

C6523326

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington[®]

MODEL 700TM M24

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

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6523306

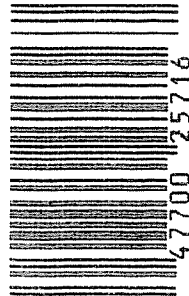
ORDER NO.
5716

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



5716 C6523306

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523306

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 3	90	RW
600	Proof	10 3	90	RW
607	Check Headspace	10 3	90	RW
610	Dis-assemble Gun	10 3	90	RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	GB
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel RWB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-13-90	TH
	Apply Coating (Bolt)		10-13-90	TH
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/2/90	GB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/9/90	GS
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			11/9/90	GS
	H) Trigger Pull Test & Retainability						11/9/90	GS
	I) Firing Pin Indent	.021	.021	.021			11/9/90	GS
	J) Assemble Stock						11/14/90	RW
	K) Assemble Swivel Studs						11-17-90	D/H
	L) Attach Front and Rear Sight Assemblies						11/14/90	RW
	M) Iron Sight Alignment						11/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/90	RW
	O) Attach Scope to Rifle						11/14/90	RW
	P) Detach & Attach Scope 20 Times						11/14/90	RW
640	Gallery Target & Test						11-15-90	AC
	A) Time						11-15-90	AC
	B) Malfunctions						11-15-90	AC
	C) Pierced Primers						11-15-90	AC
	D) Optical Clarity of Scope						11-15-90	AC
645	Inspect for Live Ammo						11-15-90	AC
655	Final Inspection							
	A) Headspace						11-19-90	D/H
	B) Trigger Pull	2.54	2.52	2.57	2.55	2.55	11-19-90	D/H
	C) Function						11-19-90	D/H
660	Pack						12-17-90	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6 523306

DATE 9/16/90

TESTER Q28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	227	228	232	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	226	221	241	2.52	
PULL #3	220	238	231	2.57	
PULL #4	218	230	236	2.55	
PULL #5	216	228	235	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	336	340		
PULL #2	328	334		
PULL #3	330	329		
PULL #4	330	331		
PULL #5	327	332		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	403	405		409
PULL #2	401	414		415
PULL #3	396	413		419
PULL #4	399	410		419
PULL #5	400	410		418
TOTAL				
AVG.				

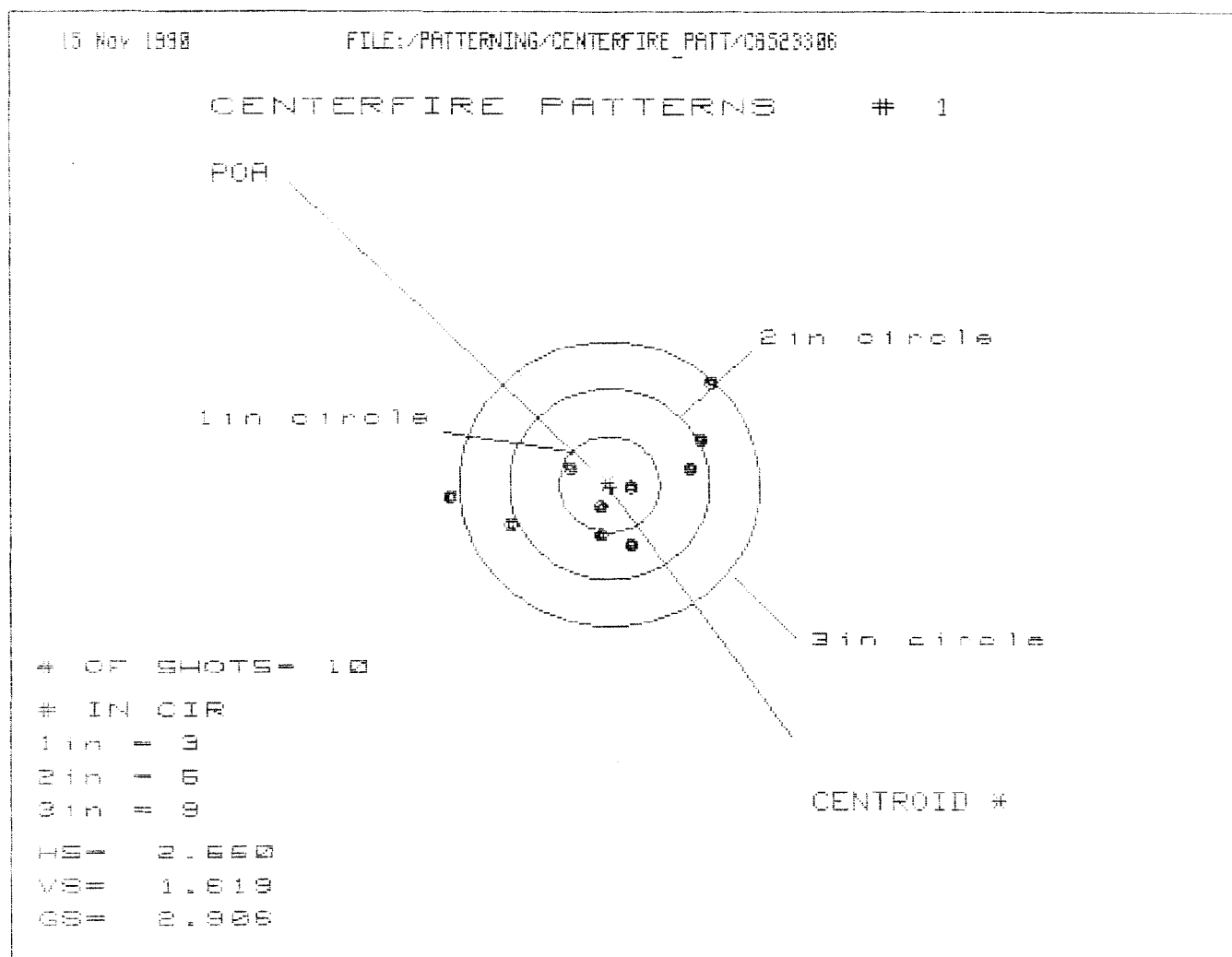
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523306
15 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0284605
1 TO	2	.150153
1 TO	3	.353375
1 TO	4	.303028
1 TO	5	.159113

5
4 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0824
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0246
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0356
THE AMR FOR THIS RIFLE IS: .8058



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.042	.862	.857
MINIMUM X	-1.618	-1.157	-1.049
MAXIMUM Y	1.040	1.026	.629
MINIMUM Y	-.579	-.593	-.465
CENTROID X	-.009	.171	.063
CENTROID Y	.027	.041	-.087
POA TO CENTROID in.	.028	.176	.107
MIN RADIUS	.235	.071	.180
MEAN RADIUS	.799	.696	.590
MAX RADIUS	1.623	1.340	1.093
HORIZONTAL SPREAD	2.660	2.019	1.905
VERTICAL SPREAD	1.619	1.619	1.094
EXTREME SPREAD	2.906	2.492	2.123
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523386

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.607

VS= 1.781

GS= 2.616

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.535	1.244	.740
MINIMUM X	:	-1.072	-.901	-.745
MAXIMUM Y	:	.942	.904	.885
MINIMUM Y	:	-.839	-.877	-.896
CENTROID X	:	-.154	-.324	-.480
CENTROID Y	:	-.012	.026	.045
POA TO CENTROID in.	:	.154	.325	.482
MIN RADIUS	:	.153	.237	.359
MEAN RADIUS	:	.859	.752	.668
MAX RADIUS	:	1.574	1.253	1.154
HORIZONTAL SPREAD	:	2.607	2.145	1.485
VERTICAL SPREAD	:	1.781	1.781	1.781
EXTREME SPREAD	:	2.616	2.145	1.901
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8523306

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.763

VS= 1.660

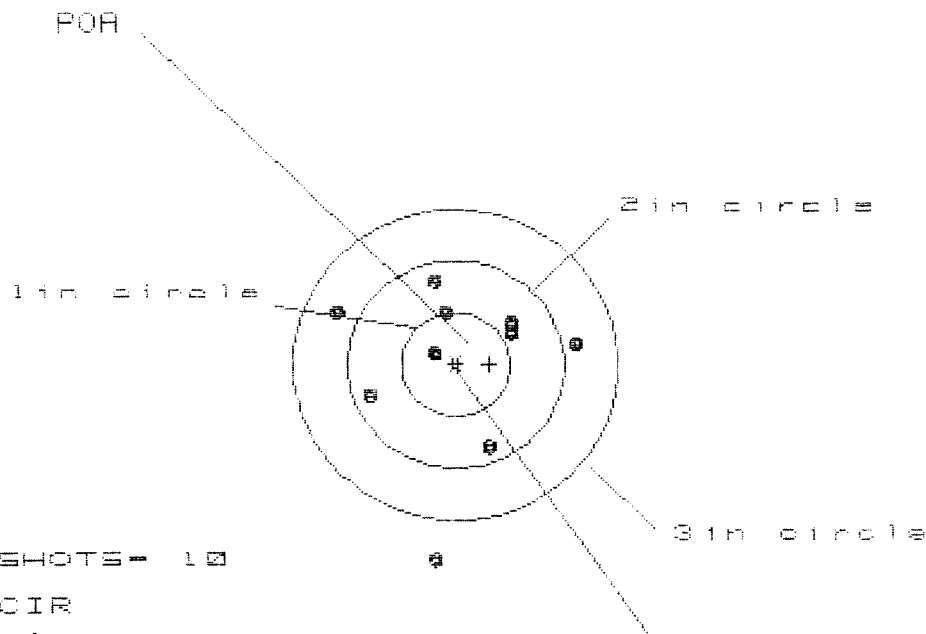
GS= 1.958

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.869
MINIMUM X	-.894
MAXIMUM Y	1.070
MINIMUM Y	-.590
CENTROID X	.076
CENTROID Y	-.316
POA TO CENTROID in.	.325
MIN RADIUS	.207
MEAN RADIUS	.828
MAX RADIUS	1.139
HORIZONTAL SPREAD	1.763
VERTICAL SPREAD	1.660
EXTREME SPREAD	1.958
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 6
NUMBER IN THREE INCH CIRCLE	= 10

15 Nov 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.268

VS= 2.656

GS= 2.656

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.151	1.133	.992
MINIMUM X	:	-1.117	-1.135	-.946
MAXIMUM Y	:	.791	.583	.617
MINIMUM Y	:	-1.865	-.973	-.939
CENTROID X	:	-.310	-.292	-.151
CENTROID Y	:	-.008	.200	.166
POA TO CENTROID in.	:	.310	.354	.324
MIN RADIUS	:	.196	.175	.304
MEAN RADIUS	:	.868	.709	.648
MAX RADIUS	:	1.872	1.166	1.034
HORIZONTAL SPREAD	:	2.268	2.268	1.938
VERTICAL SPREAD	:	2.656	1.556	1.556
EXTREME SPREAD	:	2.656	2.282	1.998
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1998

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.033

VS= 2.016

GS= 2.078

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.601
MINIMUM X	-.432
MAXIMUM Y	1.028
MINIMUM Y	-.988
CENTROID X	-.015
CENTROID Y	.186
POA TO CENTROID in.	.187
MIN RADIUS	.292
MEAN RADIUS	.675
MAX RADIUS	1.048
HORIZONTAL SPREAD	1.033
VERTICAL SPREAD	2.016
EXTREME SPREAD	2.078
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	10