C6498825

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 571G

*Includes 1 in chamber.

Remington®

CAR 702

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 0498825

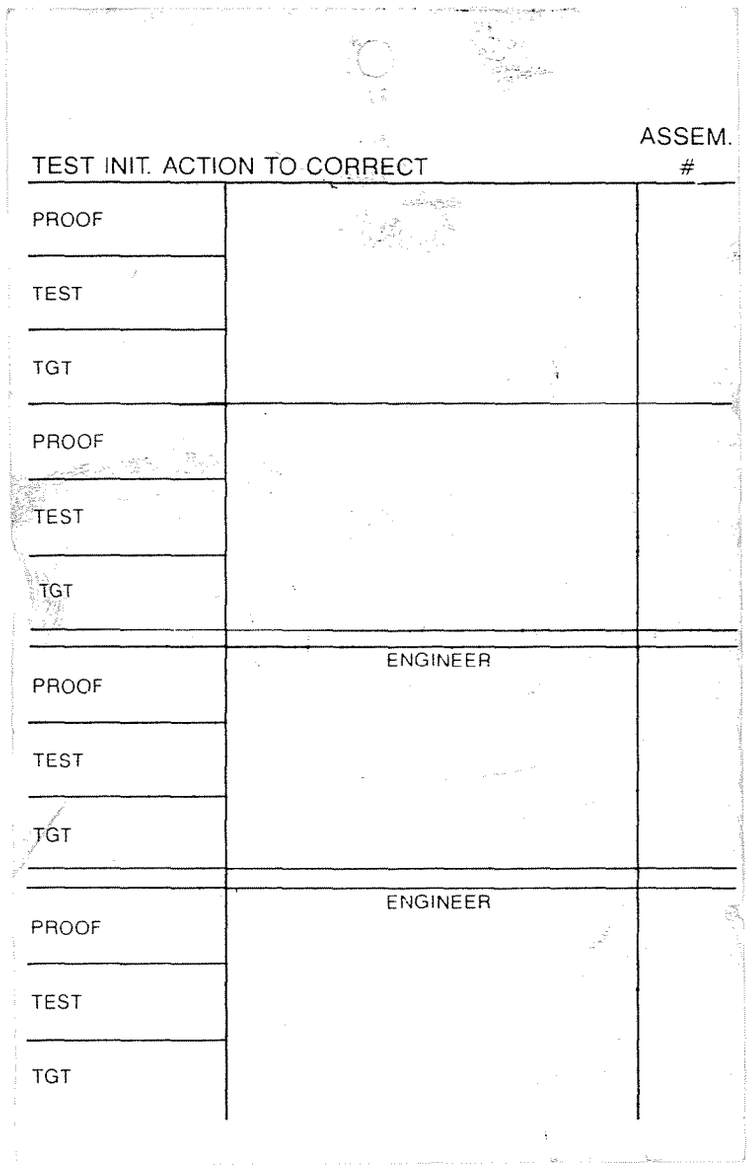
OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	RB
600	Proof		8-21-90	RB
607	Check Headspace		8-21-90	RB
610	Dis-assemble Gun		8-21-90	RB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	CB
617	Drill and Tap Sight Holes		8/22/90	LB
618	Polish Barrel RB		8/22/90	WB
620	Apply Coatings (Barrel Action)		8/31/90	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/10/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/10/90	WB
	C) Inspect Ejector Hole for Chamfer		9/10/90	WB
	D) Oil Firing Pin Ass'y		9/10/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/90	WB

QUALITY AUDIT

op. #	OP. NAME	READINGS			DATE	INIT
635 nt.	F) Safety On Force	~~4~~ 5	5	5	9/10/90	WB
	G) Safety Off Force	2½	2½	2½	9/10/90	WB
	H) Trigger Pull Test & Retainability				9/10/90	WB
	I) Firing Pin Indent	.0225	.022	.022	9/10/90	WB
	J) Assemble Stock				9/10/90	KS
	K) Assemble Swivel Studs				9/13/90	[illegible]
	L) Attach Front and Rear Sight Assemblies				9/10/90	KS
	M) Iron Sight Alignment				9/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container				9/10/90	KS
	O) Attach Scope to Rifle				9/10/90	KS
	P) Detach & Attach Scope 20 Times				9/10/90	KS
640	Gallery Target & Test				9-11-90	DH
	A) Time				9-11-90	DH
	B) Malfunctions				9-11-90	DH
	C) Pierced Primers				9-11-90	DH
	D) Optical Clearity of Scope				9-11-90	DH
645	Inspect for Live Ammo				9-11-90	DH
655	Final Inspection A) Headspace				9/13/90	[illegible]
	B) Trigger Pull	2.37 2.31	2.30	2.24 2.37	9-12-90	[illegible]
	C) Function				9/13/90	[illegible]
660	Pack				9/20/90	[illegible]

MOD. _____ GA. CAL. _____ GUN # C6498825

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
	9/1/20	SCOPE IS LOOSE	KS
	2nd	Repaired	
	3rd		
	4th		
		FUNCTION RD 6654 Rev 1	



TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF			
TEST			
TGT			
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

BARBER - M24 0008401

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498825
DATE 9/10/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.29	2.65	2.37	MIN. SETTING,
PULL #2	2.32	2.26	2.56	2.31	NO AVG. OF 5
PULL #3	2.34	2.31	2.62	2.30	READINGS ACCEPT-
PULL #4	2.37	2.32	2.48	2.24	ABLE LESS THAN 2#
PULL #5	2.38	2.25	2.63	2.37	
TOTAL	11.84	11.43	12.94	11.59	
AVG.	2.37	2.38	2.59	2.318	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.29		
PULL #2	3.09	3.20		
PULL #3	3.11	3.15		
PULL #4	3.03	3.20		
PULL #5	3.29	3.13		
TOTAL	15.75	15.97		
AVG.	3.15	3.19		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.13		4.04
PULL #2	4.24	4.00		3.95
PULL #3	4.07	4.11		3.95
PULL #4	4.00	4.11		4.02
PULL #5	4.16	4.15		4.02
TOTAL	20.59	20.50		19.98
AVG.	4.12	4.10		4.00

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498825
11 Sep 1990

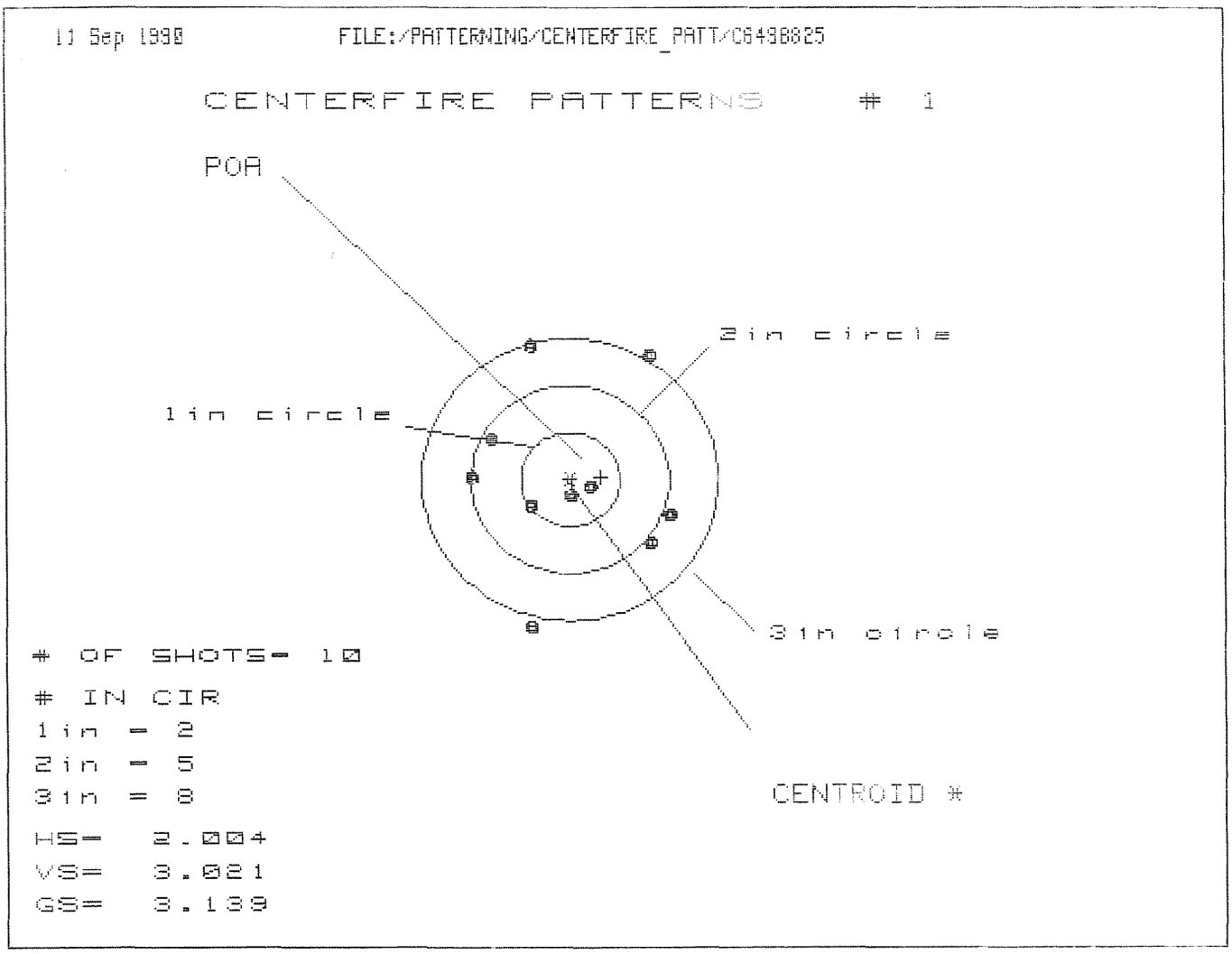
CENTROIDAL DISTANCES

Ø	TO	1	.312349
1	TO	2	.107168
1	TO	3	.421836
1	TO	4	.0603738
1	TO	5	.309919

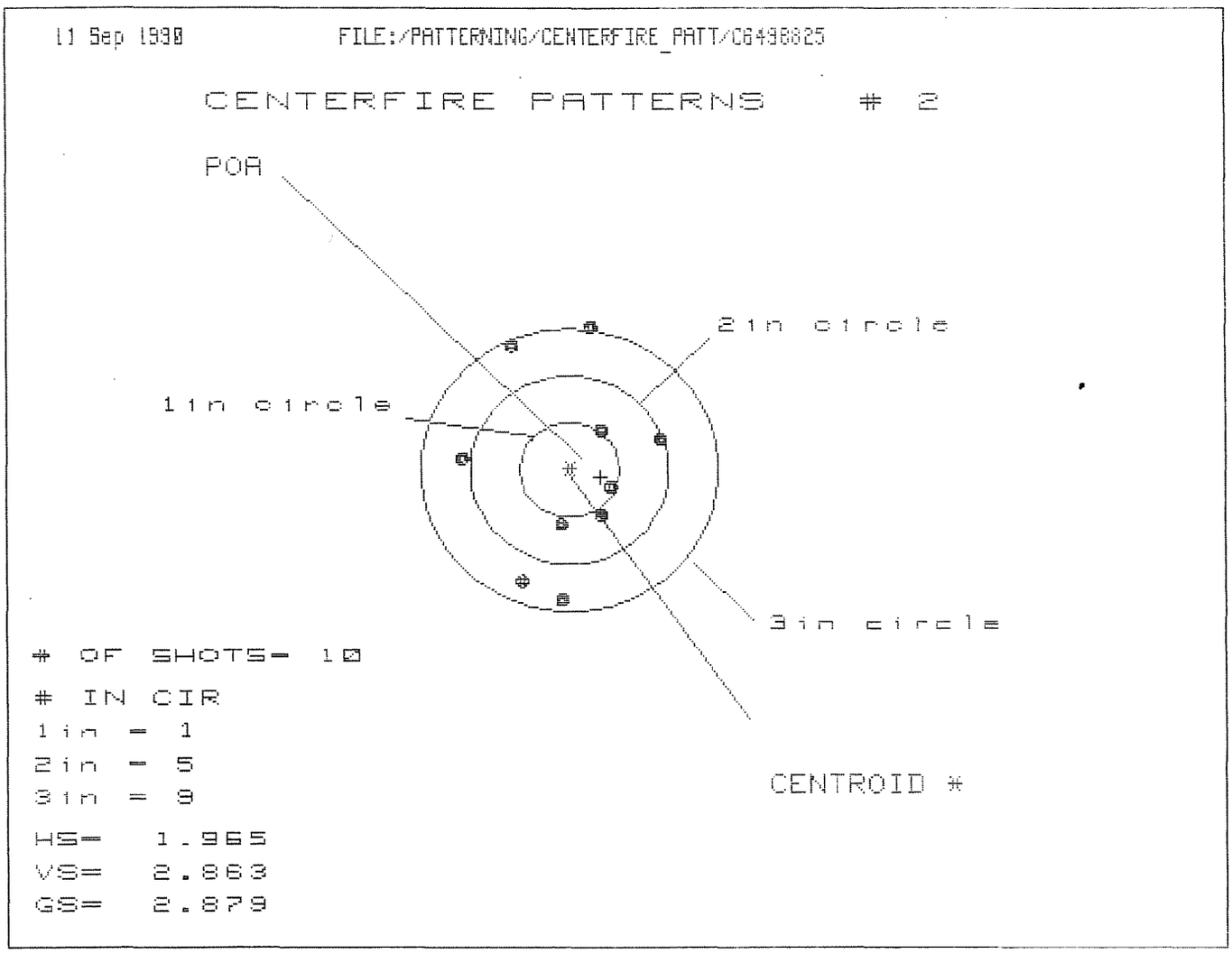
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2396
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0664
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .24863

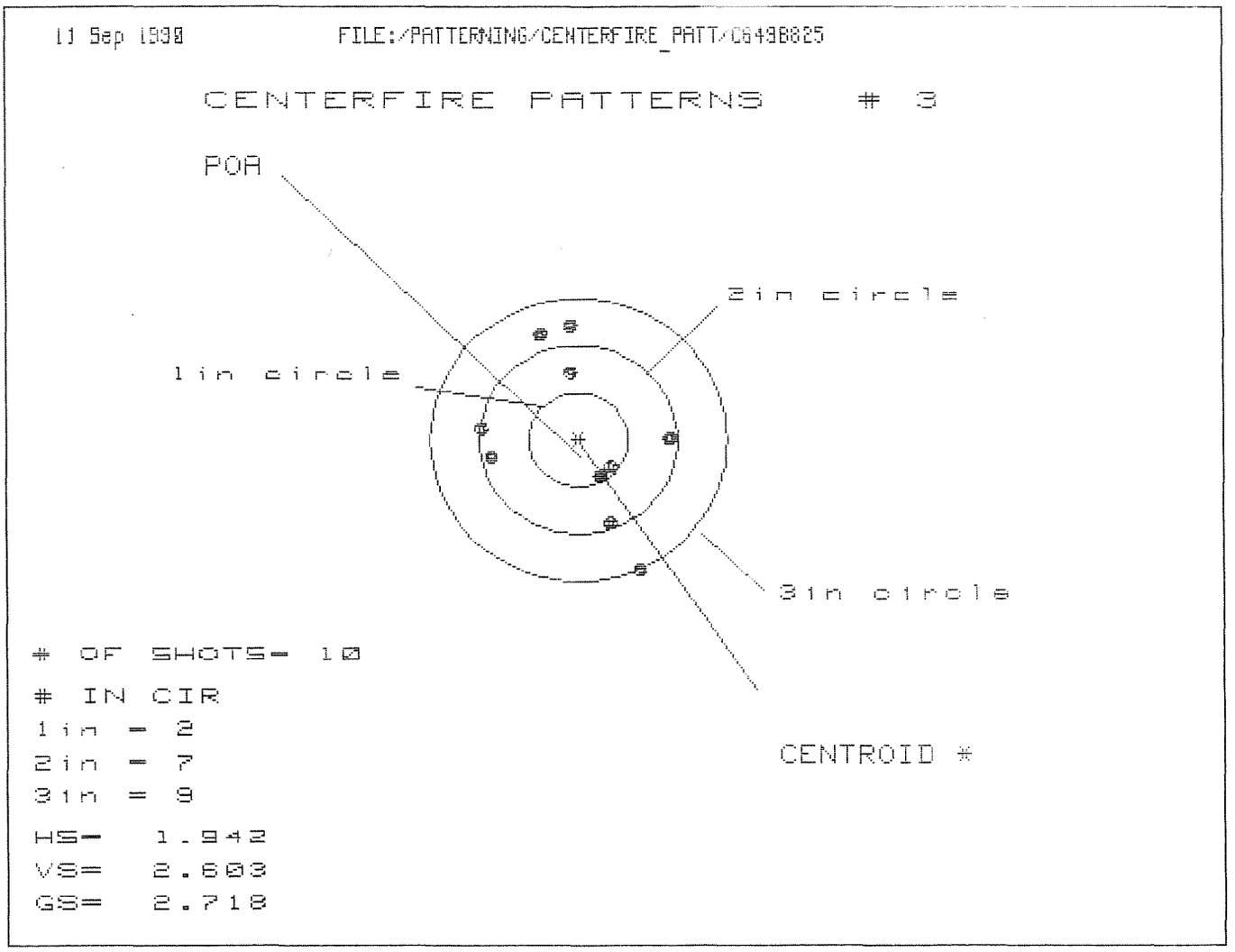
THE AMR FOR THIS RIFLE IS: .905



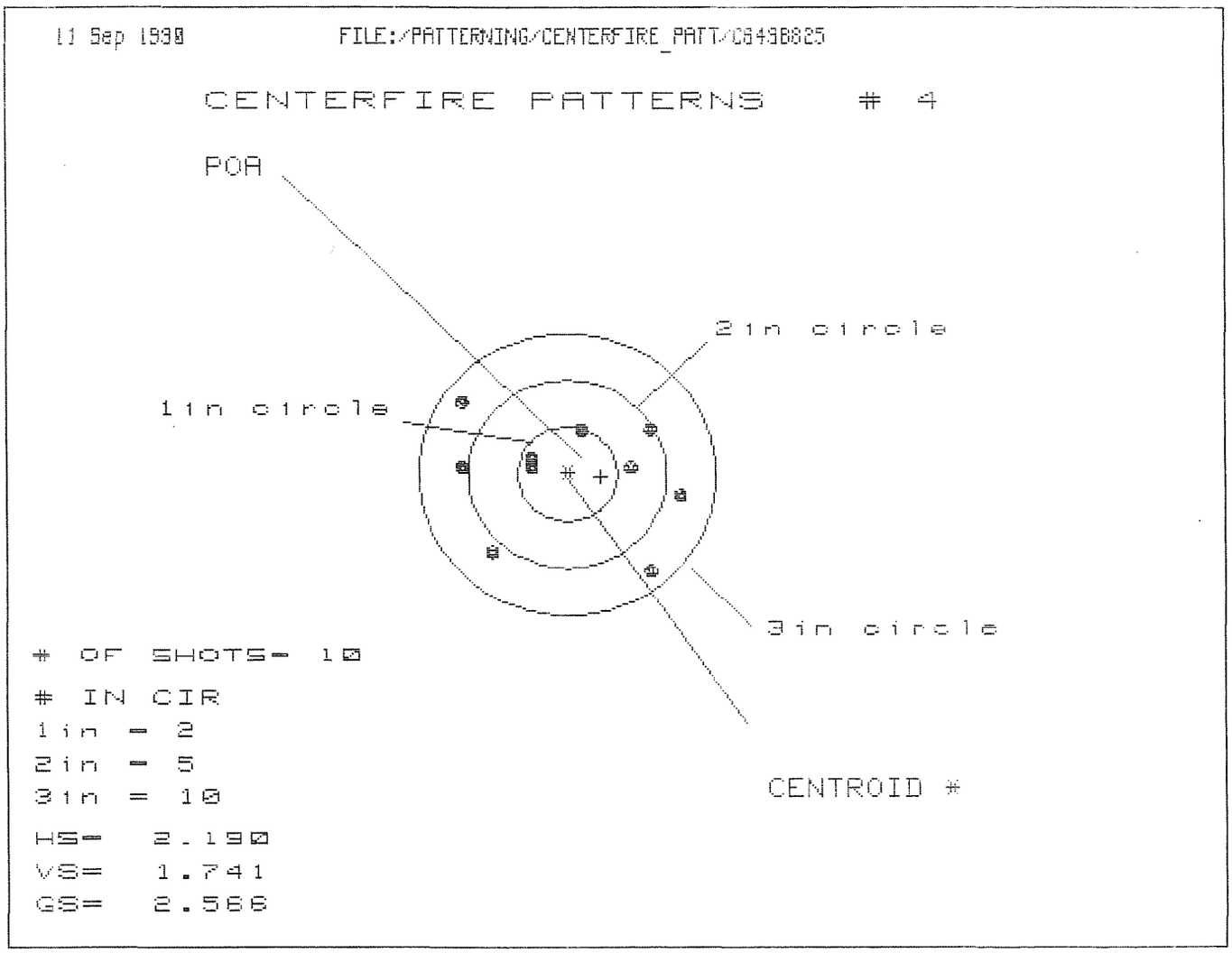
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.020	.981	1.083
MINIMUM X	:	-.984	-1.023	-.921
MAXIMUM Y	:	1.436	1.260	1.402
MINIMUM Y	:	-1.585	-.824	-.682
CENTROID X	:	-.311	-.272	-.374
CENTROID Y	:	-.029	.147	.005
POA TO CENTROID in.	:	.312	.310	.374
MIN RADIUS	:	.206	.291	.245
MEAN RADIUS	:	.964	.915	.812
MAX RADIUS	:	1.623	1.400	1.431
HORIZONTAL SPREAD	:	2.004	2.004	2.004
VERTICAL SPREAD	:	3.021	2.084	2.084
EXTREME SPREAD	:	3.139	2.391	2.391
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



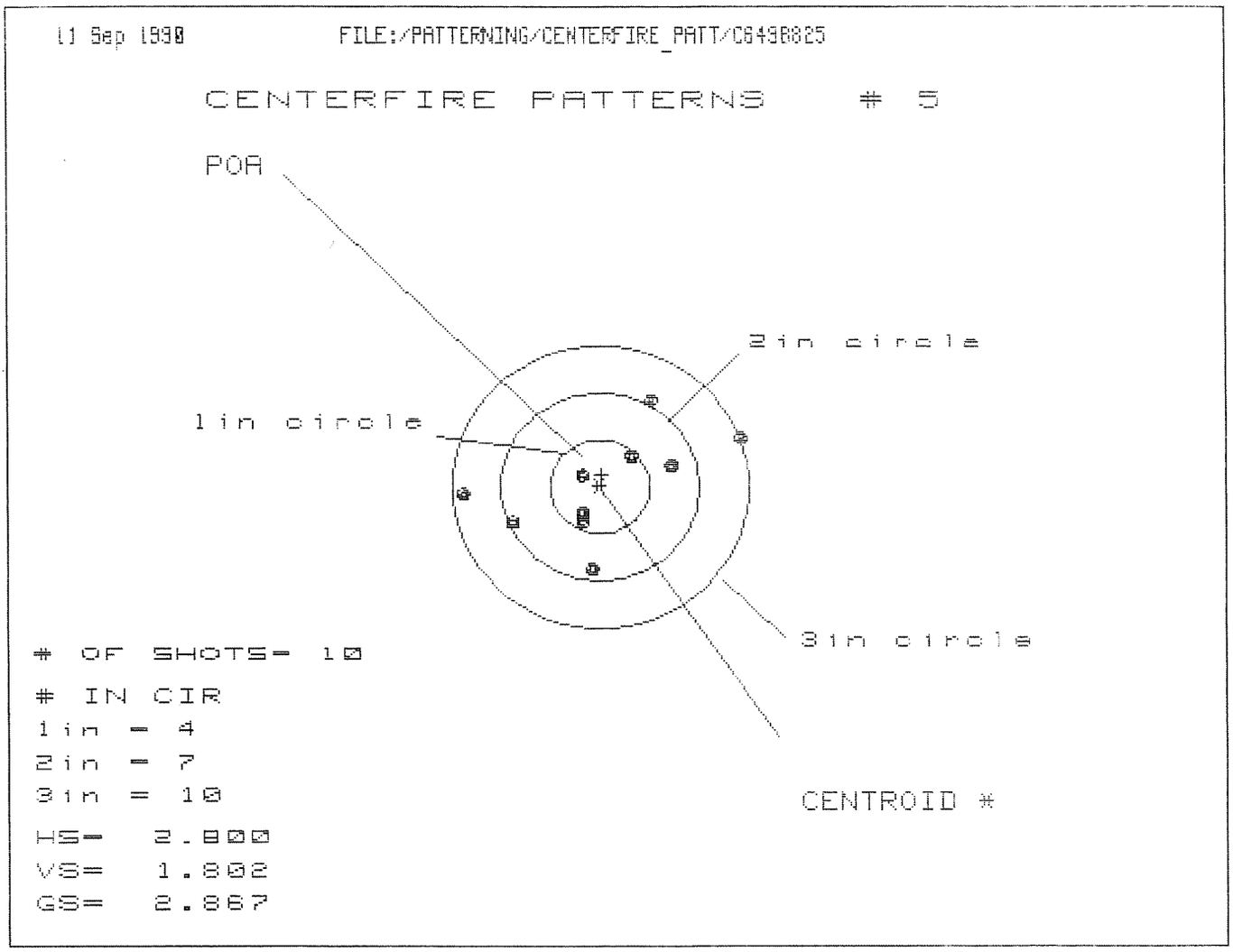
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.957	.892
MINIMUM X	:	-1.034	-1.008	-1.073
MAXIMUM Y	:	1.504	1.498	.782
MINIMUM Y	:	-1.359	-1.191	-1.004
CENTROID X	:	-.317	-.343	-.278
CENTROID Y	:	.078	-.089	-.276
POA TO CENTROID in.	:	.326	.354	.392
MIN RADIUS	:	.413	.378	.215
MEAN RADIUS	:	.969	.886	.760
MAX RADIUS	:	1.523	1.583	1.172
HORIZONTAL SPREAD	:	1.965	1.965	1.965
VERTICAL SPREAD	:	2.863	2.689	1.786
EXTREME SPREAD	:	2.879	2.730	2.081
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	:	.956	1.021	.983
MINIMUM X	:	-.986	-.921	-.959
MAXIMUM Y	:	1.177	1.018	1.139
MINIMUM Y	:	-1.426	-1.029	-.908
CENTROID X	:	-.216	-.281	-.243
CENTROID Y	:	.382	.541	.420
POA TO CENTROID in.	:	.439	.609	.486
MIN RADIUS	:	.404	.528	.450
MEAN RADIUS	:	.916	.847	.810
MAX RADIUS	:	1.541	1.085	1.139
HORIZONTAL SPREAD	:	1.942	1.942	1.942
VERTICAL SPREAD	:	2.603	2.047	2.047
EXTREME SPREAD	:	2.718	2.094	2.071
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.122	1.213	1.091
MINIMUM X	:	-1.068	-.977	-1.099
MAXIMUM Y	:	.729	.616	.456
MINIMUM Y	:	-1.012	-.946	-.869
CENTROID X	:	-.338	-.429	-.307
CENTROID Y	:	.025	.138	.061
POA TO CENTROID in.	:	.339	.451	.313
MIN RADIUS	:	.379	.249	.390
MEAN RADIUS	:	.889	.815	.783
MAX RADIUS	:	1.302	1.260	1.179
HORIZONTAL SPREAD	:	2.190	2.190	2.190
VERTICAL SPREAD	:	1.741	1.562	1.325
EXTREME SPREAD	:	2.566	2.388	2.211
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.397	.847	.691
MINIMUM X	:	-1.403	-1.248	-.876
MAXIMUM Y	:	.886	.946	.945
MINIMUM Y	:	-.916	-.856	-.857
CENTROID X	:	-.016	-.171	-.015
CENTROID Y	:	-.124	-.184	-.183
POA TO CENTROID in.	:	.125	.251	.183
MIN RADIUS	:	.199	.197	.244
MEAN RADIUS	:	.787	.690	.618
MAX RADIUS	:	1.499	1.248	1.081
HORIZONTAL SPREAD	:	2.800	2.095	1.567
VERTICAL SPREAD	:	1.802	1.802	1.802
EXTREME SPREAD	:	2.867	2.153	1.917
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington
DUPONT
Reg. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm
MODEL 700TH M24
SERIAL NO.
C6498825
ORDER NO.
5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.
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