

C6522249

MODEL 700™ M24

Model **SWS**™

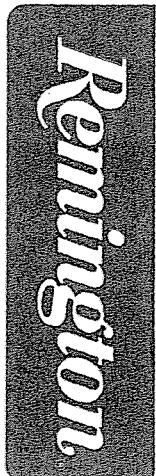
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522249

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/90	KJ
600	Proof		6/26/90	KJ
607	Check Headspace		6/26/90	KJ
610	Dis-assemble Gun		6/26/90	KJ
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	LS
617	Drill and Tap Sight Holes		7/10/90	LS
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/10/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/10/90	KS
	C) Inspect Ejector Hole for Chamfer		8/10/90	KS
	D) Oil Firing Pin Ass'y		8/10/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-11-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/8/90	JK
	G) Safety Off Force	2	2	2			8/8/90	JK
	H) Trigger Pull Test & Retainability						9-11-90	JK
	I) Firing Pin Indent	.023	.023	.023			8/8/90	JK
	J) Assemble Stock						8/13/90	KS
	K) Assemble Swivel Studs						9/12/90	JK
	L) Attach Front and Rear Sight Assemblies						8/13/90	KS
	M) Iron Sight Alignment						8/13/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/13/90	KS
	O) Attach Scope to Rifle						8/13/90	KS
	P) Detach & Attach Scope 20 Times						8/13/90	KS
640	Gallery Target & Test						8-14-90	DH
	A) Time						8-14-90	DH
	B) Malfunctions						8-14-90	DH
	C) Pierced Primers						8-14-90	DH
	D) Optical Clarity of Scope						8-14-90	DH
645	Inspect for Live Ammo						8-14-90	DH
655	Final Inspection							
	A) Headspace						9/12/90	JK
	B) Trigger Pull	2.41	2.50	2.34	2.42	2.25	9-11-90	JK
	C) Function						9/12/90	JK
660	Pack						9/19/90	JK

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522249

DATE 9-11-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.35	2.30	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.49	2.46	2.50	
PULL #3	2.30	2.34	2.46	2.34	
PULL #4	2.41	2.46	2.43	2.42	
PULL #5	2.40	2.29	2.25	2.25	
TOTAL	12.03	11.93	11.90	11.92	
AVG.	2.406	2.386	2.38	2.384	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.40		
PULL #2	3.48	3.27		
PULL #3	3.34	3.26		
PULL #4	3.23	3.42		
PULL #5	3.41	3.29		
TOTAL	16.83	16.64		
AVG.	3.366	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.50		4.29
PULL #2	4.27	4.35		4.39
PULL #3	4.15	4.35		4.31
PULL #4	4.14	4.42		4.16
PULL #5	4.36	4.18		4.21
TOTAL	21.17	21.80		21.36
AVG.	4.234	4.36		4.272

CENTRICAL DISTANCE CALCULATIONS
 FOR RIFLE # C6522249
 14 Sep 1990

CENTRICAL DISTANCES

1	.54814
2	.7221
3	1.08276
4	.944153
5	.71348

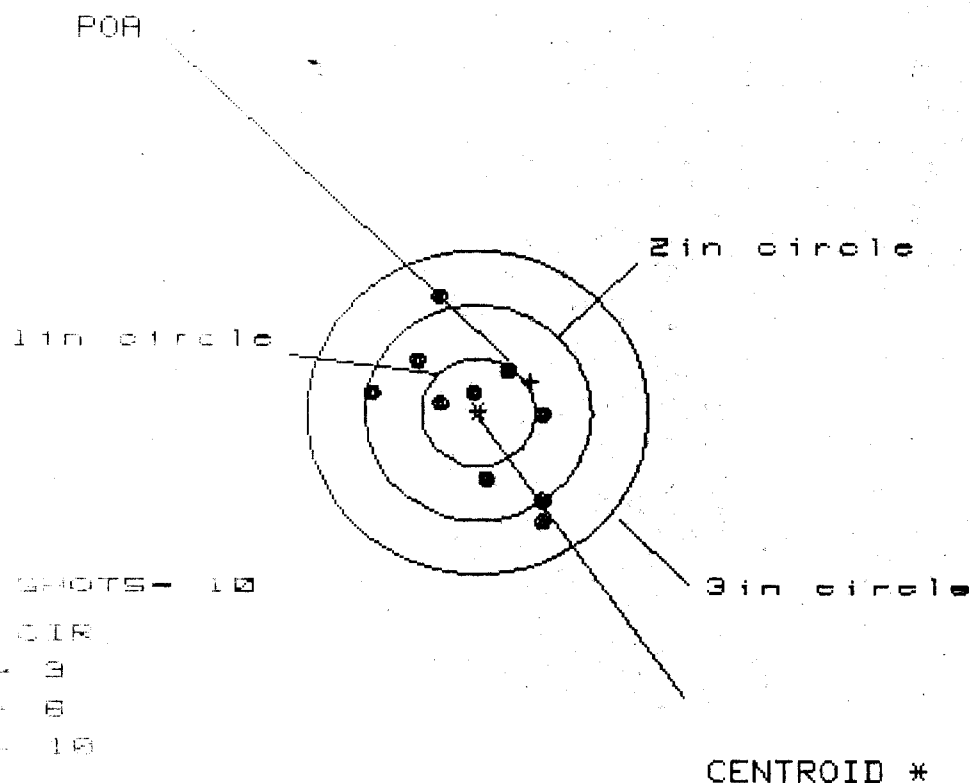
1 + <----POA
 3
 5 2
 4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4204
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.7372
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .848646
 THE AME FOR THIS RIFLE IS: .6806

14 Aug 1998

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CENTERFIRE PATTERNS # 1



* OF SHOTS - 10

IN CIR

1 - 3

2 - 8

3 - 10

X = 1.465

Y = 2.155

Z = 2.303

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.581

.549

.611

MINIMUM X

:

-.884

-.916

-.854

MAXIMUM Y

:

1.124

.602

.488

MINIMUM Y

:

-1.031

-.906

-.774

CENTROID X

:

-.467

-.435

-.497

CENTROID Y

:

-.287

-.412

-.298

POA TO CENTROID in.:

.548

.599

.579

MIN RADIUS

:

.171

.296

.187

MEAN RADIUS

:

.703

.662

.590

MAX RADIUS

:

1.160

1.032

.986

HORIZONTAL SPREAD :

1.465

1.465

1.465

VERTICAL SPREAD :

2.155

1.508

1.263

EXTREME SPREAD :

2.303

1.872

1.766

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

14 Aug 1938

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 5

2 in - 7

3 in - 10

H- 2.177

V- 1.516

E- 2.410

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	1.045	.961
MINIMUM X	:	-1.096	-.976	-1.060
MAXIMUM Y	:	.792	.712	.716
MINIMUM Y	:	-.724	-.397	-.308
CENTROID X	:	-.325	-.445	-.361
CENTROID Y	:	-.995	-.915	-1.004
POA TO CENTROID in.	:	1.047	1.017	1.067
MIN RADIUS	:	.277	.280	.245
MEAN RADIUS	:	.700	.640	.570
MAX RADIUS	:	1.301	1.073	1.062
HORIZONTAL SPREAD	:	2.177	2.021	2.021
VERTICAL SPREAD	:	1.516	1.109	1.024
EXTREME SPREAD	:	2.410	2.032	2.032
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

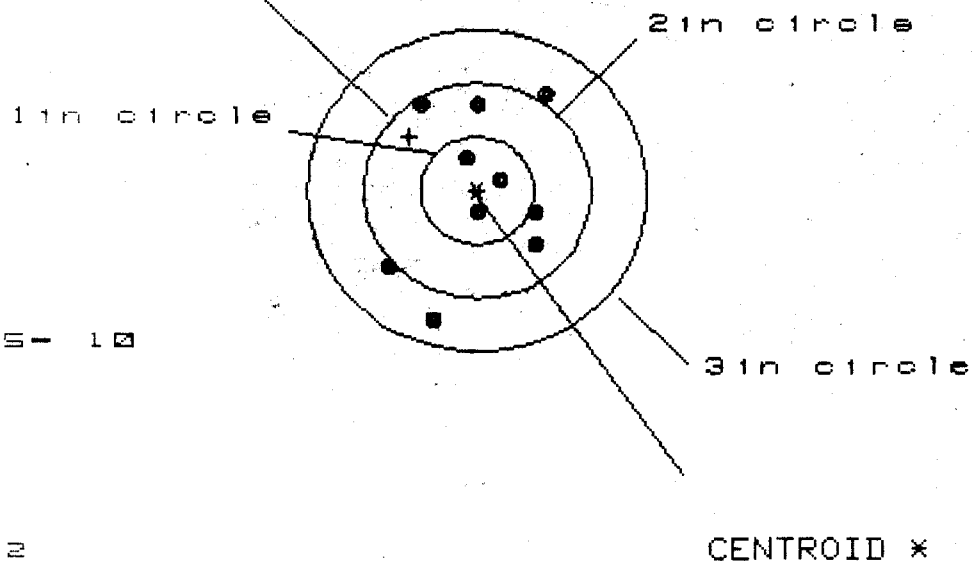
14 Aug 1990

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CENTERFIRE PATTERNS

3

POB



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

MS = 1.462

VS = 2.106

ES = 2.358

PATTERN #

:

10

9

8

SHOTS (BEST OF)

:

MAXIMUM X

:

.622

.574

.546

MINIMUM X

:

-.840

-.888

-.817

MAXIMUM Y

:

.890

.755

.722

MINIMUM Y

:

-1.216

-.796

-.701

CENTROID X

:

.594

.642

.571

CENTROID Y

:

-.503

-.368

-.463

POB TO CENTROID in.

:

.778

.740

.735

MIN RADIUS

:

.161

.140

.202

MEAN RADIUS

:

.710

.629

.591

MAX RADIUS

:

1.292

1.193

1.076

HORIZONTAL SPREAD

:

1.462

1.462

1.362

VERTICAL SPREAD

:

2.106

1.551

1.423

EXTREME SPREAD

:

2.358

2.131

1.663

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

14 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522249

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 4

2 in - 9

3 in - 10

MS- 1.768

VS- 1.444

GS- 1.859

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.896	.805
MINIMUM X	:	-.837	-.734	-.656
MAXIMUM Y	:	.632	.655	.686
MINIMUM Y	:	-.812	-.742	-.711
CENTROID X	:	-.935	-1.038	-.947
CENTROID Y	:	-1.107	-1.177	-1.208
POA TO CENTROID in.	:	1.449	1.570	1.535
MIN RADIUS	:	.223	.297	.318
MEAN RADIUS	:	.662	.594	.575
MAX RADIUS	:	1.125	.897	.851
HORIZONTAL SPREAD	:	1.768	1.630	1.461
VERTICAL SPREAD	:	1.444	1.397	1.397
EXTREME SPREAD	:	1.859	1.655	1.486
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		

14 Aug 1990

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS = 1.847

VS = 1.506

GS = 2.241

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.039	.951	.865
MINIMUM X	:	-.808	-.693	-.617
MAXIMUM Y	:	.748	.706	.651
MINIMUM Y	:	-.758	-.675	-.730
CENTROID X	:	-.969	-1.084	-.998
CENTROID Y	:	-.794	-.877	-.822
POA TO CENTROID in.	:	1.252	1.394	1.292
MIN RADIUS	:	.161	.077	.124
MEAN RADIUS	:	.628	.524	.495
MAX RADIUS	:	1.280	1.090	.988
HORIZONTAL SPREAD	:	1.847	1.644	1.481
VERTICAL SPREAD	:	1.506	1.381	1.381
EXTREME SPREAD	:	2.241	1.910	1.585
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington[®]

MODEL 700TM M24

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

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

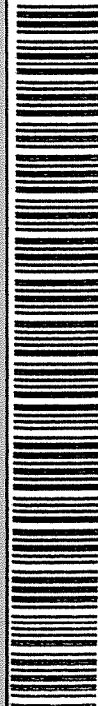
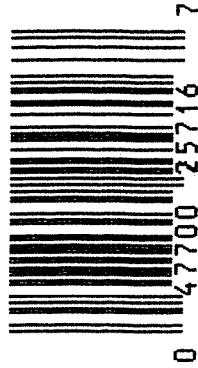
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6522249

ORDER NO.
5716

Ø1

UPC



5716 C6522249

C6522247

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington