

C6522273

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 # C6522273

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace		90	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		8/17/90	KR
	Magnaflux Bolt		8/17/90	KR
615	Rollmark Caliber		8/17/90	GS
617	Drill and Tap Sight Holes		8/17/90	GS
618	Polish Barrel <i>P.B.</i>		8/17/90	GS
620	Apply Coatings (Barrel Action)		8/24/90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/90	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/5/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			9/5/90	WB
	H) Trigger Pull Test & Retainability						9/31/90	CS
	I) Firing Pin Indent	.023	.023	.023			9/5/90	WB
	J) Assemble Stock						9/8/90	RW
	K) Assemble Swivel Studs						9/11/90	JS
	L) Attach Front and Rear Sight Assemblies						9/8/90	RW
	M) Iron Sight Alignment						9/8/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/8/90	RW
	O) Attach Scope to Rifle						9/8/90	RW
	P) Detach & Attach Scope 20 Times						9/8/90	RW
640	Gallery Target & Test						9-9-90	DH
	A) Time						9-9-90	DH
	B) Malfunctions						9-9-90	DH
	C) Pierced Primers						9-9-90	DH
	D) Optical Clarity of Scope						9-9-90	DH
645	Inspect for Live Ammo						9-9-90	DH
655	Final Inspection							
	A) Headspace						9/11/90	LB
	B) Trigger Pull	2.40	2.46	2.43	2.60	2.53	9/10/90	WB
	C) Function						9/11/90	JS
660	Pack						9/9/90	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522273

DATE 8/31/90

TESTER 918

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	259	219	239	240	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	278	204	233	246	
PULL #3	263	208	222	243	
PULL #4	239	217	216	260	
PULL #5	220	217	218	253	
TOTAL	1259	1065	1120	1242	
AVG.	252	213	224	248	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	351	342		
PULL #2	350	335		
PULL #3	346	346		
PULL #4	338	340		
PULL #5	343	333		
TOTAL	1728	1696		
AVG.	345	339		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	397	392		438
PULL #2	393	397		444
PULL #3	400	403		442
PULL #4	390	400		438
PULL #5	391	403		423
TOTAL	1971	1995		2185
AVG.	394	399		437

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522273
9 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.220912
1 TO	2	.564653
1 TO	3	.237777
1 TO	4	.30269
1 TO	5	.172456

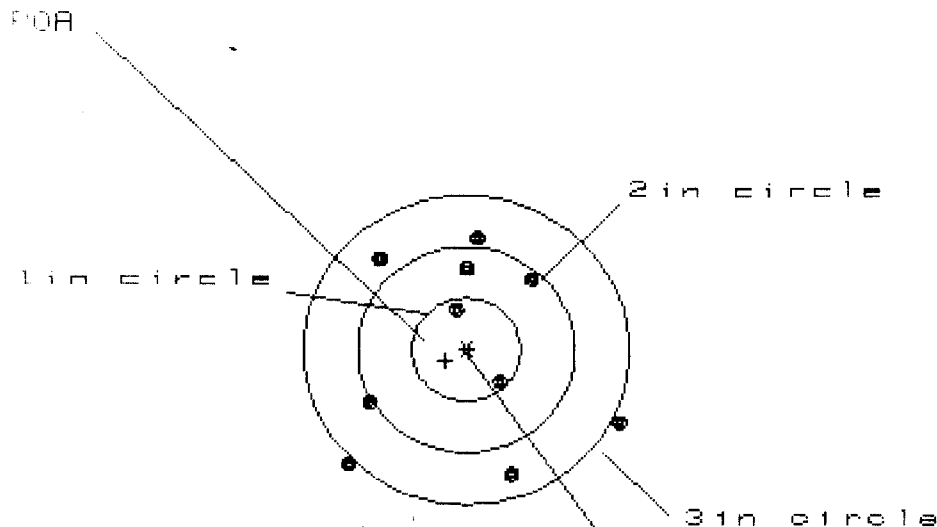
$\bar{x}_1$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.6416
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204476
THE AOR FOR THIS RIFLE IS: .939

VS

FILE:/PATTERNING/CENTERFIRE_PATT/06522273

CENTERFIRE PATTERNS # 1



BEST OF SHOTS- 10

IN CIR

1 in - 2

2 in - 4

3 in - 8

HS- 2.527

VS- 2.259

GS- 2.765

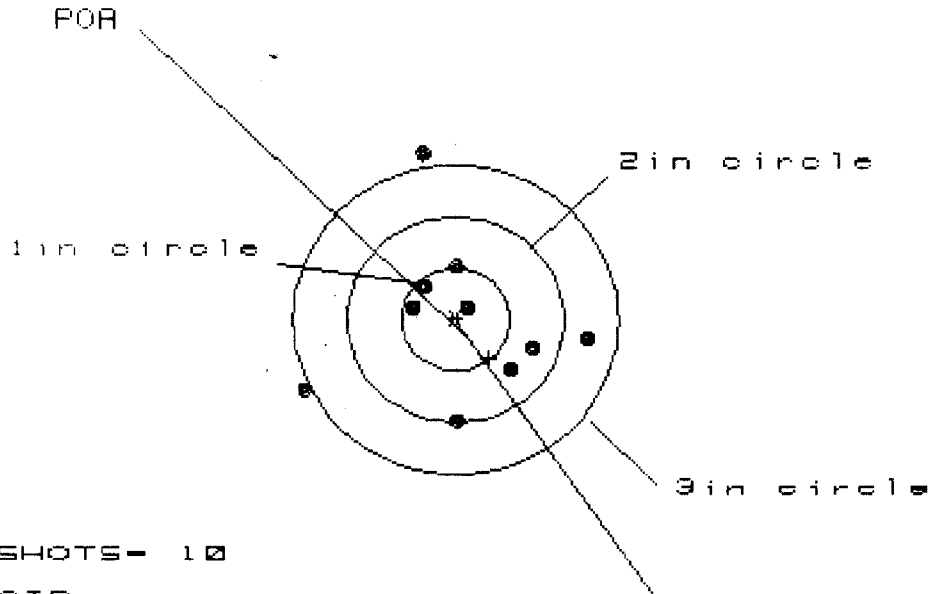
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.428	1.306	.647
MINIMUM X	-1.099	-1.015	-.852
MAXIMUM Y	1.057	.929	.825
MINIMUM Y	-1.202	-1.330	-1.434
CENTROID X	.191	.313	.150
CENTROID Y	.111	.239	.343
POA TO CENTROID in.	.221	.394	.375
MIN RADIUS	.431	.350	.195
MEAN RADIUS	1.033	.942	.834
STD RADIUS	1.596	1.549	1.493
HORIZONTAL SPREAD	2.527	2.321	1.499
VERTICAL SPREAD	2.259	2.259	2.259
MEAN SPREAD	2.765	2.765	2.437
IN ONE INCH CIRCLE =		2	
IN TWO INCH CIRCLE =		4	
IN THREE INCH CIRCLE =		8	

5 Sep 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.629

VS= 2.609

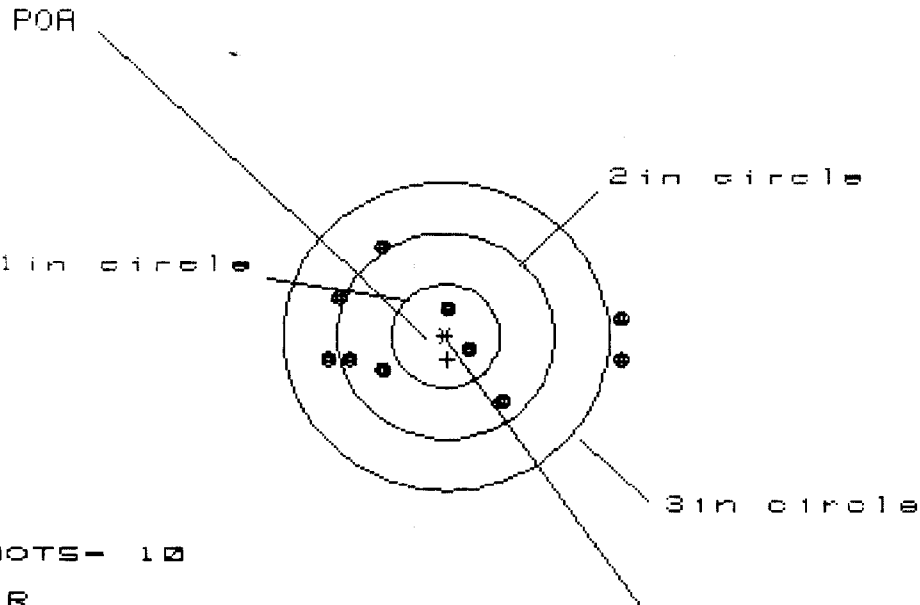
GS= 2.693

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.202	1.168	.985
MINIMUM X	:	-1.427	-1.461	-.650
MAXIMUM Y	:	1.632	.733	.665
MINIMUM Y	:	-.977	-.796	-.864
CENTROID X	:	-.306	-.272	-.089
CENTROID Y	:	.379	.198	.266
POA TO CENTROID in.	:	.487	.336	.280
MIN RADIUS	:	.122	.271	.236
MEAN RADIUS	:	.853	.774	.654
MAX RADIUS	:	1.660	1.558	.986
HORIZONTAL SPREAD	:	2.629	2.629	1.635
VERTICAL SPREAD	:	2.609	1.529	1.529
EXTREME SPREAD	:	2.693	2.693	1.651
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Sep 1938

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.791

VS= 1.568

GS= 2.824

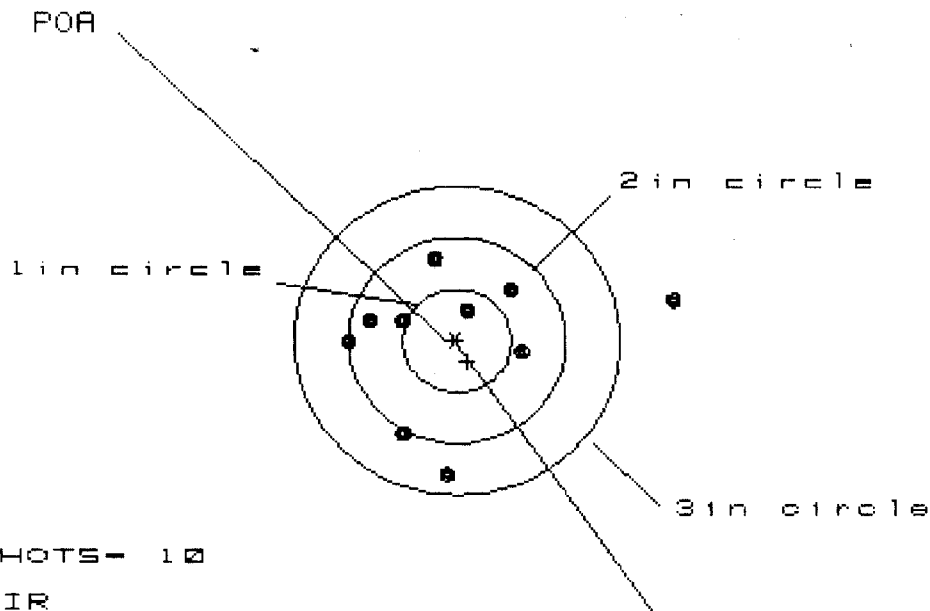
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.660	1.795	.905
MINIMUM X	:	-1.131	-.947	-.722
MAXIMUM Y	:	.914	.934	.910
MINIMUM Y	:	-.654	-.634	-.658
CENTROID X	:	-.016	-.200	-.425
CENTROID Y	:	.228	.208	.232
POA TO CENTROID in.	:	.228	.289	.484
MIN RADIUS	:	.276	.386	.381
MEAN RADIUS	:	.950	.849	.696
MAX RADIUS	:	1.669	1.805	1.119
HORIZONTAL SPREAD	:	2.791	2.742	1.627
VERTICAL SPREAD	:	1.568	1.568	1.568
EXTREME SPREAD	:	2.824	2.742	1.876
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Sep 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 3.006

VS= 2.141

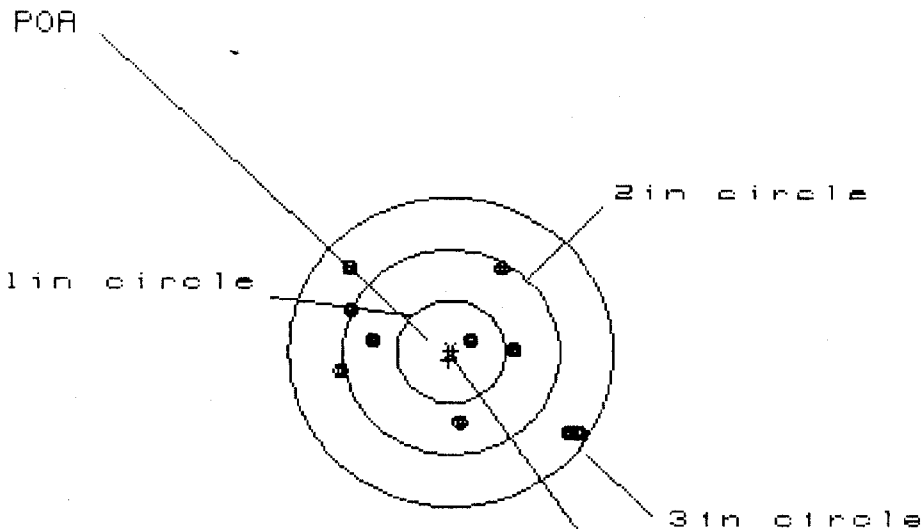
GS= 3.028

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.960	.843	.860
MINIMUM X	:	-1.046	-.828	-.811
MAXIMUM Y	:	.819	.860	.700
MINIMUM Y	:	-1.322	-1.281	-1.018
CENTROID X	:	-.098	-.316	-.333
CENTROID Y	:	.201	.160	.320
POA TO CENTROID in.	:	.224	.354	.461
MIN RADIUS	:	.303	.405	.323
MEAN RADIUS	:	.930	.790	.695
MAX RADIUS	:	1.996	1.287	1.042
HORIZONTAL SPREAD	:	3.006	1.671	1.671
VERTICAL SPREAD	:	2.141	2.141	1.718
EXTREME SPREAD	:	3.028	2.144	1.739
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Sep 1990

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.200

VS= 1.689

GS= 2.632

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.172	1.189	.878
MINIMUM X	:	-1.028	-.898	-.749
MAXIMUM Y	:	.862	.770	.665
MINIMUM Y	:	-.827	-.833	-.889
CENTROID X	:	.021	-.109	-.258
CENTROID Y	:	.082	.174	.279
POA TO CENTROID in.	:	.085	.206	.380
MIN RADIUS	:	.228	.303	.447
MEAN RADIUS	:	.929	.864	.776
MAX RADIUS	:	1.435	1.452	1.025
HORIZONTAL SPREAD	:	2.200	2.087	1.627
VERTICAL SPREAD	:	1.689	1.603	1.554
EXTREME SPREAD	:	2.632	2.490	1.857
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6522273

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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5716 C6522273

UPC



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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0001898 M2400001929