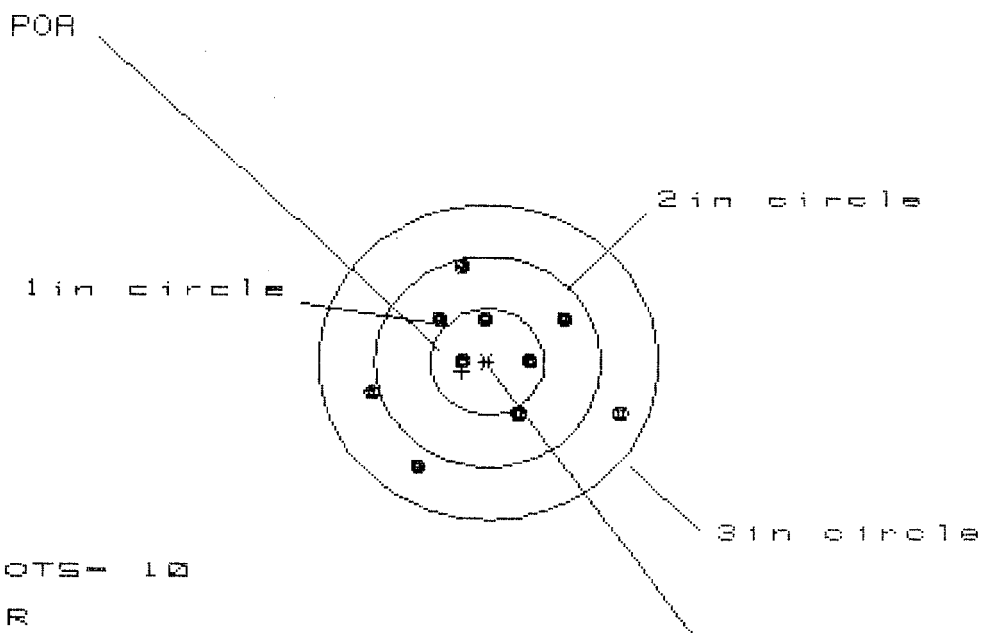
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.262	.938	.910
MINIMUM X	:	-.936	-.796	-.824
MAXIMUM Y	:	1.062	.770	.595
MINIMUM Y	:	-1.515	-1.397	-.958
CENTROID X	:	.196	.056	.084
CENTROID Y	:	.084	-.034	.141
POA TO CENTROID in.	:	.213	.065	.164
MIN RADIUS	:	.047	.205	.172
MEAN RADIUS	:	.880	.809	.707
MAX RADIUS	:	1.649	1.415	1.214
HORIZONTAL SPREAD	:	2.198	1.734	1.734
VERTICAL SPREAD	:	2.577	2.167	1.553
EXTREME SPREAD	:	3.047	2.325	2.168
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.170

VS= 1.857

GS= 2.179

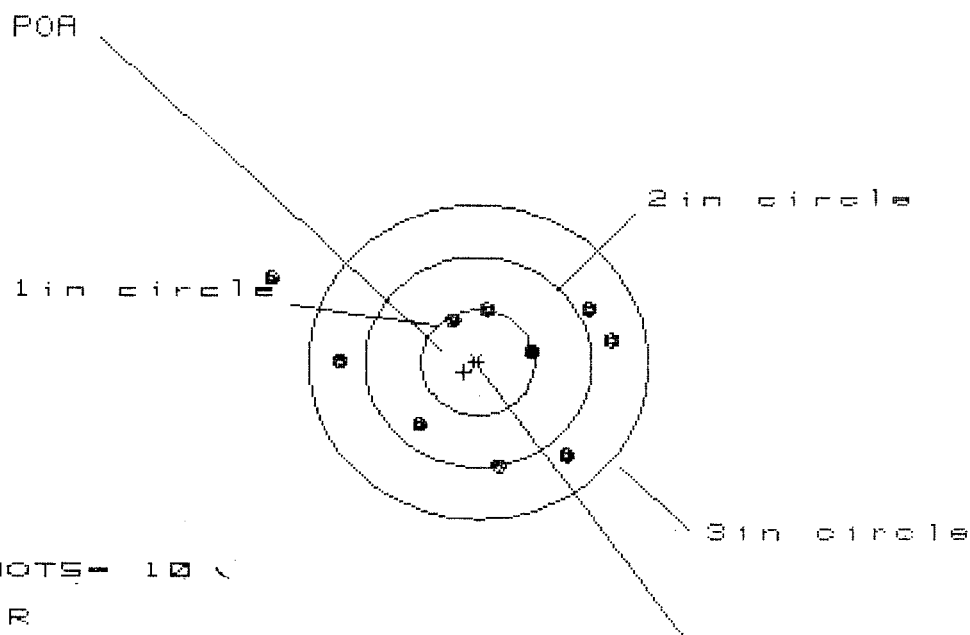
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	.846	.788
MINIMUM X	:	-1.038	-.912	-.970
MAXIMUM Y	:	.912	.862	.738
MINIMUM Y	:	-.945	-.995	-.699
CENTROID X	:	.229	.103	.161
CENTROID Y	:	.089	.139	.263
POA TO CENTROID in.	:	.245	.173	.308
MIN RADIUS	:	.224	.122	.252
MEAN RADIUS	:	.741	.674	.608
MAX RADIUS	:	1.217	1.097	1.056
HORIZONTAL SPREAD	:	2.170	1.758	1.758
VERTICAL SPREAD	:	1.857	1.857	1.437
EXTREME SPREAD	:	2.179	1.901	1.885
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HC= 3.001

VS= 1.823

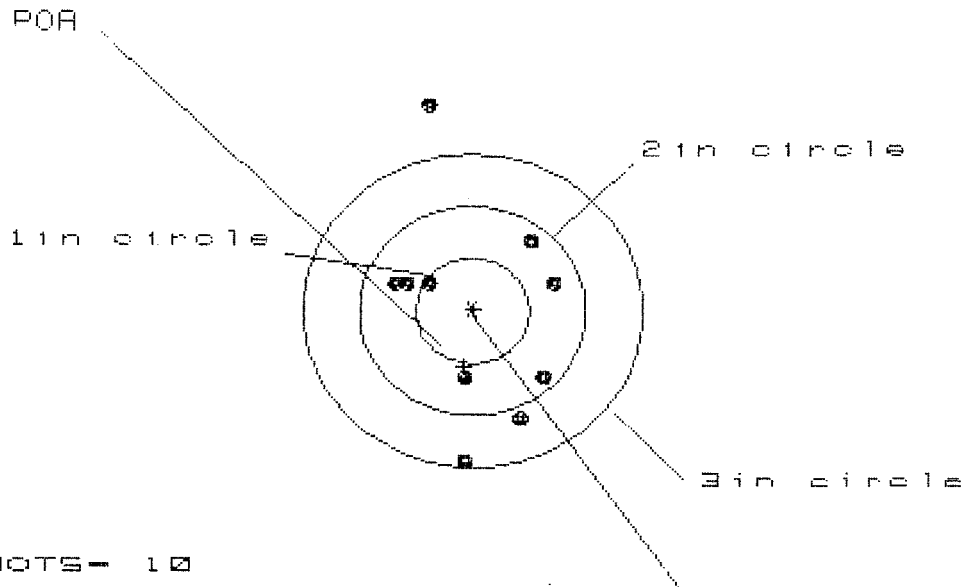
GS= 3.147

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	.998	1.075
MINIMUM X	:	-1.803	-1.386	-1.309
MAXIMUM Y	:	.830	.587	.484
MINIMUM Y	:	-.993	-.901	-1.004
CENTROID X	:	.122	.322	.245
CENTROID Y	:	.089	-.003	.100
POA TO CENTROID in.	:	.151	.322	.265
MIN RADIUS	:	.440	.340	.351
MEAN RADIUS	:	.995	.869	.831
MAX RADIUS	:	1.985	1.389	1.309
HORIZONTAL SPREAD	:	3.001	2.384	2.384
VERTICAL SPREAD	:	1.823	1.488	1.488
EXTREME SPREAD	:	3.147	2.394	2.394
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.399

VS= 3.428

GS= 3.439

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.709	.667	.649
MINIMUM X	-.690	-.732	-.750
MAXIMUM Y	1.950	.910	.752
MINIMUM Y	-1.478	-1.262	-.940
CENTROID X	.079	.121	.139
CENTROID Y	.532	.316	.474
POA TO CENTROID in.	.538	.338	.494
MIN RADIUS	.474	.402	.557
MEAN RADIUS	.936	.808	.739
MAX RADIUS	1.985	1.270	.991
HORIZONTAL SPREAD	1.399	1.399	1.399
VERTICAL SPREAD	3.428	2.172	1.692
EXTREME SPREAD	3.439	2.247	1.695
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		