C6498863

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498863

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	K.R
615	Rollmark Caliber		7-12-90	D.L.
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	RH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/14/90	KS
	C) Inspect Ejector Hole for Chamfer		8/14/90	KS
	D) Oil Firing Pin Ass'y		8/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/15/90	RH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/30/90	[illegible]
	G) Safety Off Force	3	3	3			7/30/90	[illegible]
	H) Trigger Pull Test & Retainability						8/15/90	[illegible]
	I) Firing Pin Indent	.023	.023	.023			7/30/90	[illegible]
	J) Assemble Stock						8/15/90	KS
	K) Assemble Swivel Studs						8/29/90	[illegible]
	L) Attach Front and Rear Sight Assemblies						8/15/90	KS
	M) Iron Sight Alignment						8/15/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/15/90	KS
	O) Attach Scope to Rifle						8/15/90	KS
	P) Detach & Attach Scope 20 Times						8/15/90	KS
640	Gallery Target & Test						8-16-90	KJ
	A) Time						8-16-90	KJ
	B) Malfunctions						8-16-90	KJ
	C) Pierced Primers						8-16-90	KJ
	D) Optical Clearity of Scope						8-16-90	KJ
645	Inspect for Live Ammo						8-16-90	KJ
655	Final Inspection A) Headspace						8/29/90	[illegible]
	B) Trigger Pull	2.55	2.54	2.50	2.19	2.18	8/21/90	[illegible]
	C) Function						8/29/90	[illegible]
660	Pack						9/20/90	[illegible]

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498863
DATE 8/15/90
TESTER GH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.36	2.40	2.55	MIN. SETTING,
PULL #2	2.37	2.33	2.36	2.54	NO AVG. OF 5
PULL #3	2.44	2.36	2.39	2.50	READINGS ACCEPT-
PULL #4	2.35	2.39	2.33	2.19	ABLE LESS THAN 2#
PULL #5	2.34	2.38	2.30	2.18	
TOTAL	11.84	11.82	11.78	11.96	
AVG.	2.368	2.364	2.356	2.392	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.33		
PULL #2	3.10	3.30		
PULL #3	3.25	3.33		
PULL #4	3.25	3.36		
PULL #5	3.33	3.40		
TOTAL	16.07	16.72		
AVG.	3.214	3.344		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.46		4.21
PULL #2	4.21	4.49		4.25
PULL #3	4.24	4.20		4.34
PULL #4	4.22	4.15		4.37
PULL #5	4.30	4.30		4.36
TOTAL	21.07	21.70		21.53
AVG.	4.214	4.34		4.306

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF		Adjust Mag.	8/16/90
TEST	✓	BOX	
TGT			RW
PROOF			
TEST			
TGT			
PROOF		ENGINEER	
TEST			
TGT			
PROOF		ENGINEER	
TEST			
TGT			

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

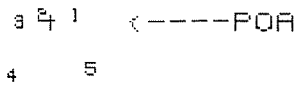
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	TIGHT mag Box	
	2nd		
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498863
17 Aug 1990

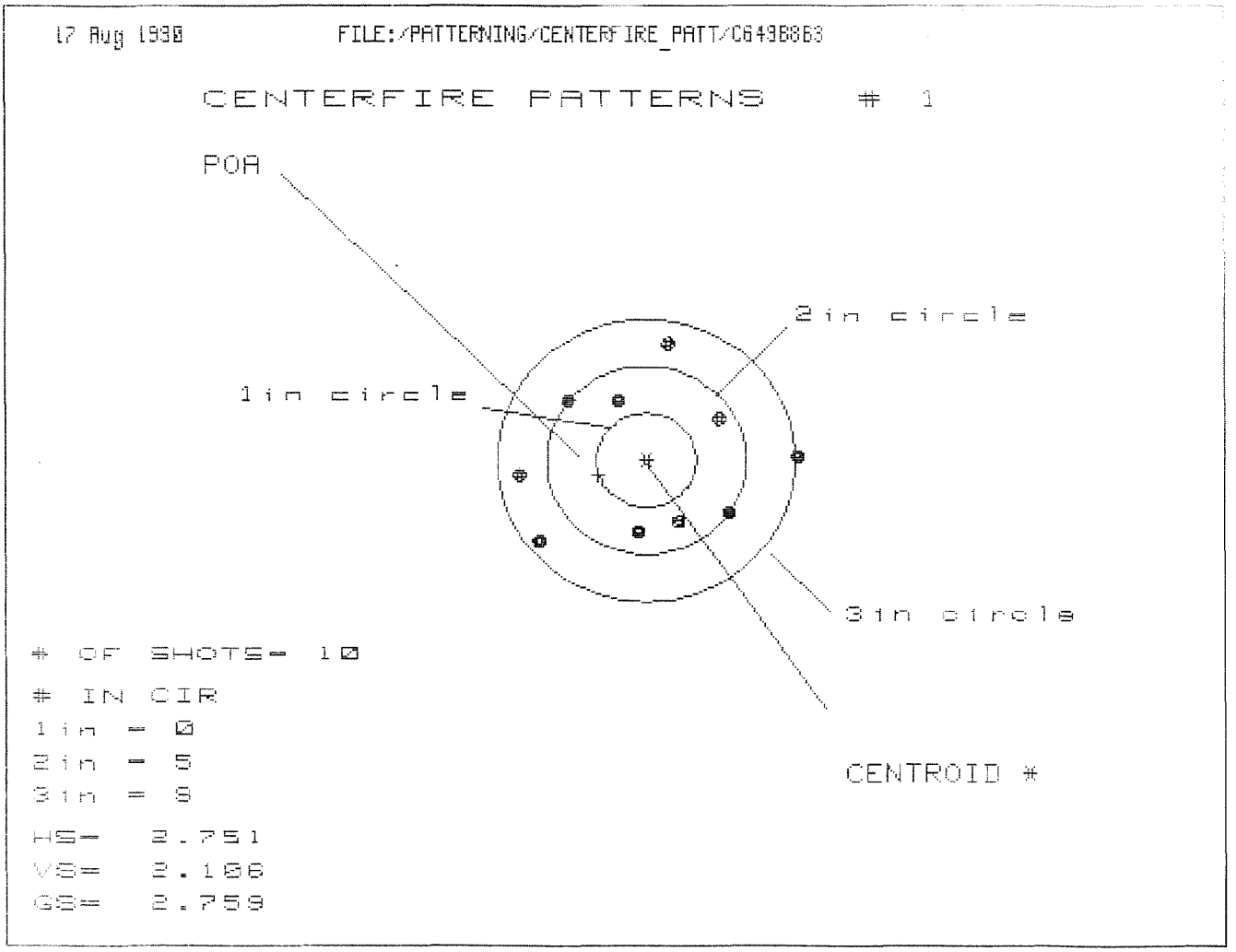
CENTROIDAL DISTANCES

0	TO	1	.503123
1	TO	2	.611138
1	TO	3	1.04638
1	TO	4	1.6548
1	TO	5	1.05784

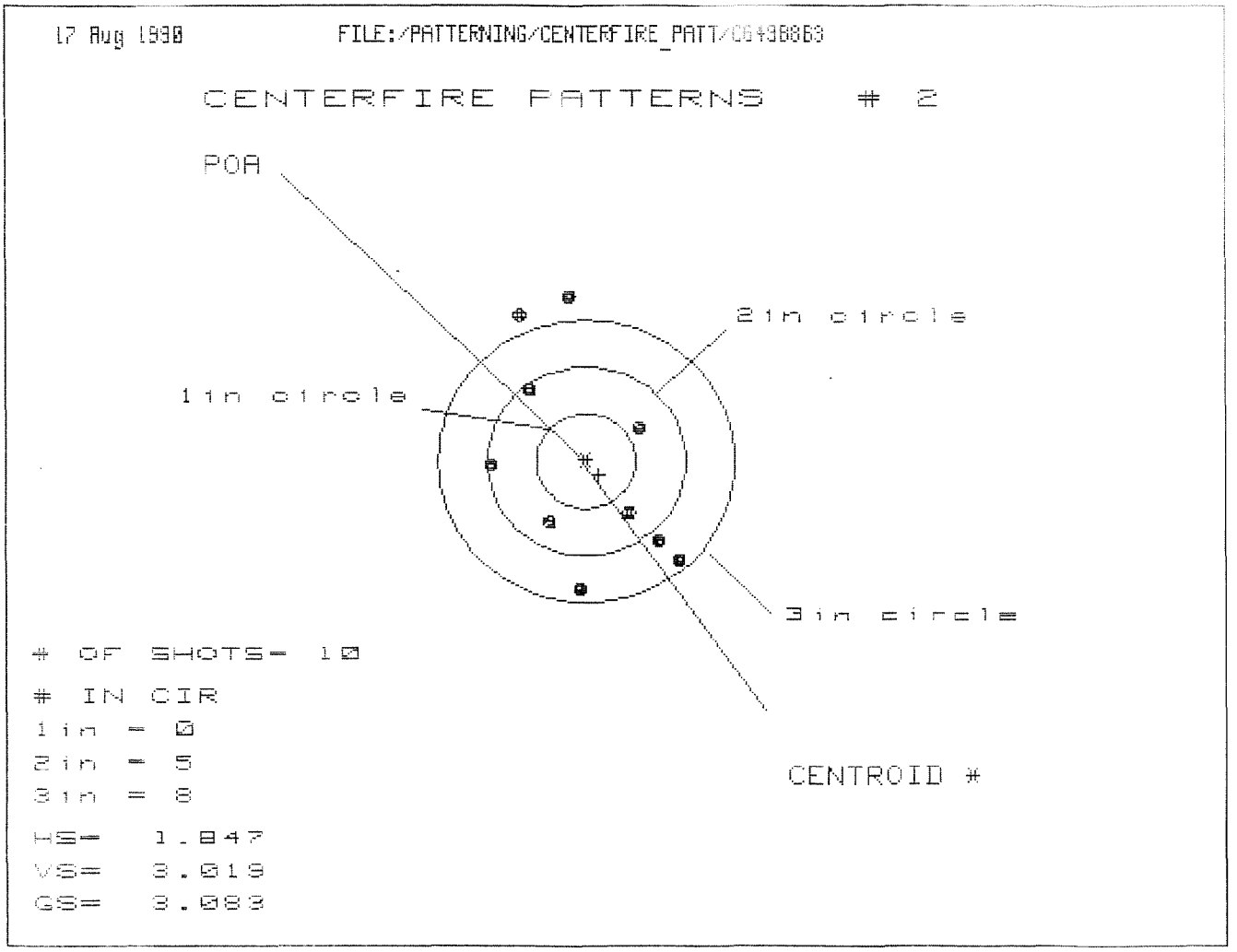


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0292
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3086
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .309978

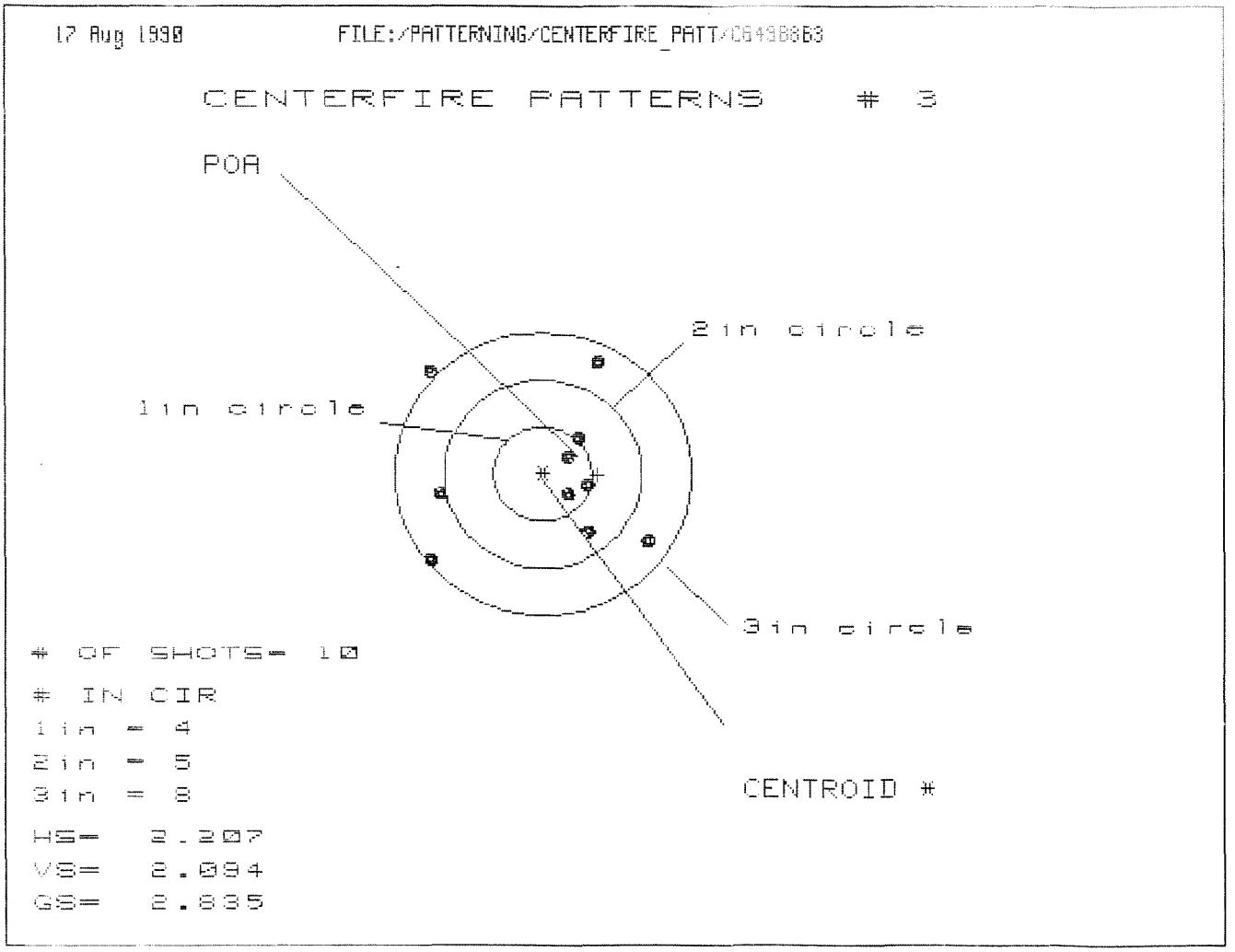
THE AMR FOR THIS RIFLE IS: 1.075



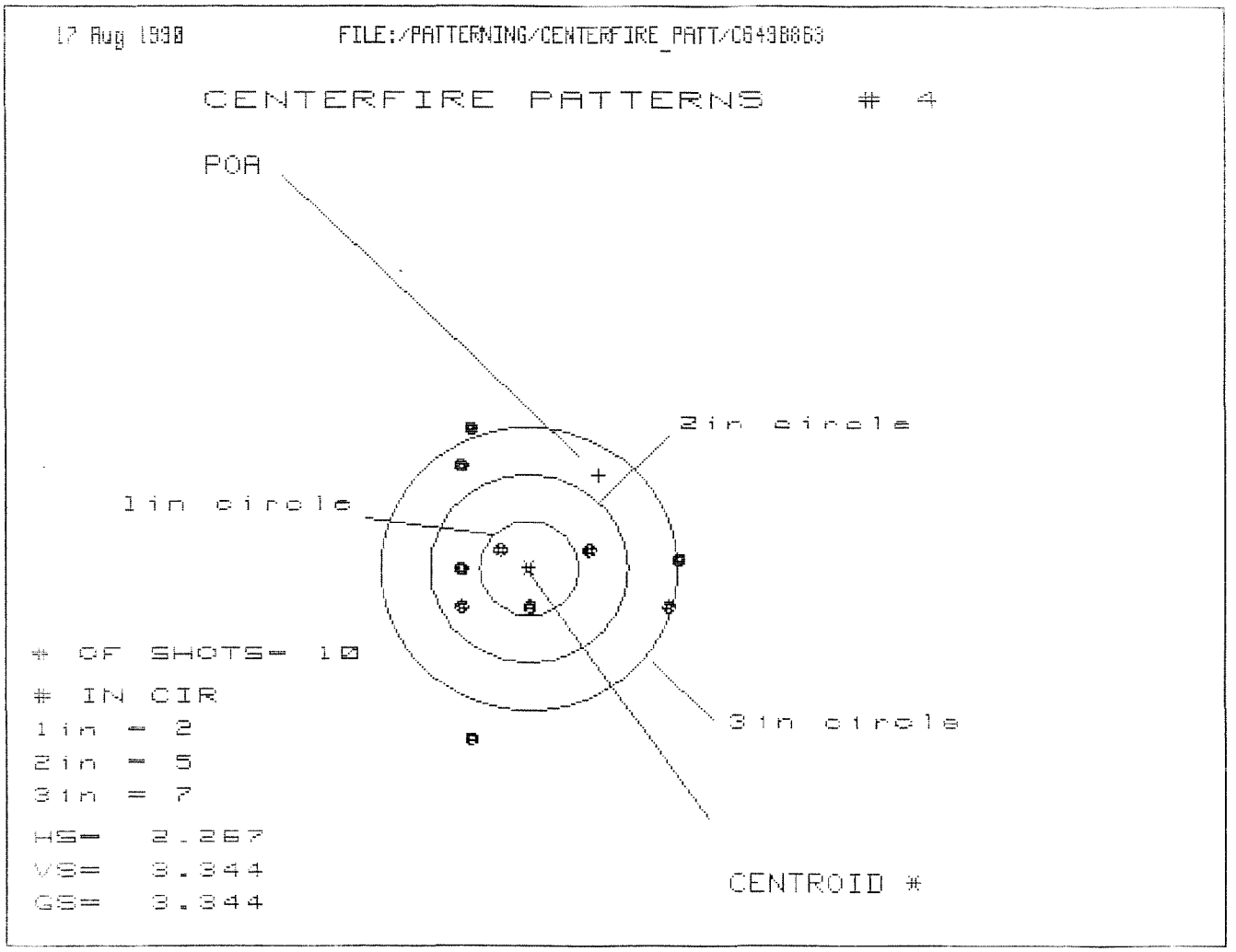
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.512	.955	.840
MINIMUM X	:	-1.239	-1.071	-1.186
MAXIMUM Y	:	1.277	1.281	1.178
MINIMUM Y	:	-.829	-.825	-.860
CENTROID X	:	.478	.310	.425
CENTROID Y	:	.157	.153	.256
POA TO CENTROID in.	:	.503	.346	.496
MIN RADIUS	:	.701	.643	.588
MEAN RADIUS	:	1.049	.989	.948
MAX RADIUS	:	1.512	1.341	1.219
HORIZONTAL SPREAD	:	2.751	2.026	2.026
VERTICAL SPREAD	:	2.106	2.106	2.038
EXTREME SPREAD	:	2.759	2.482	2.069
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.922	.904	.824
MINIMUM X	:	-.925	-.943	-1.024
MAXIMUM Y	:	1.722	1.788	1.183
MINIMUM Y	:	-1.297	-1.106	-.882
CENTROID X	:	-.133	-.115	-.034
CENTROID Y	:	.144	-.047	-.271
POA TO CENTROID in.	:	.196	.124	.273
MIN RADIUS	:	.677	.583	.395
MEAN RADIUS	:	1.132	1.032	.873
MAX RADIUS	:	1.729	1.900	1.360
HORIZONTAL SPREAD	:	1.847	1.847	1.847
VERTICAL SPREAD	:	3.019	2.894	2.065
EXTREME SPREAD	:	3.083	3.083	2.369
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



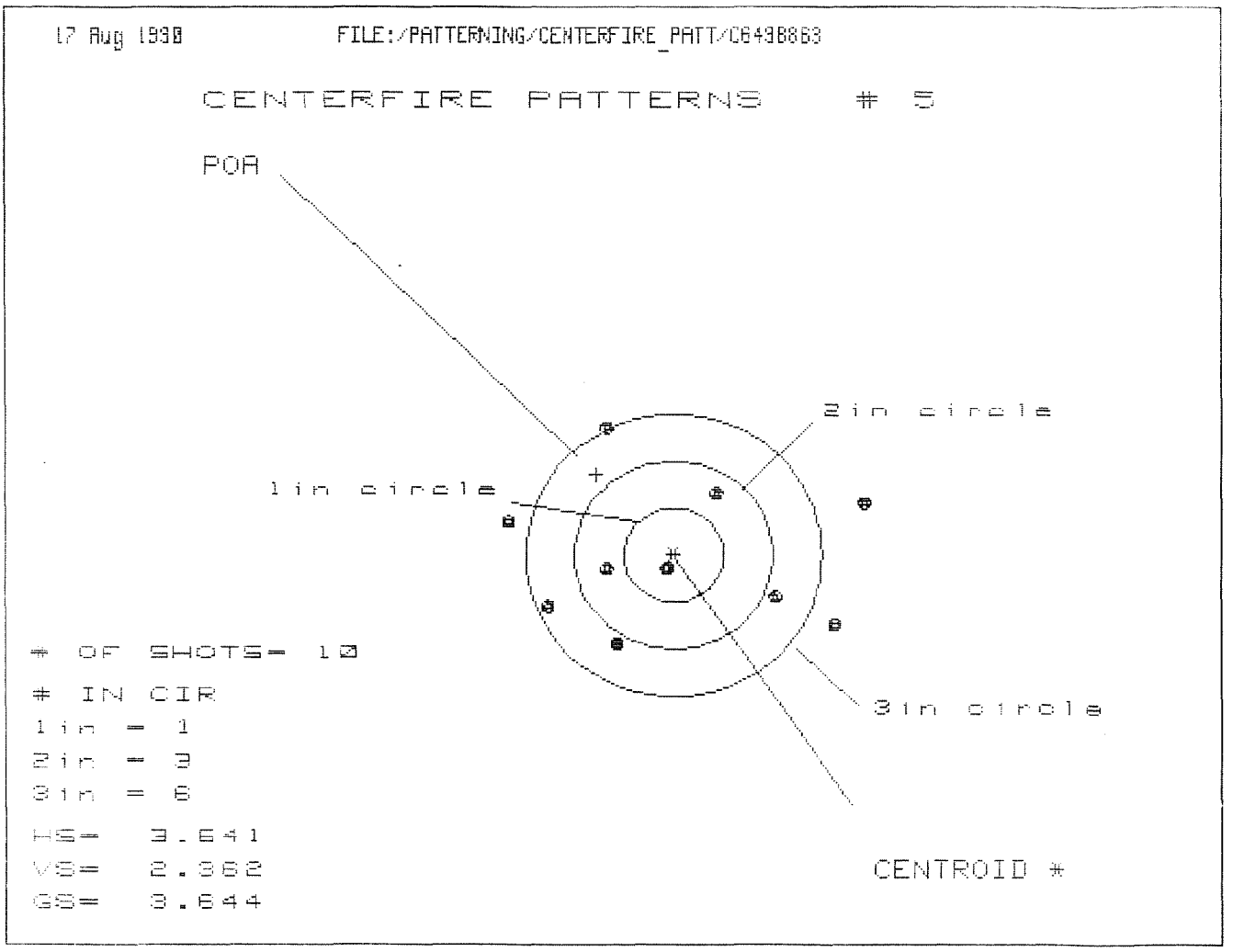
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.919	.757
MINIMUM X	:	-1.164	-1.288	-1.321
MAXIMUM Y	:	1.146	1.269	1.165
MINIMUM Y	:	-.948	-.825	-.712
CENTROID X	:	-.558	-.434	-.272
CENTROID Y	:	.010	-.113	-.010
POA TO CENTROID in.	:	.558	.448	.273
MIN RADIUS	:	.267	.095	.154
MEAN RADIUS	:	.896	.777	.638
MAX RADIUS	:	1.571	1.530	1.334
HORIZONTAL SPREAD	:	2.207	2.207	2.078
VERTICAL SPREAD	:	2.094	2.094	1.878
EXTREME SPREAD	:	2.835	2.733	2.143
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



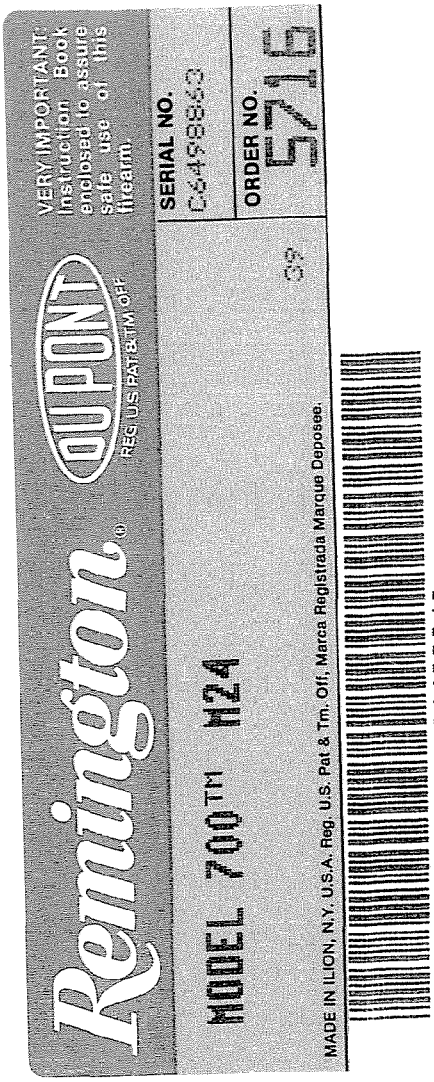
PATTERN # : **4**

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.538	1.470	1.385
MINIMUM X	:	-.729	-.797	-.882
MAXIMUM Y	:	1.545	1.345	1.050
MINIMUM Y	:	-1.799	-.628	-.460
CENTROID X	:	-.709	-.641	-.556
CENTROID Y	:	-.996	-.796	-.964
POA TO CENTROID in.	:	1.223	1.022	1.113
MIN RADIUS	:	.314	.337	.441
MEAN RADIUS	:	1.066	.981	.900
MAX RADIUS	:	1.902	1.507	1.385
HORIZONTAL SPREAD	:	2.267	2.267	2.267
VERTICAL SPREAD	:	3.344	1.973	1.510
EXTREME SPREAD	:	3.344	2.771	2.499

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 7



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.954	1.799	1.514
MINIMUM X	:	-1.687	-1.470	-1.245
MAXIMUM Y	:	1.381	1.438	1.358
MINIMUM Y	:	.981	-.924	-1.004
CENTROID X	:	.076	.559	.334
CENTROID Y	:	-.858	-.915	-.835
POA TO CENTROID in.	:	1.157	1.072	.899
MIN RADIUS	:	.163	.119	.317
MEAN RADIUS	:	1.233	1.111	1.000
MAX RADIUS	:	2.021	1.909	1.571
HORIZONTAL SPREAD	:	3.641	3.269	2.759
VERTICAL SPREAD	:	2.362	2.362	2.362
EXTREME SPREAD	:	3.644	3.439	2.864
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24
SERIAL NO.
C6498863
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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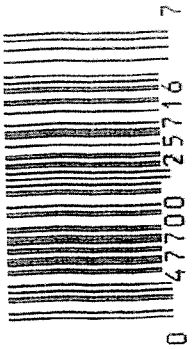
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