

C6649116

MODEL 700™ M24

Model **SWS**™

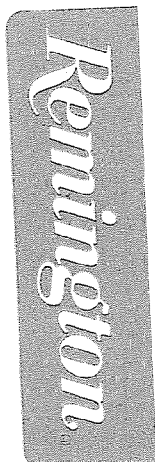
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

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

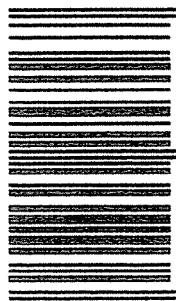
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO. C6649116	ORDER NO. 5716
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5716 C6649116

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

SHim

Stock
Repaired

GUN SERIAL #

C6649116

Repair
OK/6/27/91

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	Rw
600	Proof	4 30	91	Rw
607	Check Headspace	4 30	91	Rw
610	Dis-assemble Gun	4 30	91	Rw
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5/20/91	TH
	Apply Coating (Bolt)		5/20/91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-31-91	DH
	G) Safety Off Force	4	4	4			5-31-91	DH
	H) Trigger Pull Test & Retainability						5/31/91	JP
	I) Firing Pin Indent	.020	.020	.020			5-31-91	DH
	J) Assemble Stock						6/1/91	Rw
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/1/91	Rw
	M) Iron Sight Alignment						6/1/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						6/1/91	Rw
	O) Attach Scope to Rifle						6/1/91	Rw
	P) Detach & Attach Scope 20 Times						6/1/91	Rw
640	Gallery Target & Test						6-3-91	DH
	A) Time						6-3-91	DH
	B) Malfunctions						6-3-91	DH
	C) Pierced Primers						6-3-91	DH
	D) Optical Clarity of Scope						6-3-91	DH
645	Inspect for Live Ammo						6-3-91	DH
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.18	2.28	2.35	2.37	2.36	6-8-91	JP
	C) Function						6-8-91	DH
660	Pack						6-20-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649116

DATE 5/31/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.49	2.52	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.51	2.48	2.28	
PULL #3	2.44	2.53	2.63	2.35	
PULL #4	2.46	2.51	2.55	2.39	
PULL #5	2.39	2.56	2.55	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.48		
PULL #2	3.70	3.46		
PULL #3	3.31	3.41		
PULL #4	3.42	3.41		
PULL #5	3.44	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.60		4.57
PULL #2	4.49	4.55		4.60
PULL #3	4.68	4.62		4.58
PULL #4	4.58	4.54		4.58
PULL #5	4.56	4.60		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649116
3 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.147513
1 TO	2	.070214
1 TO	3	.433042
1 TO	4	.283975
1 TO	5	.548967

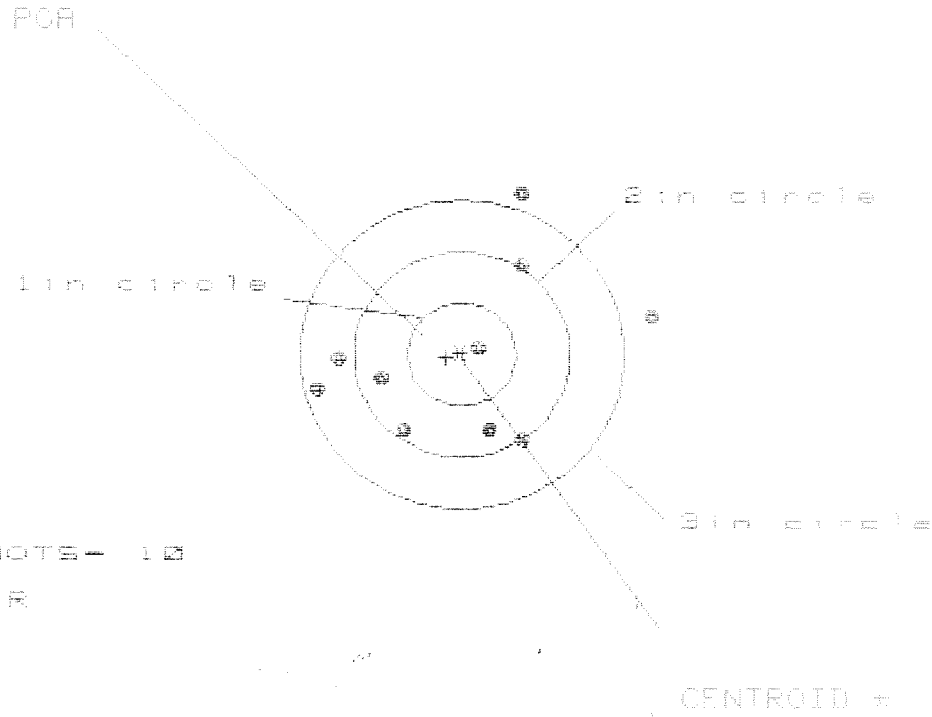
548 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1114
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0826
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138682
THE AMR FOR THIS RIFLE IS: .7946

2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649116

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.078

VS = 2.438

GS = 3.142

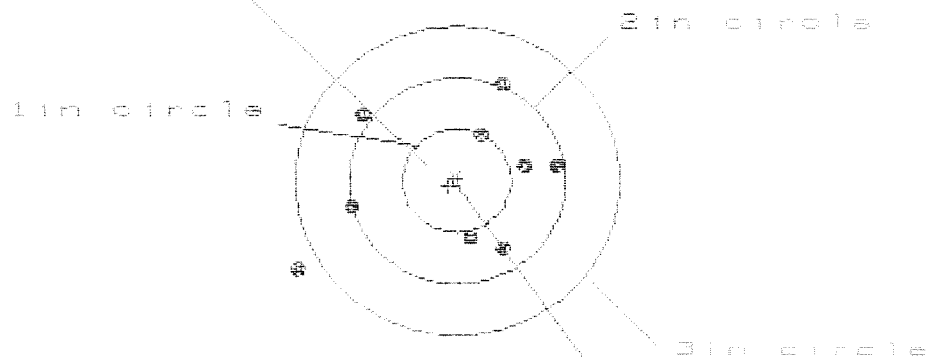
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.716	.768	.851
MINIMUM X	-1.362	-1.172	-1.075
MAXIMUM Y	1.570	1.608	1.123
MINIMUM Y	-.860	-.822	-.621
CENTROID X	.144	-.046	-.143
CENTROID Y	.032	-.006	-.207
POA TO CENTROID in.	.148	.047	.251
MIN RADIUS	.127	.321	.427
MEAN RADIUS	1.046	.952	.810
MAX RADIUS	1.749	1.782	1.377
HORIZONTAL SPREAD	3.078	1.940	1.926
VERTICAL SPREAD	2.438	2.438	1.744
EXTREME SPREAD	3.142	2.689	2.212
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

3 Jun 1991

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CENTERFIRE PATTERNS # 2

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.5897

VS = 1.916

GS = 2.562

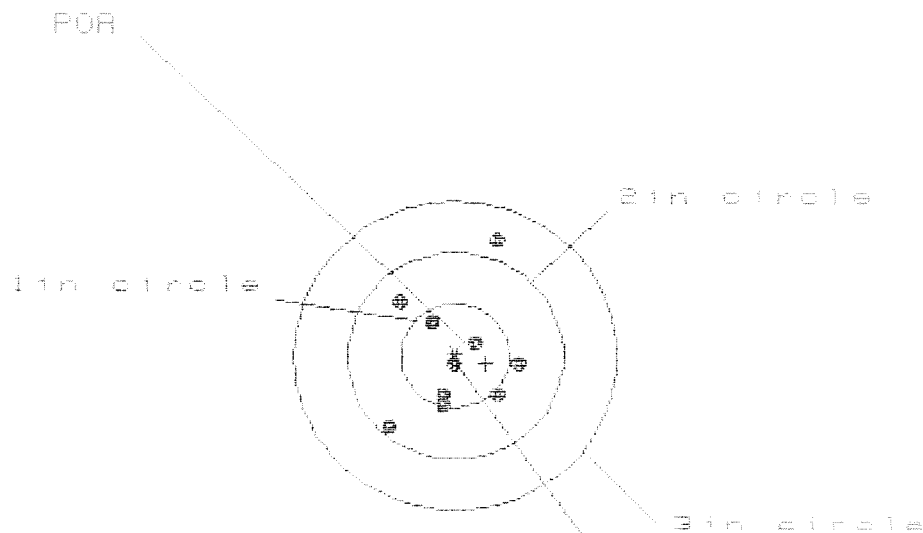
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.888	.720	.586
MINIMUM X	-1.509	-1.104	-1.239
MAXIMUM Y	.921	.822	.889
MINIMUM Y	-.895	-.735	-.667
CENTROID X	.077	.245	.379
CENTROID Y	.053	.152	.065
FOR TO CENTROID in.	.094	.288	.362
MIN RADIUS	.491	.331	.321
MEAN RADIUS	.893	.736	.648
MAX RADIUS	1.755	1.199	1.270
HORIZONTAL SPREAD	2.397	1.824	1.824
VERTICAL SPREAD	1.816	1.557	1.557
EXTREME SPREAD	2.662	1.864	1.862
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =			8

3 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 10

HE = 1.129

VS = 1.754

GS = 2.007

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.949	.594	.527
MINIMUM X	-.580	-.535	-.563
MAXIMUM Y	1.110	.610	.550
MINIMUM Y	-.644	-.521	.450
CENTROID X	-.287	-.332	-.265
CENTROID Y	.074	-.049	.016
POR TO CENTROID in.	.297	.335	.285
MIN RADIUS	.082	.059	.073
MEAN RADIUS	.554	.469	.429
MAX RADIUS	1.179	.790	.790
HORIZONTAL SPREAD	1.129	1.129	1.090
VERTICAL SPREAD	1.754	1.139	1.006
EXTREME SPREAD	2.007	1.248	1.247
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

3 Jun 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HE= 1.818

VS= 2.219

GS= 2.295

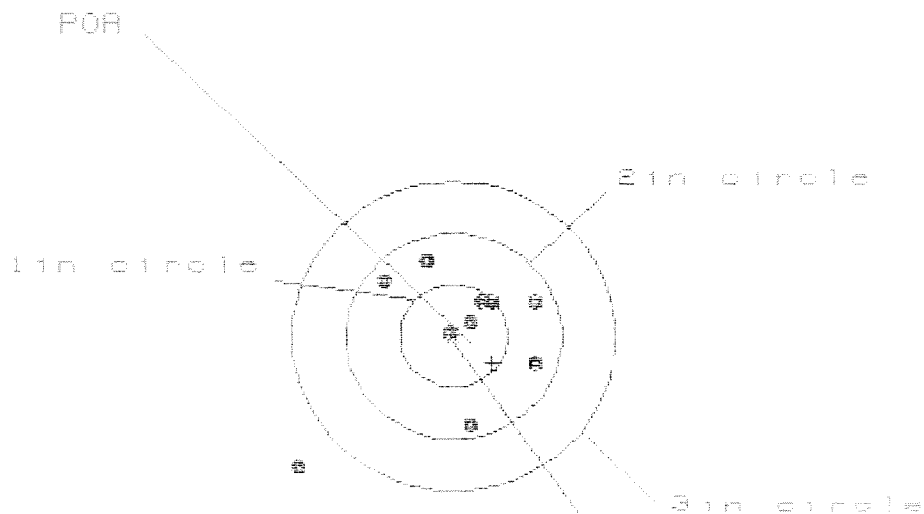
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.591	.454	.432
MINIMUM X	-1.227	-.729	-.751
MAXIMUM Y	1.196	1.186	.596
MINIMUM Y	-1.024	-1.033	-.884
CENTROID X	-.137	-.000	.022
CENTROID Y	-.009	.001	-.148
POA TO CENTROID in.	.137	.001	.149
MIN RADIUS	.114	.244	.322
MEAN RADIUS	.757	.684	.630
MAX RADIUS	1.230	1.200	1.007
HORIZONTAL SPREAD	1.818	1.183	1.183
VERTICAL SPREAD	2.219	2.219	1.480
EXTREME SPREAD	2.295	2.295	1.676
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =		10	

3 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.232

VS= 2.018

CS= 2.695

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.751	.586	.589
MINIMUM X	:	-1.481	-.846	-.843
MAXIMUM Y	:	.767	.628	.499
MINIMUM Y	:	-1.251	-1.038	-.579
CENTROID X	:	-.354	-.189	-.192
CENTROID Y	:	.263	.402	.531
POR TO CENTROID in.	:	.441	.444	.350
MIN RADIUS	:	.045	.028	.126
MEAN RADIUS	:	.733	.536	.455
MAX RADIUS	:	1.939	1.038	.891
HORIZONTAL SPREAD	:	2.232	1.432	1.432
VERTICAL SPREAD	:	2.018	1.666	1.077
EXTREME SPREAD	:	2.695	1.720	1.674
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			9	