

C6522235

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 # C6522235

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	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	LL
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel AB		8/14/90	WB
620	Apply Coatings (Barrel Action)		2-22-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/24/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/24/90	RW
	C) Inspect Ejector Hole for Chamfer		8/24/90	RW
	D) Oil Firing Pin Ass'y		8/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/90	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/28/90	WB
	G) Safety Off Force	2	2	2			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	94
	I) Firing Pin Indent	.023	.023	.023			8/28/90	WB
	J) Assemble Stock						8/28/90	RW
	K) Assemble Swivel Studs						8/31/90	98
	L) Attach Front and Rear Sight Assemblies						8/28/90	RW
	M) Iron Sight Alignment						8/28/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/90	RW
	O) Attach Scope to Rifle						8/28/90	RW
	P) Detach & Attach Scope 20 Times						8/28/90	RW
640	Gallery Target & Test						8-29-90	DH
	A) Time						8-29-90	DH
	B) Malfunctions						8-29-90	DH
	C) Pierced Primers						8-29-90	DH
	D) Optical Clarity of Scope						8-29-90	DH
645	Inspect for Live Ammo						8-29-90	DH
655	Final Inspection							
	A) Headspace						8/31/90	98
	B) Trigger Pull	2.41	2.29	2.29	2.26	2.33	8/31/90	94
	C) Function						8/31/90	98
660	Pack						9/19/90	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 06522235

DATE 8/28/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.30	2.35	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.08	2.34	2.29	
PULL #3	2.26	2.34	2.26	2.29	
PULL #4	2.28	2.29	2.20	2.26	
PULL #5	2.35	2.28	2.27	2.33	
TOTAL	11.58	11.29	11.42	11.99	
AVG.	2.316	2.258	2.284	2.298	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.32		
PULL #2	3.37	3.28		
PULL #3	3.33	3.34		
PULL #4	3.35	3.34		
PULL #5	3.34	3.36		
TOTAL	16.54	16.74		
AVG.	3.308	3.348		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.23		4.30
PULL #2	4.17	4.36		4.32
PULL #3	4.32	4.36		4.34
PULL #4	4.27	4.35		4.33
PULL #5	4.28	4.36		4.33
TOTAL	21.23	21.66		21.62
AVG.	4.246	4.332		4.324

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522235
29 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.682974
1 TO	2	.686001
1 TO	3	.164149
1 TO	4	1.09249
1 TO	5	.795

4 2 31
5+ <----POA

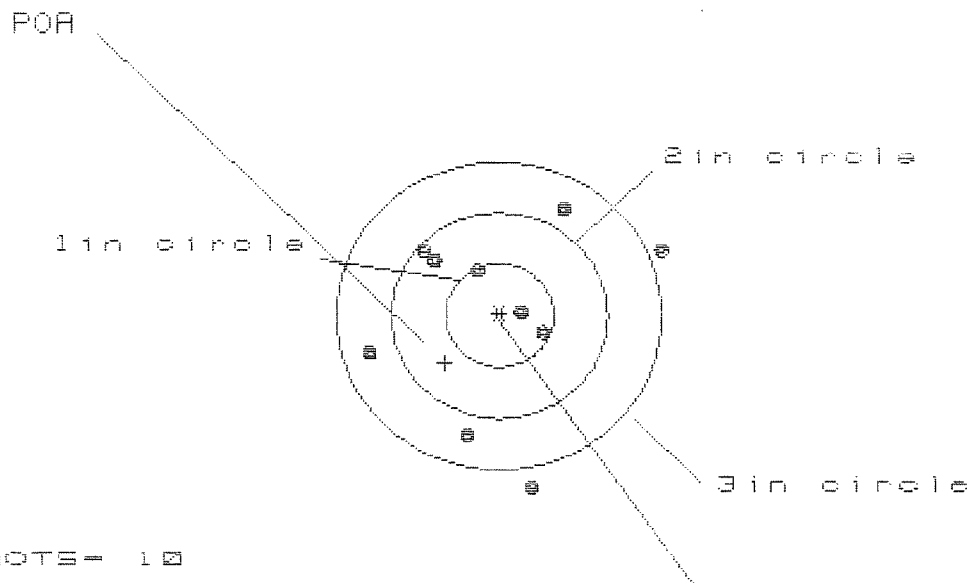
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .368754

THE RMF FOR THIS RIFLE IS: 1.131

29 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522235

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.771

VS= 2.623

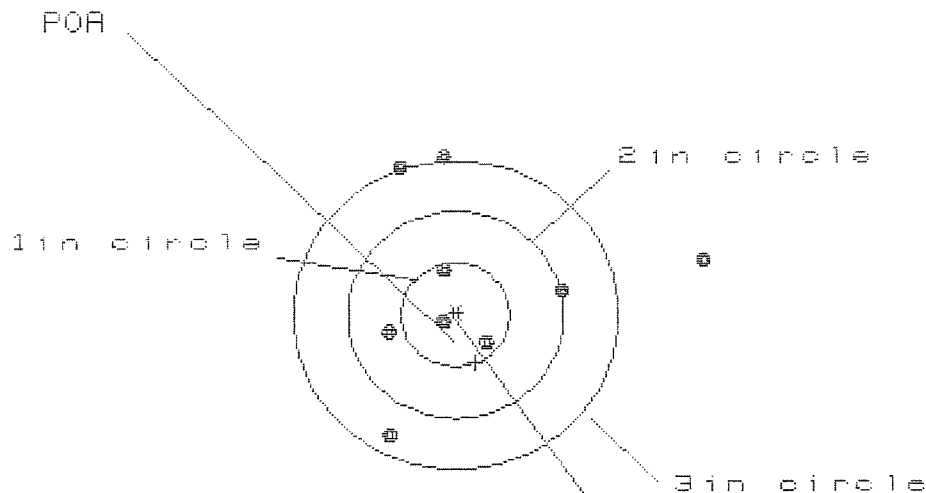
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PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.521	.729	.785
MINIMUM X	:	-1.251	-1.082	-1.026
MAXIMUM Y	:	.991	1.064	.869
MINIMUM Y	:	-1.632	-1.559	-1.238
CENTROID X	:	.503	.334	.278
CENTROID Y	:	.462	.389	.584
POA TO CENTROID in.	:	.683	.513	.647
MIN RADIUS	:	.216	.390	.324
MEAN RADIUS	:	.979	.912	.785
MAX RADIUS	:	1.657	1.621	1.238
HORIZONTAL SPREAD	:	2.771	1.811	1.811
VERTICAL SPREAD	:	2.623	2.623	2.107
EXTREME SPREAD	:	2.967	2.639	2.285
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 6

HS = 3.653

VS = 4.186

GS = 4.880

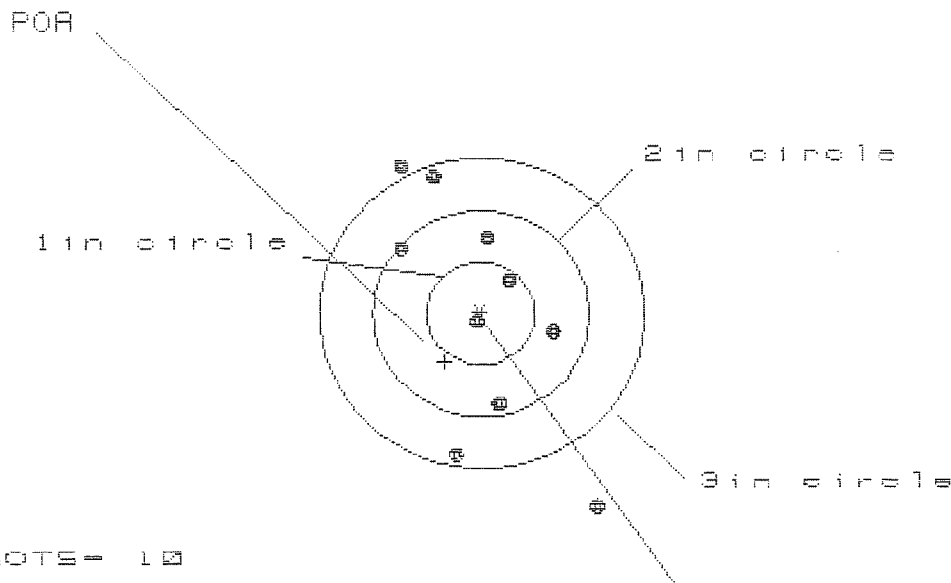
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.264	2.109	1.114
MINIMUM X	:	-1.389	-.802	-.538
MAXIMUM Y	:	1.520	1.224	1.259
MINIMUM Y	:	-2.665	-1.453	-1.418
CENTROID X	:	-.183	-.029	-.293
CENTROID Y	:	.463	.759	.724
POR TO CENTROID IN.	:	.498	.759	.781
MIN RADIUS	:	.150	.271	.159
MEAN RADIUS	:	1.239	1.047	.865
MAX RADIUS	:	3.006	2.127	1.517
HORIZONTAL SPREAD	:	3.653	2.911	1.652
VERTICAL SPREAD	:	4.186	2.677	2.677
EXTREME SPREAD	:	4.880	3.384	2.734
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.785

VS= 3.356

GS= 3.802

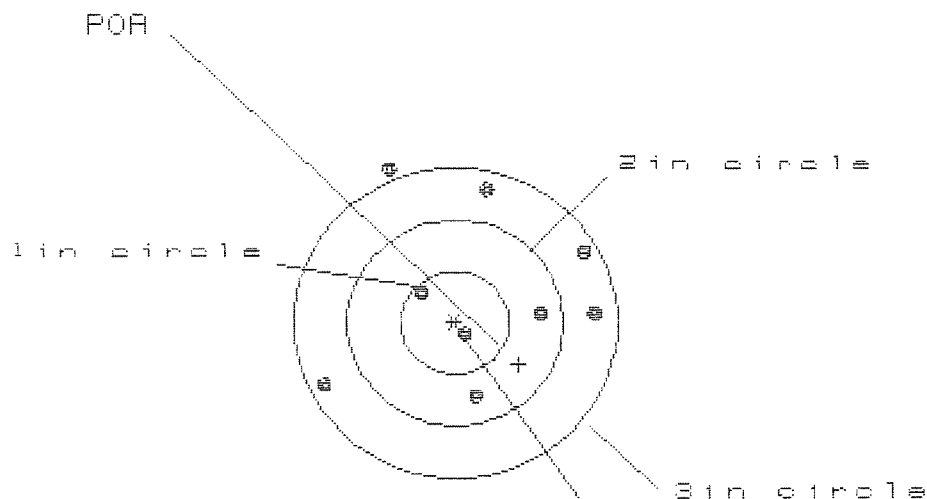
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.047
MINIMUM X	-.739
MAXIMUM Y	1.455
MINIMUM Y	-1.901
CENTROID X	.339
CENTROID Y	.469
POA TO CENTROID in.	.579
MIN RADIUS	.115
MEAN RADIUS	1.033
MAX RADIUS	2.171
HORIZONTAL SPREAD	1.786
VERTICAL SPREAD	3.356
EXTREME SPREAD	3.802
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	8

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

IS = 2.996

VS = 4.004

GS = 4.258

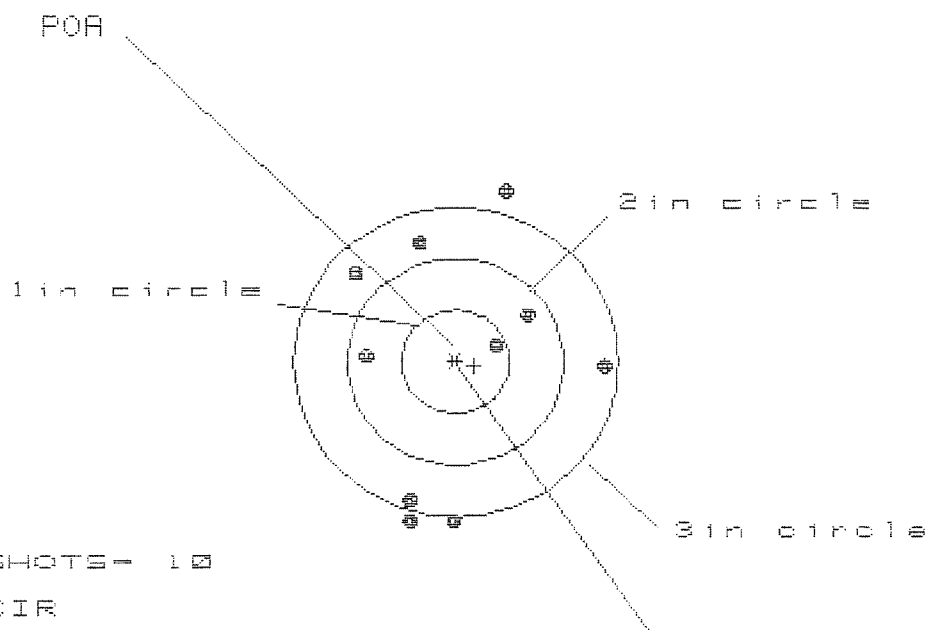
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.296	1.107	1.013
MINIMUM X	-1.700	-1.389	-1.483
MAXIMUM Y	1.540	1.266	1.133
MINIMUM Y	-2.464	-0.958	-0.800
CENTROID X	-0.588	-0.399	-0.305
CENTROID Y	.405	.679	.521
POR TO CENTROID in.	.714	.787	.603
MIN RADIUS	.140	.400	.303
MEAN RADIUS	1.193	.971	.880
MAX RADIUS	2.994	1.652	1.656
HORIZONTAL SPREAD	2.996	2.496	2.496
VERTICAL SPREAD	4.004	2.224	1.933
EXTREME SPREAD	4.258	2.708	2.708
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

IS = 2.219

VS = 3.249

ES = 3.369

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.327	1.383	1.342
MINIMUM X	:	-0.892	-0.836	-0.877
MAXIMUM Y	:	1.695	1.349	1.179
MINIMUM Y	:	-1.554	-1.366	-1.497
CENTROID X	:	-0.172	-0.228	-0.187
CENTROID Y	:	.042	-0.146	.024
POA TO CENTROID in.	:	.177	.271	.188
MIN RADIUS	:	.458	.605	.479
MEAN RADIUS	:	1.211	1.154	1.095
MAX RADIUS	:	1.769	1.405	1.498
HORIZONTAL SPREAD	:	2.219	2.219	2.219
VERTICAL SPREAD	:	3.249	2.715	2.676
EXTREME SPREAD	:	3.369	2.717	2.685
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

Remington



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

MODEL 700™ H24

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

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

SERIAL NO.	C6522235
ORDER NO.	5716



5716 C6522235

UPC



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