C652213

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

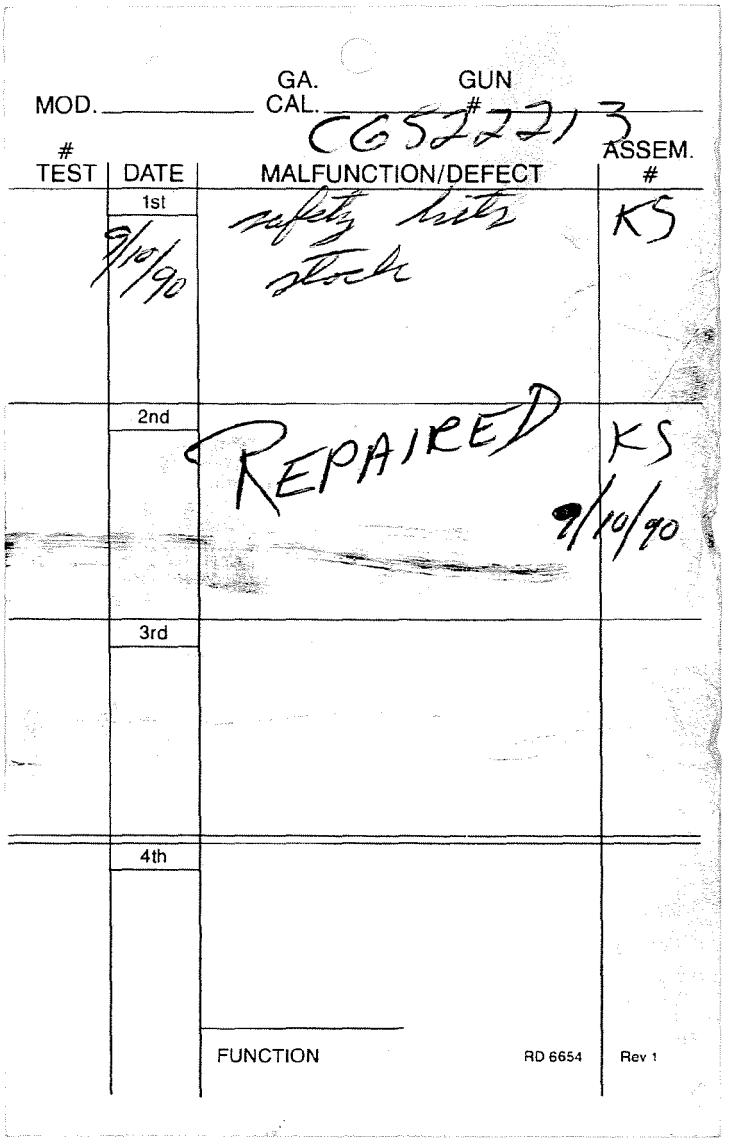
M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522213

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	[illegible]
617	Drill and Tap Sight Holes		8/10/90	[illegible]
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/6/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/6/90	WB
	C) Inspect Ejector Hole for Chamfer		9/6/90	WB
	D) Oil Firing Pin Ass'y		9/6/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/6/90	WB
	G) Safety Off Force	3	3	3			9/6/90	WB
	H) Trigger Pull Test & Retainability						9/6/90	WB
	I) Firing Pin Indent	.024	.0245	.0245			9/6/90	WB
	J) Assemble Stock						9/7/90	KS
	K) Assemble Swivel Studs						9/13/90	[illegible]
	L) Attach Front and Rear Sight Assemblies						9/7/90	KS
	M) Iron Sight Alignment						9/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/7/90	KS
	O) Attach Scope to Rifle						9/7/90	KS
	P) Detach & Attach Scope 20 Times						9/7/90	KS
640	Gallery Target & Test						9-10-90	DH
	A) Time						9-10-90	DH
	B) Malfunctions						9-10-90	DH
	C) Pierced Primers						9-10-90	DH
	D) Optical Clearity of Scope						9-10-90	DH
645	Inspect for Live Ammo						9-10-90	DH
655	Final Inspection A) Headspace						9/13/90	[illegible]
	B) Trigger Pull	2.30	2.29	2.26	2.32	2.33	9-12-90	JC
	C) Function						9/13/90	[illegible]
660	Pack						9/20/90	MF



MOD. _____ GA. _____ CAL. _____ GUN # C652213

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	safety hits stock	KS
	9/10/90		
	2nd	REPAIRED	KS
			9/10/90
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
	ENGINEER	
PROOF		
TEST		
TGT		
	ENGINEER	
PROOF		
TEST		
TGT		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6522213
DATE 9/6/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.40	2.66	2.30	MIN. SETTING,
PULL #2	2.53	2.34	2.70	2.29	NO AVG. OF 5
PULL #3	2.47	2.46	2.72	2.26	READINGS ACCEPT-
PULL #4	2.44	2.41	2.70	2.32	ABLE LESS THAN 2#
PULL #5	2.46	2.50	2.69	2.33	
TOTAL	12.31	12.11	13.47	11.50	
AVG.	2.46	2.42	2.69	2.3	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.18		
PULL #2	3.18	3.16		
PULL #3	3.10	3.22		
PULL #4	3.12	3.22		
PULL #5	3.14	3.14		
TOTAL	15.72	15.92		
AVG.	3.14	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.09		4.28
PULL #2	4.10	4.00		4.18
PULL #3	4.04	4.05		4.17
PULL #4	4.10	4.04		4.24
PULL #5	4.07	4.10		4.26
TOTAL	20.40	20.28		21.13
AVG.	4.08	4.05		4.22

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522213
10 Sep 1990

CENTROIDAL DISTANCES

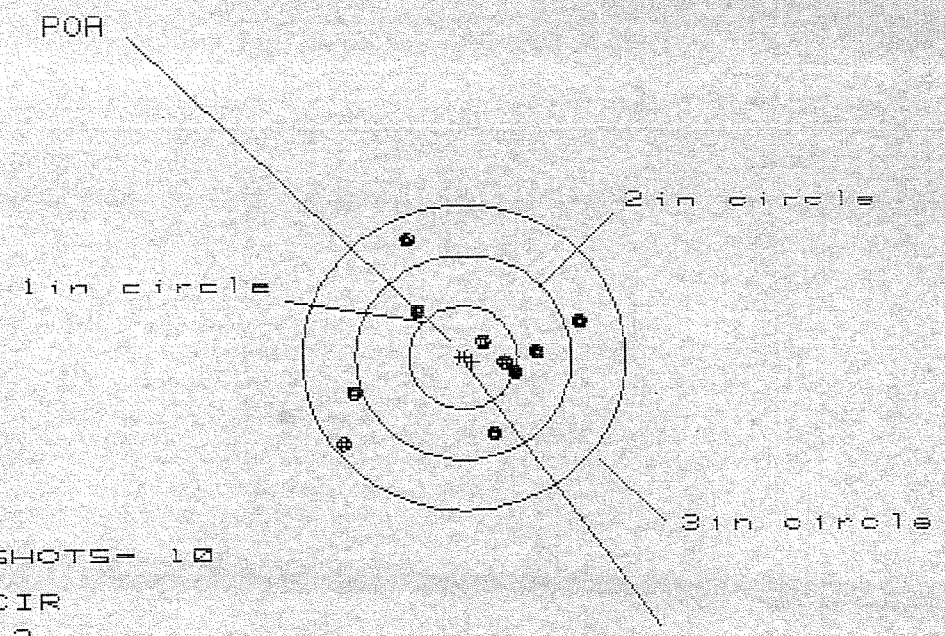
0	TO	1	.0899444
1	TO	2	.519065
1	TO	3	.174195
1	TO	4	.515396
1	TO	5	.482412

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.101
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .238266

THE AMR FOR THIS RIFLE IS: .8416

10 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522213

CENTERFIRE PATTERNS # 1

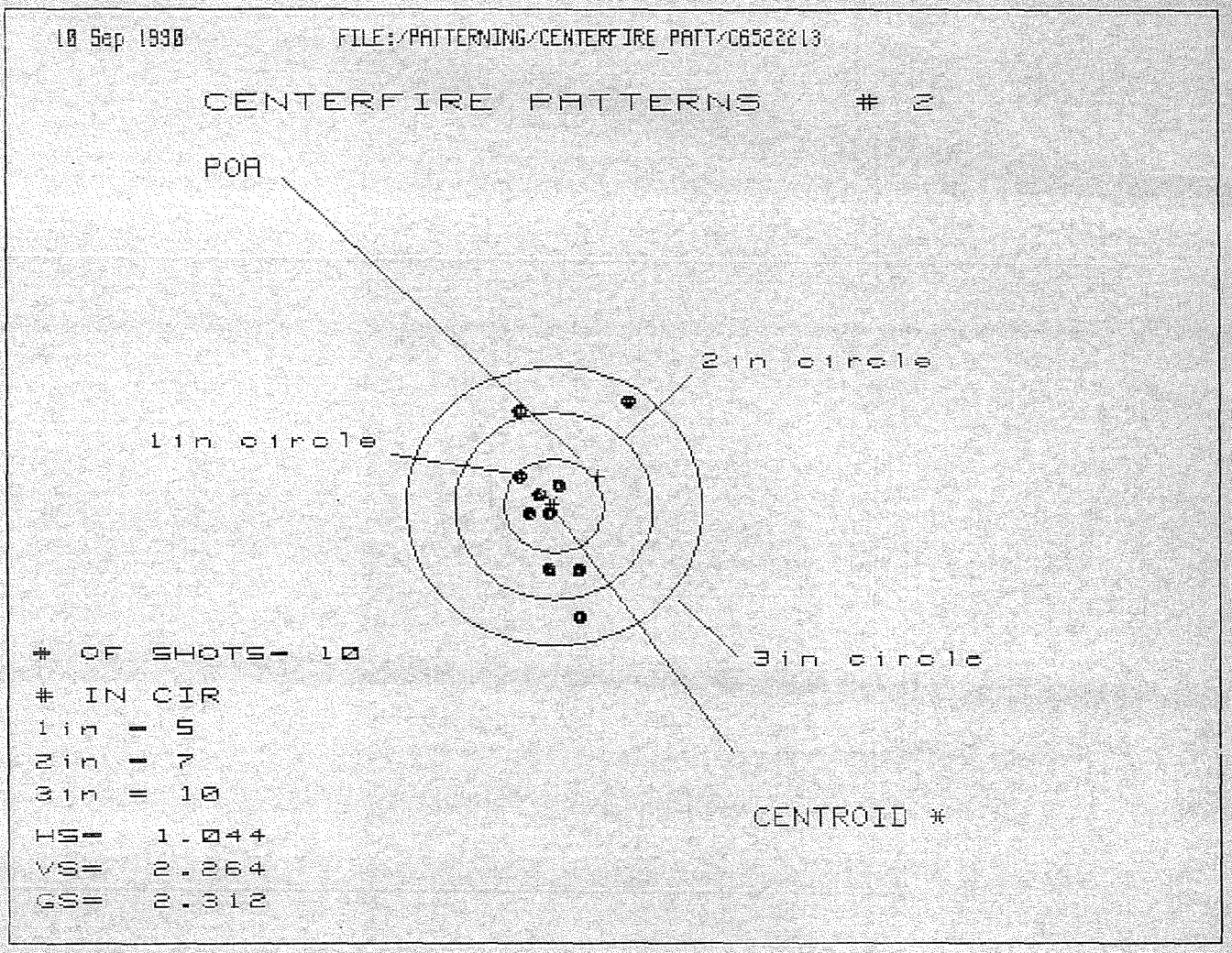


OF SHOTS= 10

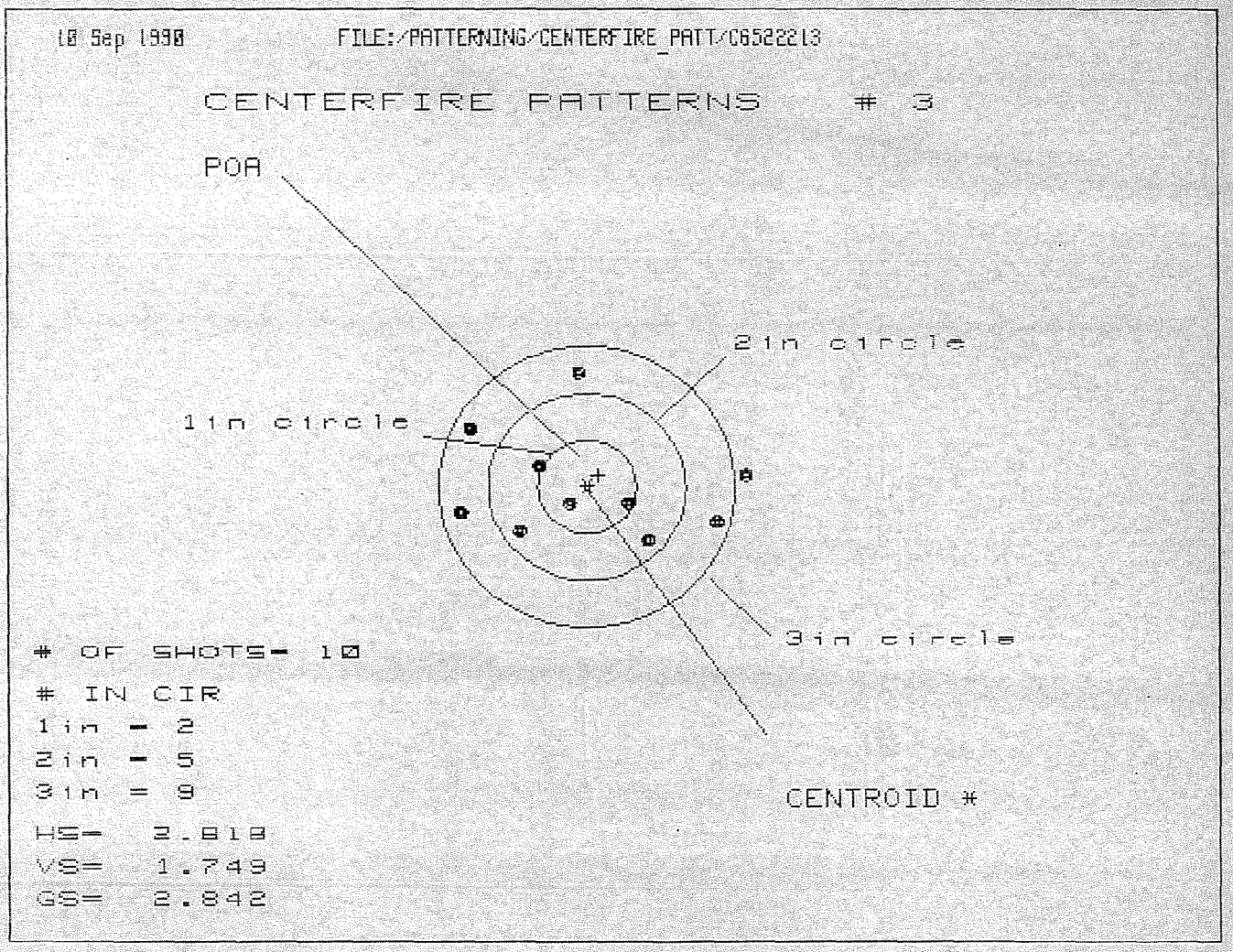
# IN CIR	
1in	2
2in	5
3in	10

HS= 2.231
VS= 1.920
GS= 2.509

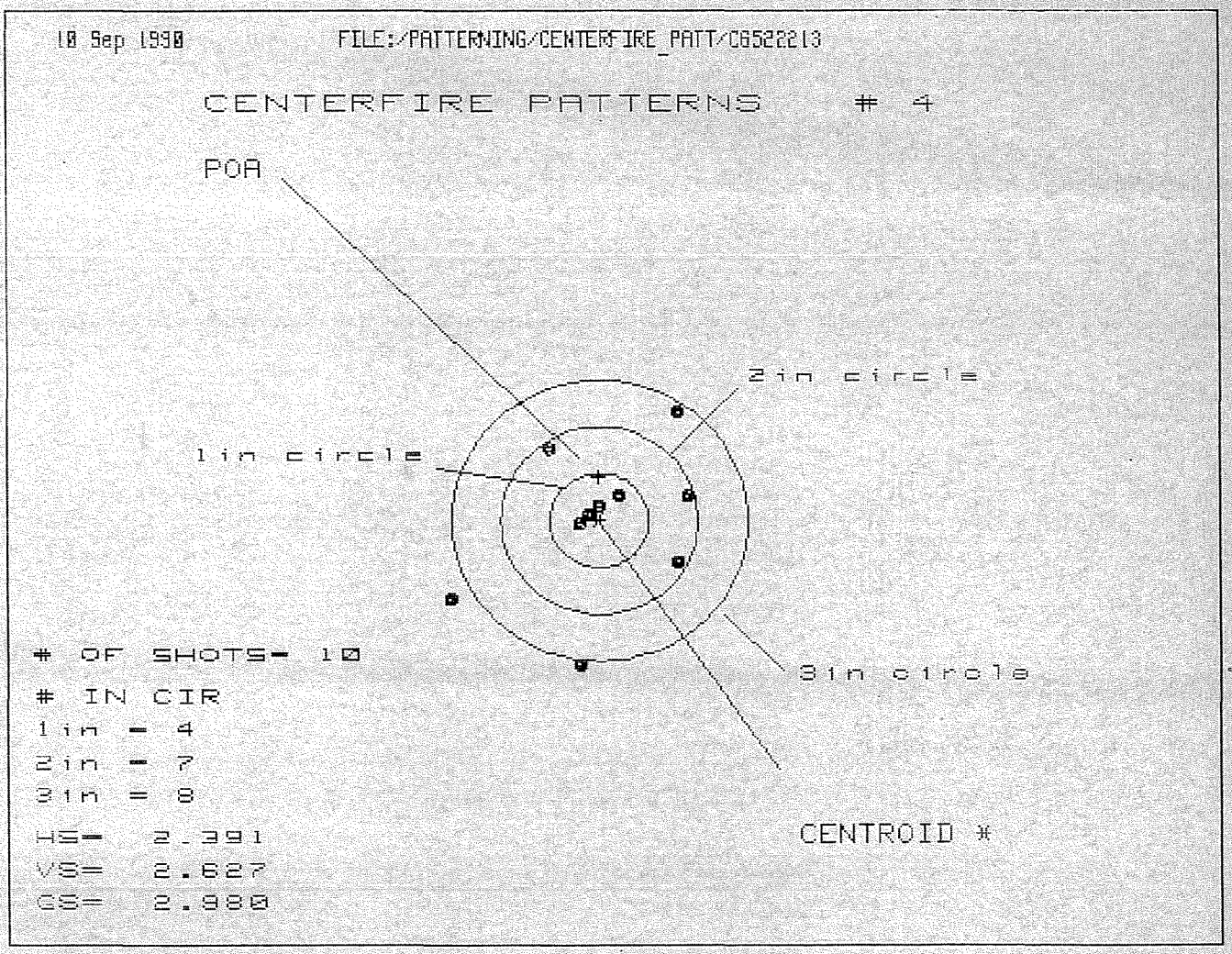
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.082	.955	.871
MINIMUM X	:	-1.149	-1.108	-1.192
MAXIMUM Y	:	1.110	1.020	.444
MINIMUM Y	:	-.810	-.864	-.737
CENTROID X	:	-.079	.048	.132
CENTROID Y	:	.043	.133	.006
POA TO CENTROID in.	:	.090	.142	.132
MIN RADIUS	:	.276	.127	.168
MEAN RADIUS	:	.806	.700	.609
MAX RADIUS	:	1.406	1.220	1.221
HORIZONTAL SPREAD	:	2.231	2.063	2.063
VERTICAL SPREAD	:	1.920	1.884	1.181
EXTREME SPREAD	:	2.509	2.160	2.160
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



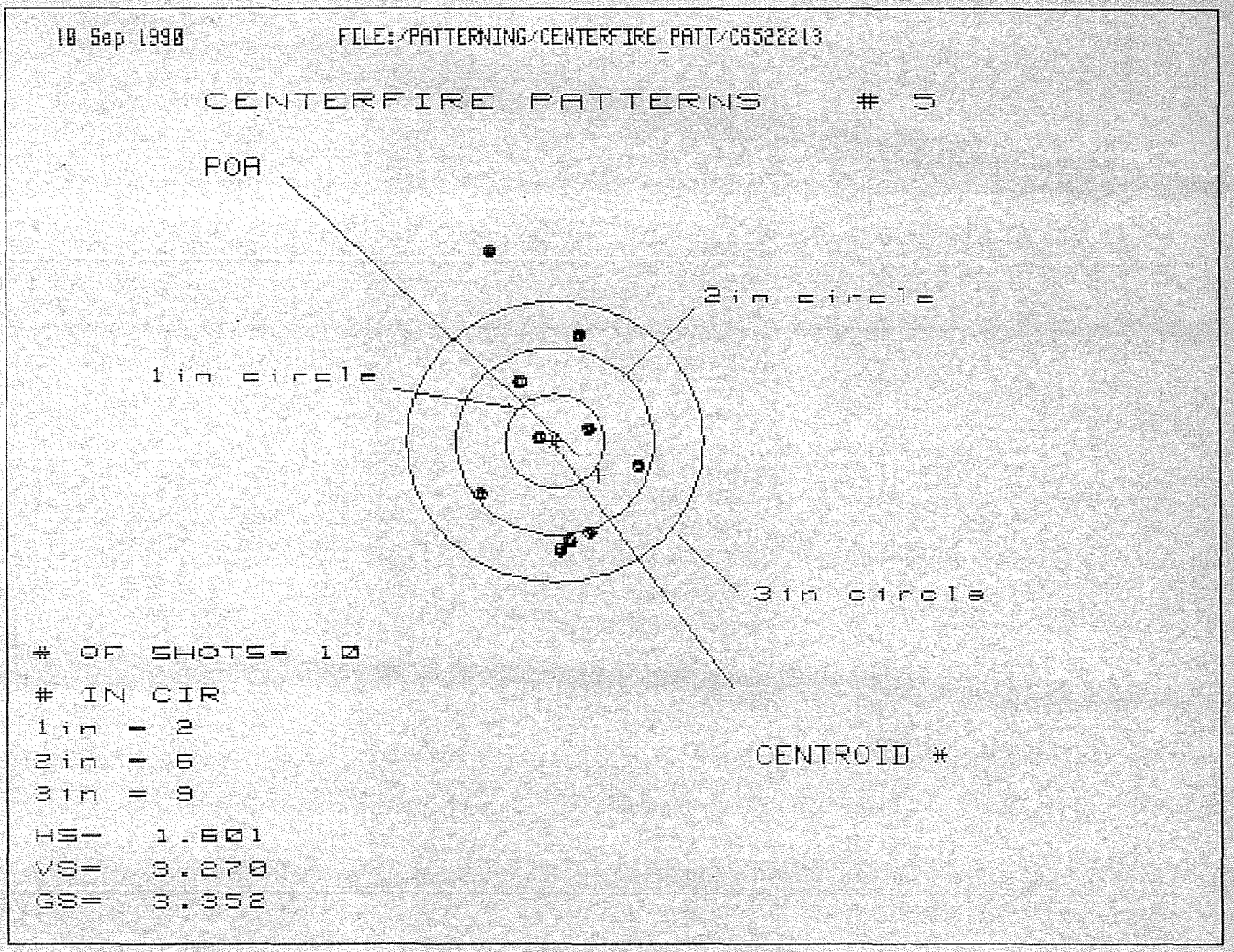
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.703	.328	.367
MINIMUM X	:	-.341	-.263	-.224
MAXIMUM Y	:	1.074	1.110	.976
MINIMUM Y	:	-1.190	-1.071	-.741
CENTROID X	:	-.451	-.529	-.568
CENTROID Y	:	-.319	-.438	-.304
POA TO CENTROID in.	:	.552	.687	.644
MIN RADIUS	:	.138	.016	.084
MEAN RADIUS	:	.627	.535	.444
MAX RADIUS	:	1.284	1.141	1.002
HORIZONTAL SPREAD	:	1.044	.591	.591
VERTICAL SPREAD	:	2.264	2.181	1.717
EXTREME SPREAD	:	2.312	2.255	1.739
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.570	1.463	.957
MINIMUM X	:	-1.248	-1.074	-.891
MAXIMUM Y	:	1.201	1.209	1.161
MINIMUM Y	:	-.548	-.540	-.588
CENTROID X	:	-.117	-.291	-.474
CENTROID Y	:	-.127	-.135	-.087
POA TO CENTROID in.	:	.172	.321	.482
MIN RADIUS	:	.304	.216	.187
MEAN RADIUS	:	.961	.868	.770
MAX RADIUS	:	1.571	1.513	1.194
HORIZONTAL SPREAD	:	2.818	2.537	1.848
VERTICAL SPREAD	:	1.749	1.749	1.749
EXTREME SPREAD	:	2.842	2.677	2.146
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.892	.725	.672
MINIMUM X	:	-1.499	-.698	-.751
MAXIMUM Y	:	1.139	1.050	.853
MINIMUM Y	:	-1.488	-1.577	-.745
CENTROID X	:	.008	.175	.228
CENTROID Y	:	-.465	-.376	-.179
POA TO CENTROID in.	:	.465	.415	.290
MIN RADIUS	:	.104	.208	.073
MEAN RADIUS	:	.828	.728	.605
MAX RADIUS	:	1.699	1.633	1.012
HORIZONTAL SPREAD	:	2.391	1.423	1.423
VERTICAL SPREAD	:	2.627	2.627	1.598
EXTREME SPREAD	:	2.980	2.818	1.858
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.869	.790	.809
MINIMUM X	:	-.732	-.811	-.791
MAXIMUM Y	:	2.074	1.417	1.065
MINIMUM Y	:	-1.196	-.965	-.788
CENTROID X	:	-.440	-.361	-.380
CENTROID Y	:	.363	.132	-.045
POA TO CENTROID in.	:	.570	.384	.383
MIN RADIUS	:	.203	.363	.484
MEAN RADIUS	:	.986	.829	.739
MAX RADIUS	:	2.192	1.426	1.155
HORIZONTAL SPREAD	:	1.601	1.601	1.601
VERTICAL SPREAD	:	3.270	2.382	1.853
EXTREME SPREAD	:	3.352	2.391	1.899
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.
MODEL 700TM M24
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C6522213
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