

C6522233

MODEL 700™ M24

Model **SWS**™

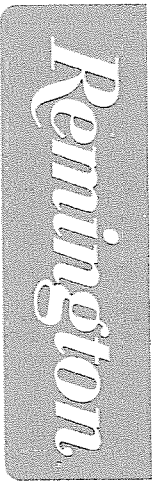
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522233

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	KR
615	Rollmark Caliber		7-12-90	B.S.
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	TH
	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		8/21/90	JL

BARBER - M24 0002541

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/30/90	QJ
	G) Safety Off Force	3	3	3			7/30/90	QJ
	H) Trigger Pull Test & Retainability						8/15/90	QJ
	I) Firing Pin Indent	.0235	.0235	.0235			7/30/90	QJ
	J) Assemble Stock						8/15/90	KS
	K) Assemble Swivel Studs						8/29/90	QJ
	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	DH
	A) Time						8-16-90	DH
	B) Malfunctions						8-16-90	DH
	C) Pierced Primers						8-16-90	DH
	D) Optical Clarity of Scope						8-16-90	DH
645	Inspect for Live Ammo						8-16-90	DH
655	Final Inspection						8/29/90	QJ
	A) Headspace						8/29/90	QJ
	B) Trigger Pull	2.41	2.50	2.51	2.49	2.50	8/21/90	QJ
	C) Function						8/29/90	QJ
660	Pack						9-20-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522233

DATE 8/15/90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.28	2.23	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.22	2.13	2.50	
PULL #3	2.23	2.23	2.11	2.51	
PULL #4	2.29	2.23	2.34	2.49	
PULL #5	2.30	2.26	2.33	2.50	
TOTAL	11.52	11.22	11.14	12.41	
AVG.	2.304	2.244	2.228	2.482	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.26		
PULL #2	3.24	3.28		
PULL #3	3.25	3.29		
PULL #4	3.24	3.31		
PULL #5	3.26	3.28		
TOTAL	16.29	16.42		
AVG.	3.258	3.284		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.26		4.28
PULL #2	4.29	4.26		4.11
PULL #3	4.29	4.26		4.13
PULL #4	4.27	4.31		4.11
PULL #5	4.29	4.26		4.13
TOTAL	21.47	21.35		20.76
AVG.	4.294	4.27		4.152

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522233
17 Aug 1990

CENTROIDAL DISTANCES

0	TO	1	.412317
1	TO	2	1.20552
1	TO	3	1.43319
1	TO	4	1.96341
1	TO	5	1.36499

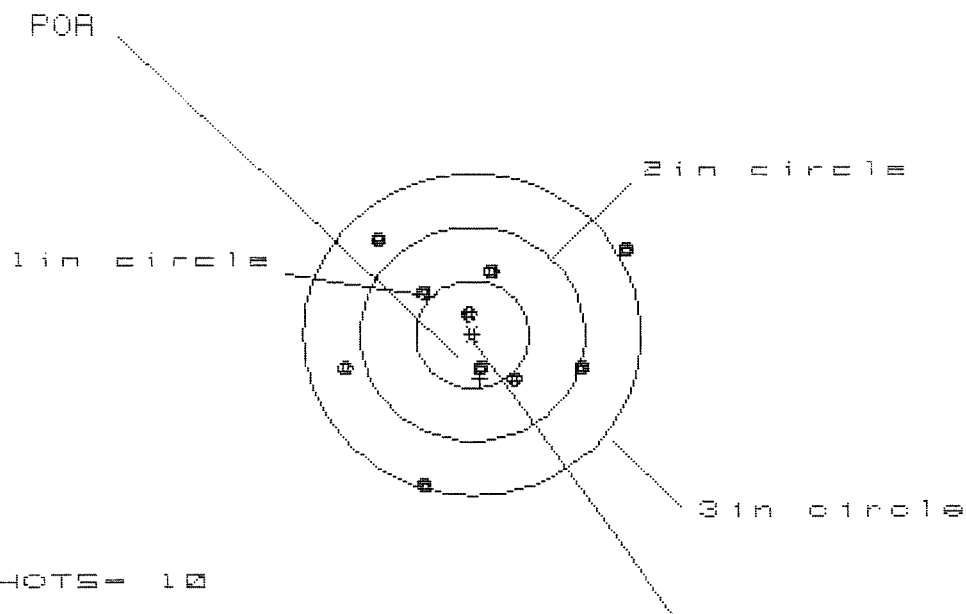
$$^1_0 + \text{-----POA}$$

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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.223
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.6128
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .652114
THE AMP FOR THIS RIFLE IS: .8658
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17 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522233

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.471

VS= 2.300

GS= 2.911

CENTROID *

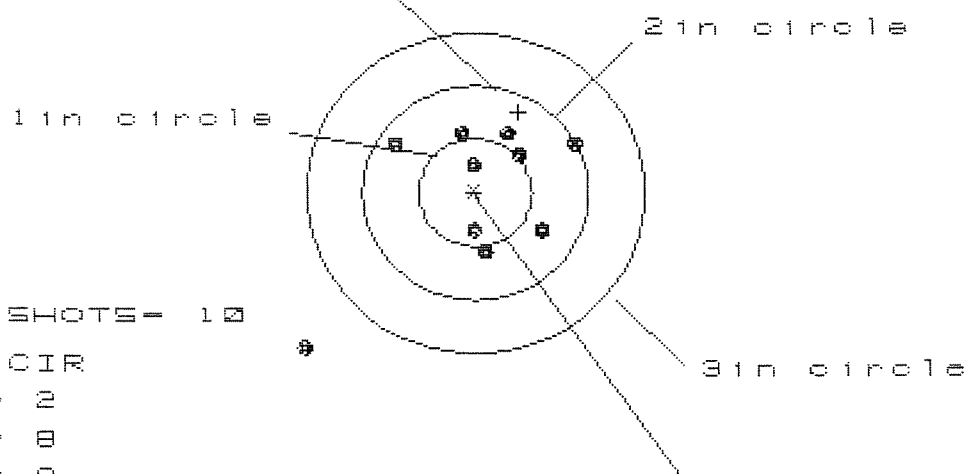
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.372	1.071	1.036
MINIMUM X	-1.099	-.946	-.981
MAXIMUM Y	.847	.939	.769
MINIMUM Y	-1.453	-1.361	-.529
CENTROID X	-.066	-.219	-.184
CENTROID Y	.407	.315	.485
POA TO CENTROID in.	.413	.383	.519
MIN RADIUS	.248	.321	.163
MEAN RADIUS	.884	.806	.704
MAX RADIUS	1.604	1.389	1.117
HORIZONTAL SPREAD	2.471	2.017	2.017
VERTICAL SPREAD	2.300	2.300	1.298
EXTREME SPREAD	2.911	2.335	2.115
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

17 Aug 1998

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CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.367

VS= 2.074

GS= 3.061

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.903	.740	.551
MINIMUM X	:	-1.464	-.838	-.746
MAXIMUM Y	:	.589	.424	.461
MINIMUM Y	:	-1.485	-.724	-.687
CENTROID X	:	-.387	-.224	-.317
CENTROID Y	:	-.755	-.590	-.627
POR TO CENTROID in.	:	.849	.632	.702
MIN RADIUS	:	.237	.216	.154
MEAN RADIUS	:	.748	.557	.522
MAX RADIUS	:	2.085	.884	.810
HORIZONTAL SPREAD	:	2.367	1.578	1.297
VERTICAL SPREAD	:	2.074	1.148	1.148
EXTREME SPREAD	:	3.061	1.578	1.497
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.163

VS= 2.189

GS= 2.805

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.045	.587	.510
MINIMUM X	:	-1.118	-1.002	-1.079
MAXIMUM Y	:	1.026	.744	.615
MINIMUM Y	:	-1.163	-1.049	-1.178
CENTROID X	:	-.680	-.796	-.719
CENTROID Y	:	-.888	-1.002	-.873
POA TO CENTROID in.	:	1.118	1.279	1.131
MIN RADIUS	:	.214	.312	.257
MEAN RADIUS	:	.854	.811	.721
MAX RADIUS	:	1.464	1.201	1.259
HORIZONTAL SPREAD	:	2.163	1.589	1.589
VERTICAL SPREAD	:	2.189	1.793	1.793
EXTREME SPREAD	:	2.805	2.268	2.268
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.143

VS= 3.087

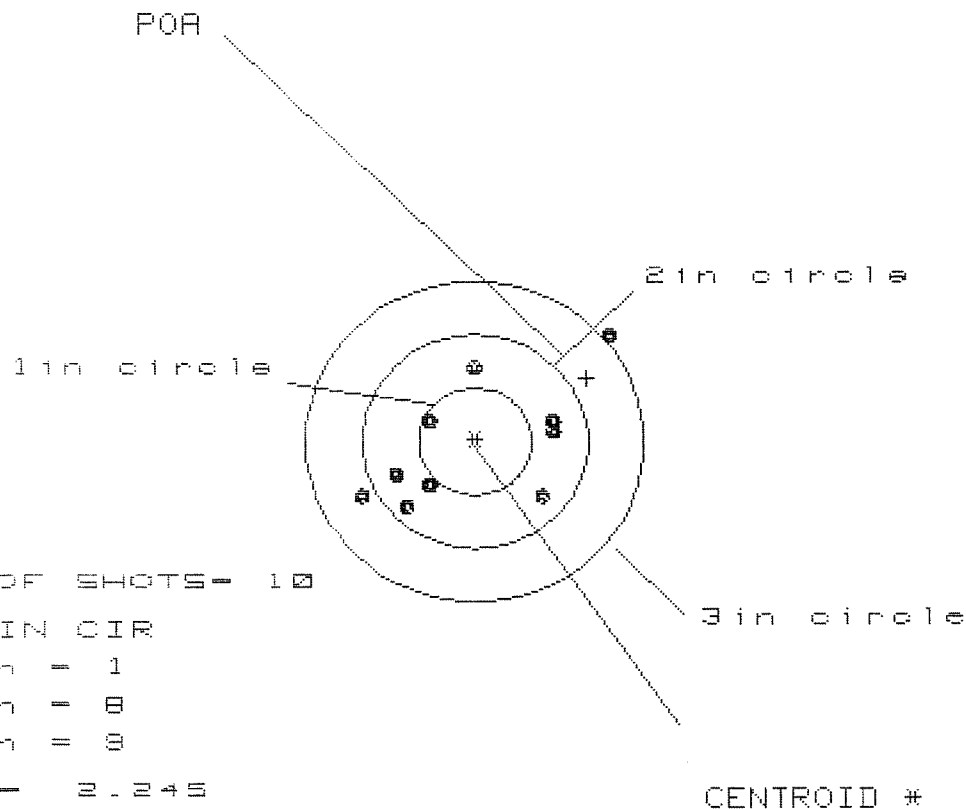
GS= 3.087

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.173	1.263	1.062
MINIMUM X	:	-.970	-.880	-.722
MAXIMUM Y	:	1.839	1.201	1.087
MINIMUM Y	:	-1.248	-1.044	-1.158
CENTROID X	:	1.012	.922	.764
CENTROID Y	:	-1.030	-1.234	-1.120
POA TO CENTROID in.	:	1.444	1.540	1.356
MIN RADIUS	:	.381	.198	.246
MEAN RADIUS	:	1.022	.875	.762
MAX RADIUS	:	2.013	1.558	1.571
HORIZONTAL SPREAD	:	2.143	2.143	1.784
VERTICAL SPREAD	:	3.087	2.245	2.245
EXTREME SPREAD	:	3.087	2.546	2.484
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 2.245

VS= 1.600

GS= 2.709

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.192	.869	.754
MINIMUM X	:	-1.053	-.921	-.691
MAXIMUM Y	:	1.019	.807	.759
MINIMUM Y	:	-.581	-.468	-.516
CENTROID X	:	-.994	-1.126	-1.011
CENTROID Y	:	-.594	-.707	-.659
POA TO CENTROID in.	:	1.158	1.330	1.207
MIN RADIUS	:	.442	.377	.467
MEAN RADIUS	:	.821	.714	.682
MAX RADIUS	:	1.568	.998	.790
HORIZONTAL SPREAD	:	2.245	1.790	1.445
VERTICAL SPREAD	:	1.600	1.275	1.275
EXTREME SPREAD	:	2.709	1.906	1.542
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

SERIAL NO.
C6522233

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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