

C6523388

MODEL 700TM M24

Model **SWS** TM

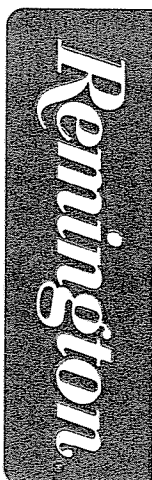
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6523388

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/23/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/23/93	RW
	C) Inspect Ejector Hole for Chamfer		2/23/93	RW
	D) Oil Firing Pin Ass'y		2/23/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/23/93	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/23/93	RW
	G) Safety Off Force	3	3	2.5			2/23/93	RW
	H) Trigger Pull Test & Retainability						2/23/93	RW
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle						2/23/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						3/2/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						3/2/93	RW
655	Final Inspection						3/2/93	RW
	A) Headspace						3/2/93	RW
	B) Trigger Pull	2.69	2.55	2.48	2.43	2.40	3/2/93	RW
	C) Function						3/2/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523388

DATE 2/23/93

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.53	2.40	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.33	2.34	
PULL #3	2.53	2.26	2.32	
PULL #4	2.51	2.32	2.30	
PULL #5	2.53	2.31	2.36	
TOTAL	12.67	11.62	11.62	
AVG.	2.53	2.32	2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.15	3.20	
PULL #2	3.14	3.14	
PULL #3	3.13	3.27	
PULL #4	3.03	3.10	
PULL #5	3.02	3.27	
TOTAL	15.47	15.88	
AVG.	3.09	3.18	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.15		4.22
PULL #2	4.04	4.08		4.25
PULL #3	4.11	4.10		4.13
PULL #4	4.12	4.04		4.15
PULL #5	4.12	4.12		4.07
TOTAL	20.49	20.49		20.82
AVG.	4.10	4.10		4.16

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

Remington®

MODEL 700™ M24

REG. U.S. PAT. & TM. OFF.

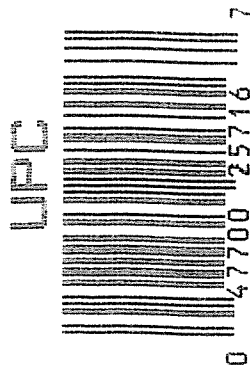
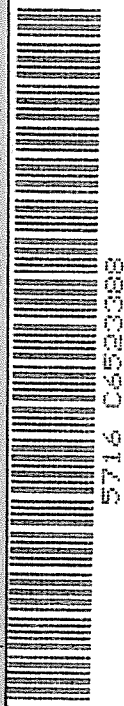
DUPONT

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

SERIAL NO.
C6523388

ORDER NO.
5716

Q1



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523388

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	K.R.
	Magnaflux Bolt		9-25-90	K.R.
615	Rollmark Caliber		9-25-90 G.S.	⊙
617	Drill and Tap Sight Holes		9-25-90	F.B.
618	Polish Barrel AB		9/25/90	W.B.
620	Apply Coatings (Barrel Action)		10-2-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/18/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
655 nt.	F) Safety On Force	5	5	5			10/24/90	WLB
	G) Safety Off Force	2	2	2			10/24/90	WLB
	H) Trigger Pull Test & Retainability						10/18/90	JH
	I) Firing Pin Indent	.0205	.0205	.0205			10/24/90	WLB
	J) Assemble Stock						10/26/90	RW
	K) Assemble Swivel Studs						3/18/90	JS
	L) Attach Front and Rear Sight Assemblies						10/26/90	RW
	M) Iron Sight Alignment						10/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/26/90	RW
	O) Attach Scope to Rifle						10/26/90	RW
	P) Detach & Attach Scope 20 Times						10/26/90	RW
640	Gallery Target & Test						10-29-90	AC
	A) Time						10-29-90	AC
	B) Malfunctions						10-29-90	AC
	C) Pierced Primers						10-29-90	AC
	D) Optical Clarity of Scope						10-29-90	AC
645	Inspect for Live Ammo						10-29-90	AC
655	Final Inspection						3/18/90	JS
	A) Headspace						3/18/90	JS
	B) Trigger Pull	239	239	227	228	237	3/18/90	JS
	C) Function						3/18/90	JS
660	Pack						12/7/90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523388

DATE 10/18/90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.29	2.35	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.34	2.31	2.39	
PULL #3	2.28	2.35	2.35	2.27	
PULL #4	2.31	2.25	2.32	2.28	
PULL #5	2.33	2.41	2.21	2.37	
TOTAL	11.62	11.64	11.54		
AVG.	2.324	2.328	2.308		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.37		
PULL #2	3.48	3.34		
PULL #3	3.46	3.45		
PULL #4	3.45	3.34		
PULL #5	3.47	3.39		
TOTAL	17.43	16.89		
AVG.	3.486	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.37		4.43
PULL #2	4.47	4.48		4.48
PULL #3	4.48	4.47		4.45
PULL #4	4.49	4.49		4.44
PULL #5	4.43	4.46		4.39
TOTAL	22.37	22.27		22.19
AVG.	4.474	4.454		4.438

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523388
29 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.150233
1 TO	2	.149251
1 TO	3	.309013
1 TO	4	.203953
1 TO	5	.10655

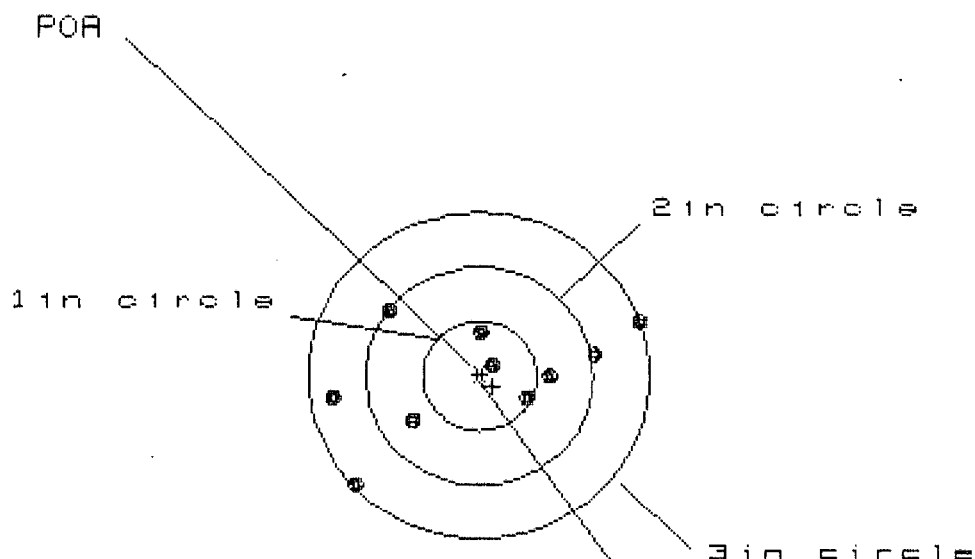
41 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0512
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0406
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0653437
THE AMR FOR THIS RIFLE IS: .7654

29 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B8

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.696

VS= 1.635

GS= 2.862

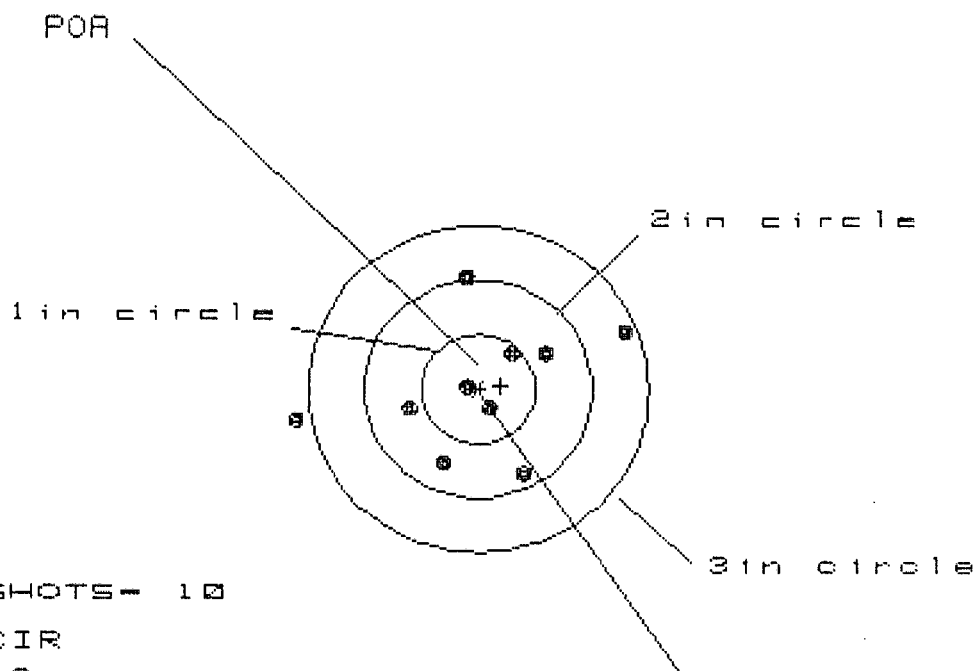
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	1.205	1.094
MINIMUM X	-1.303	-1.148	-1.259
MAXIMUM Y	.611	.665	.543
MINIMUM Y	-1.024	-.970	-.434
CENTROID X	-.113	-.268	-.157
CENTROID Y	.099	.045	.167
POA TO CENTROID in.	.150	.272	.229
MIN RADIUS	.165	.321	.169
MEAN RADIUS	.868	.817	.718
MAX RADIUS	1.475	1.313	1.282
HORIZONTAL SPREAD	2.696	2.353	2.353
VERTICAL SPREAD	1.635	1.635	.977
EXTREME SPREAD	2.862	2.423	2.383
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

29 Oct 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.967

VS= 1.798

GS= 3.077

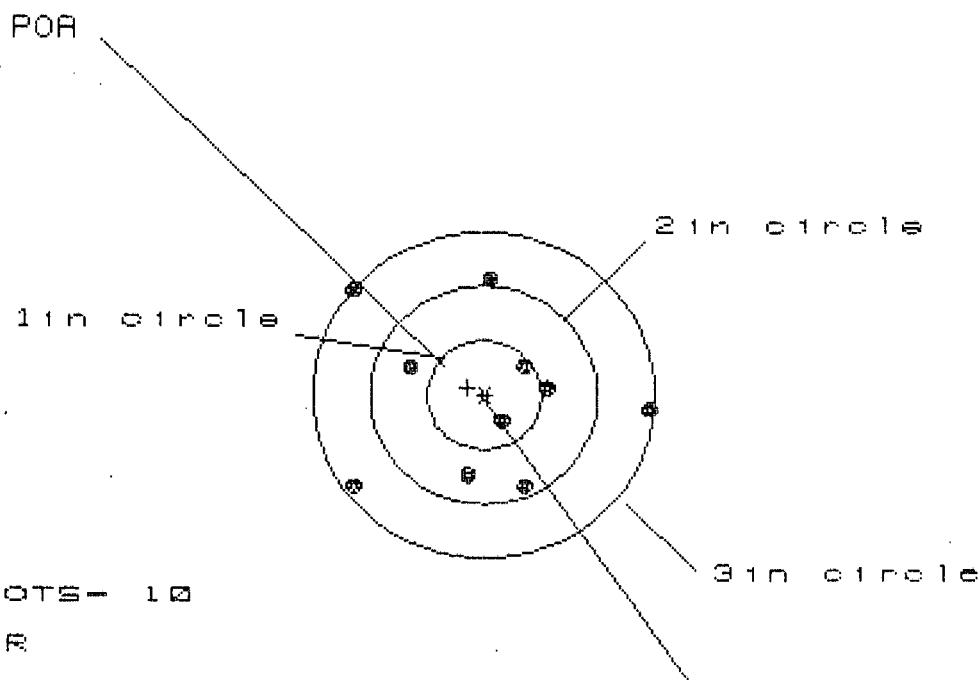
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	1.131	.533
MINIMUM X	:	-1.653	-.759	-.618
MAXIMUM Y	:	.980	.948	1.009
MINIMUM Y	:	-.818	-.850	-.789
CENTROID X	:	-.193	-.010	-.151
CENTROID Y	:	-.027	.005	-.056
POA TO CENTROID in.	:	.195	.011	.161
MIN RADIUS	:	.128	.199	.146
MEAN RADIUS	:	.781	.679	.588
MAX RADIUS	:	1.679	1.231	1.019
HORIZONTAL SPREAD	:	2.967	1.890	1.151
VERTICAL SPREAD	:	1.798	1.798	1.798
EXTREME SPREAD	:	3.077	2.028	1.878
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

29 Oct 1990

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.619

VS= 1.863

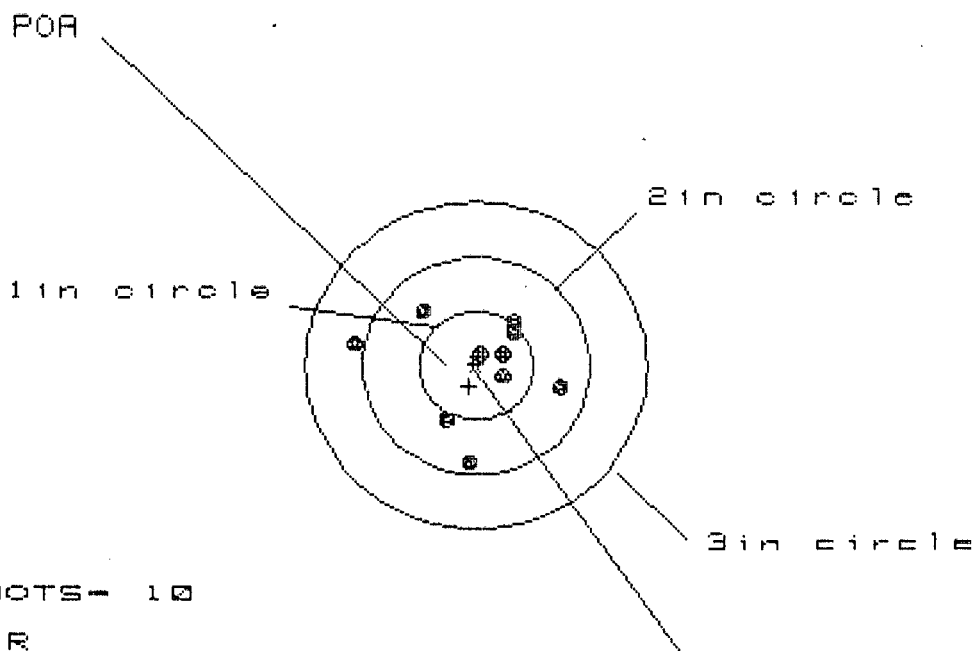
GS= 2.826

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.339	.640
MINIMUM X	:	-1.156	-1.280	-1.112
MAXIMUM Y	:	1.063	1.173	1.165
MINIMUM Y	:	-.800	-.690	-.698
CENTROID X	:	.147	.271	.104
CENTROID Y	:	-.068	-.178	-.170
POA TO CENTROID in.	:	.162	.324	.199
MIN RADIUS	:	.297	.145	.253
MEAN RADIUS	:	.912	.817	.766
MAX RADIUS	:	1.490	1.454	1.313
HORIZONTAL SPREAD	:	2.619	2.619	1.753
VERTICAL SPREAD	:	1.863	1.863	1.863
EXTREME SPREAD	:	2.826	2.693	2.239
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.880

VS= 1.333

GS= 1.935

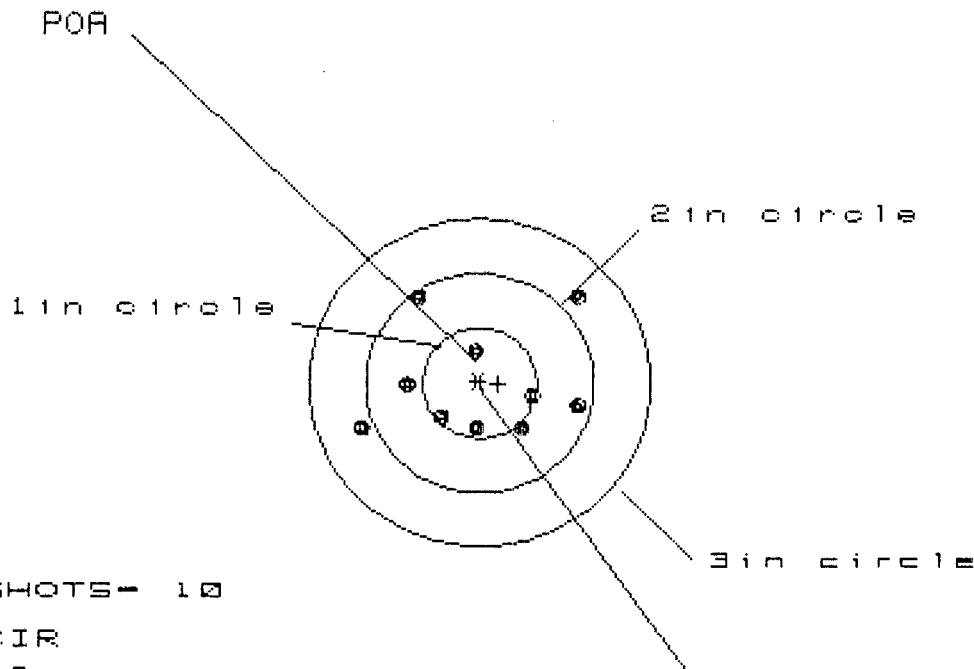
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.781	.659	.639
MINIMUM X	:	-1.099	-.615	-.635
MAXIMUM Y	:	.458	.483	.377
MINIMUM Y	:	-.875	-.850	-.526
CENTROID X	:	.068	.190	.210
CENTROID Y	:	.193	.168	.274
POA TO CENTROID in.	:	.204	.254	.346
MIN RADIUS	:	.102	.094	.114
MEAN RADIUS	:	.558	.471	.400
MAX RADIUS	:	1.121	.865	.738
HORIZONTAL SPREAD	:	1.880	1.274	1.274
VERTICAL SPREAD	:	1.333	1.333	.903
EXTREME SPREAD	:	1.935	1.452	1.452
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.899

VS= 1.235

GS= 2.253

CENTROID *

PATTERN #	15	16	17
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.911	.990	.879
MINIMUM X	-.988	-.887	-.691
MAXIMUM Y	.781	.865	.819
MINIMUM Y	-.454	-.370	-.349
CENTROID X	-.165	-.266	-.155
CENTROID Y	.006	-.078	-.032
POA TO CENTROID in.	.165	.277	.158
MIN RADIUS	.342	.311	.351
MEAN RADIUS	.708	.639	.596
MAX RADIUS	1.185	.998	1.006
HORIZONTAL SPREAD	1.899	1.877	1.570
VERTICAL SPREAD	1.235	1.235	1.168
EXTREME SPREAD	2.253	1.892	1.771
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

