C6522186

MODEL 700™ M24

Model SWS™

Action

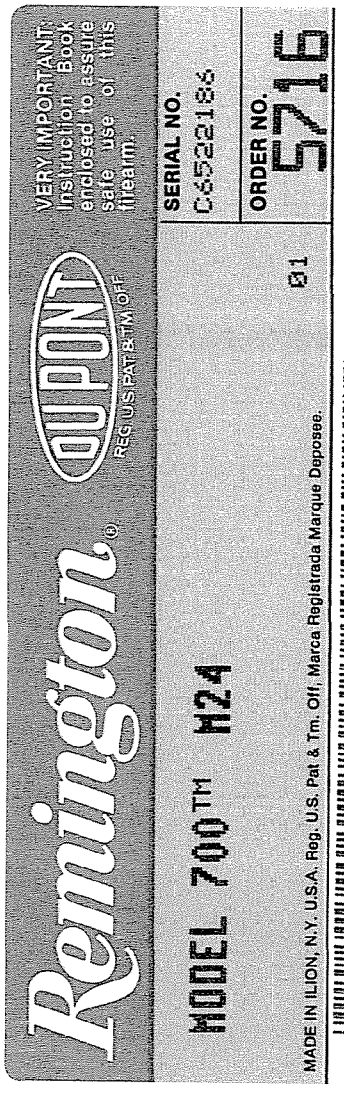
Barrel Length

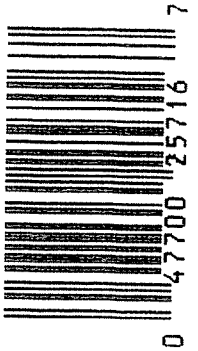
Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.
MODEL 700TM M24
SERIAL NO.
C6522186
ORDER NO.
5716
01
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off.; Marca Registrada Marque Deposee.
5716 C6522186


UPC
0 47700 25716 7

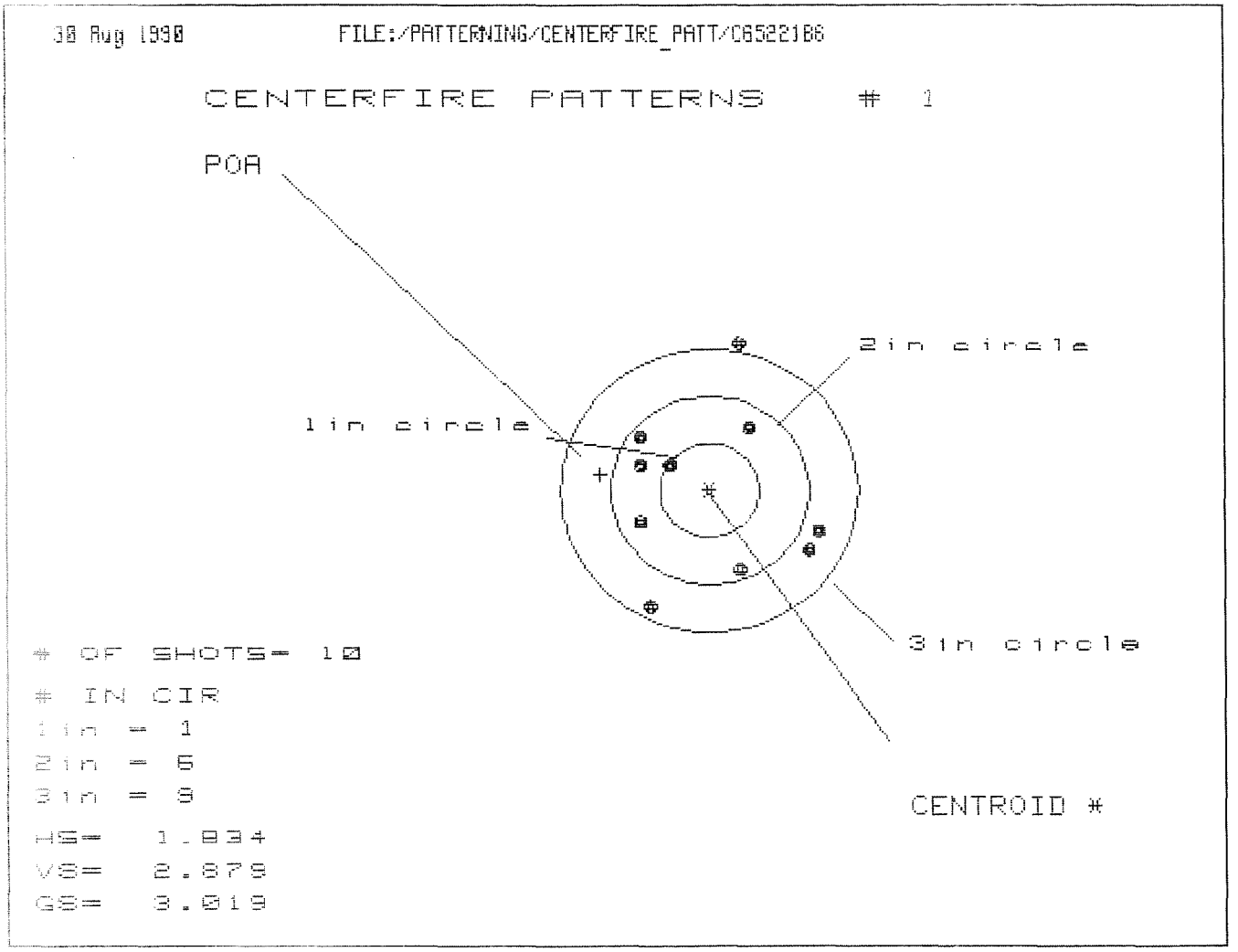
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522186
30 Aug 1990

CENTROIDAL DISTANCES

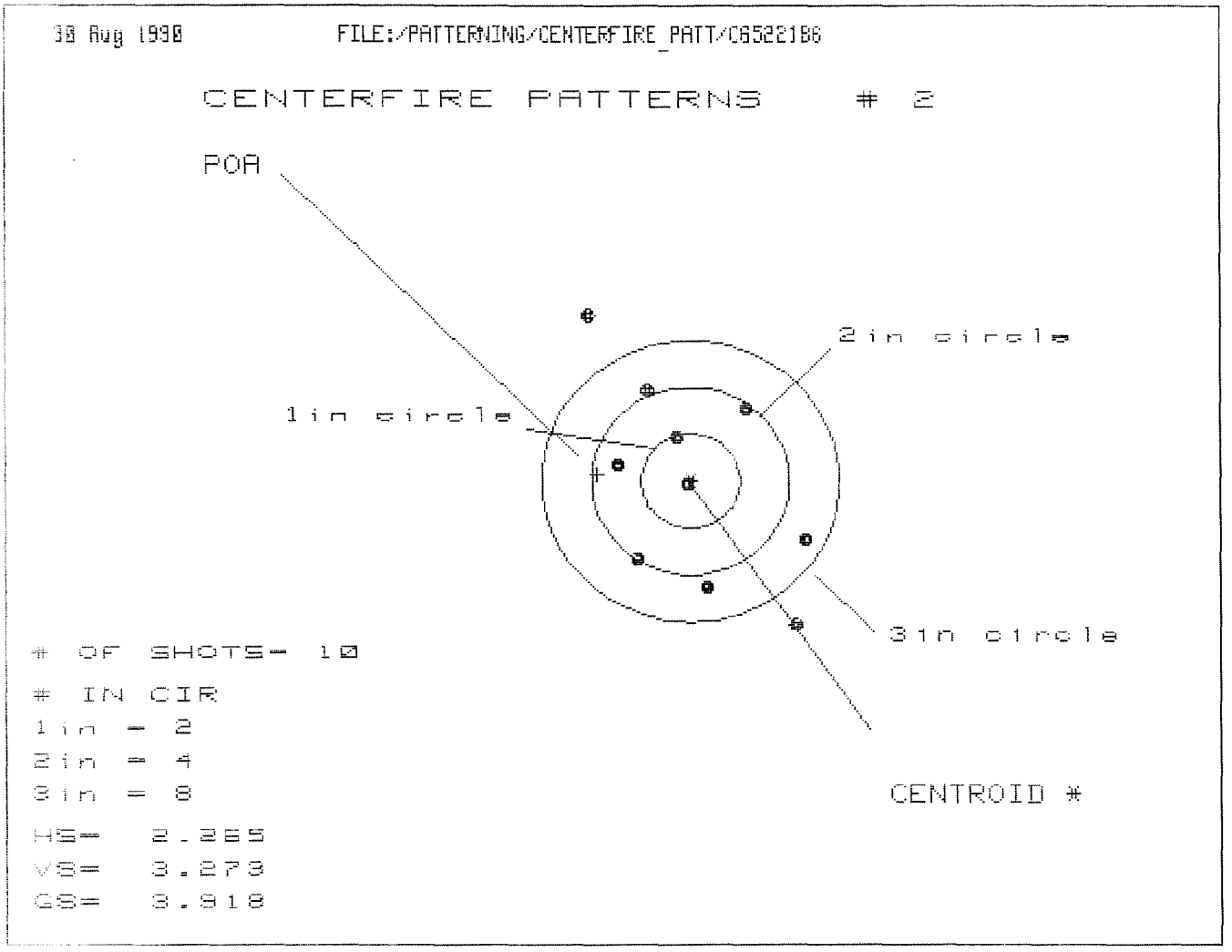
Ø	TO	1	1.11488
1	TO	2	.189336
1	TO	3	.356041
1	TO	4	.828409
1	TO	5	.63694

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .8238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .828551

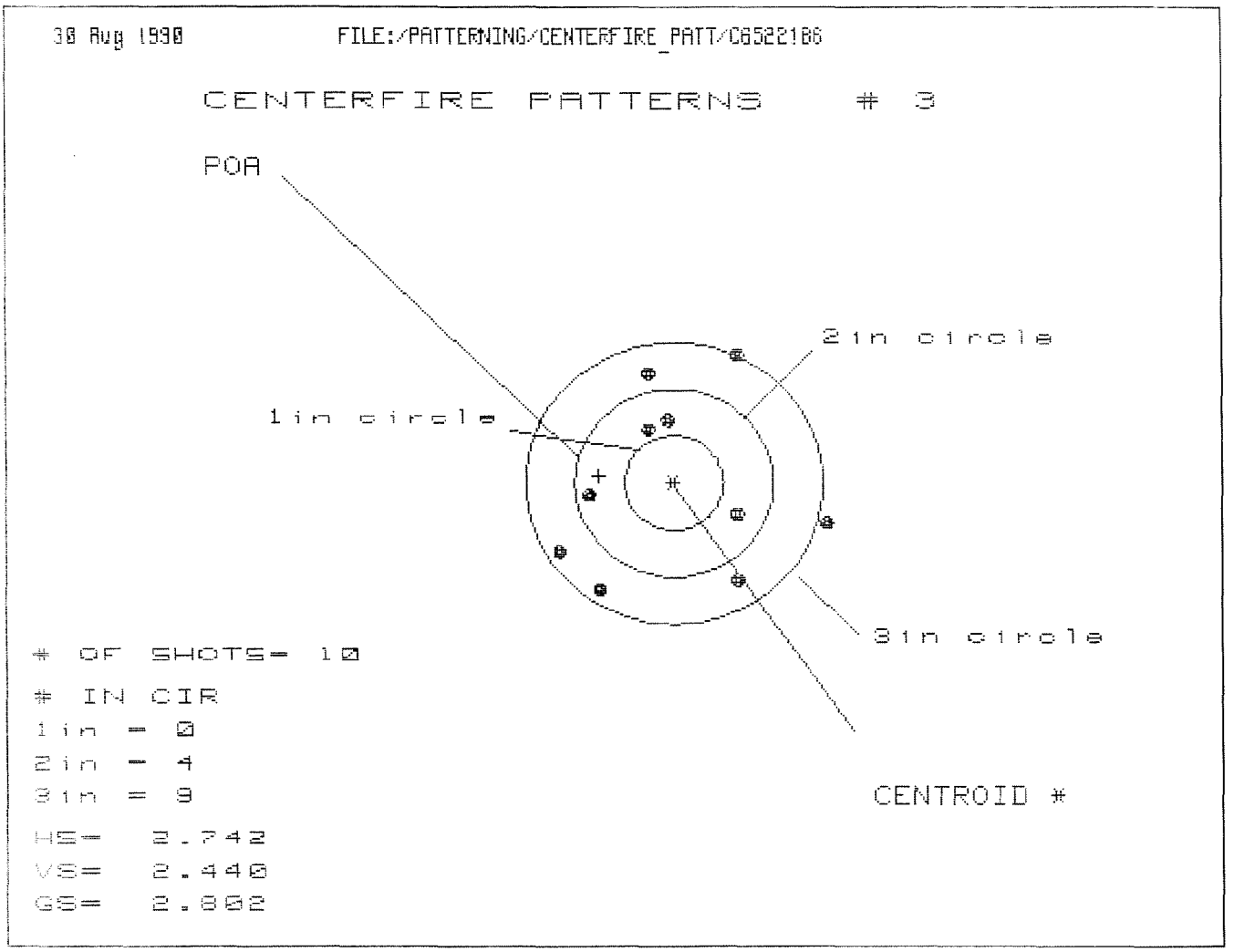
THE AMP FOR THIS RIFLE IS: 1.022



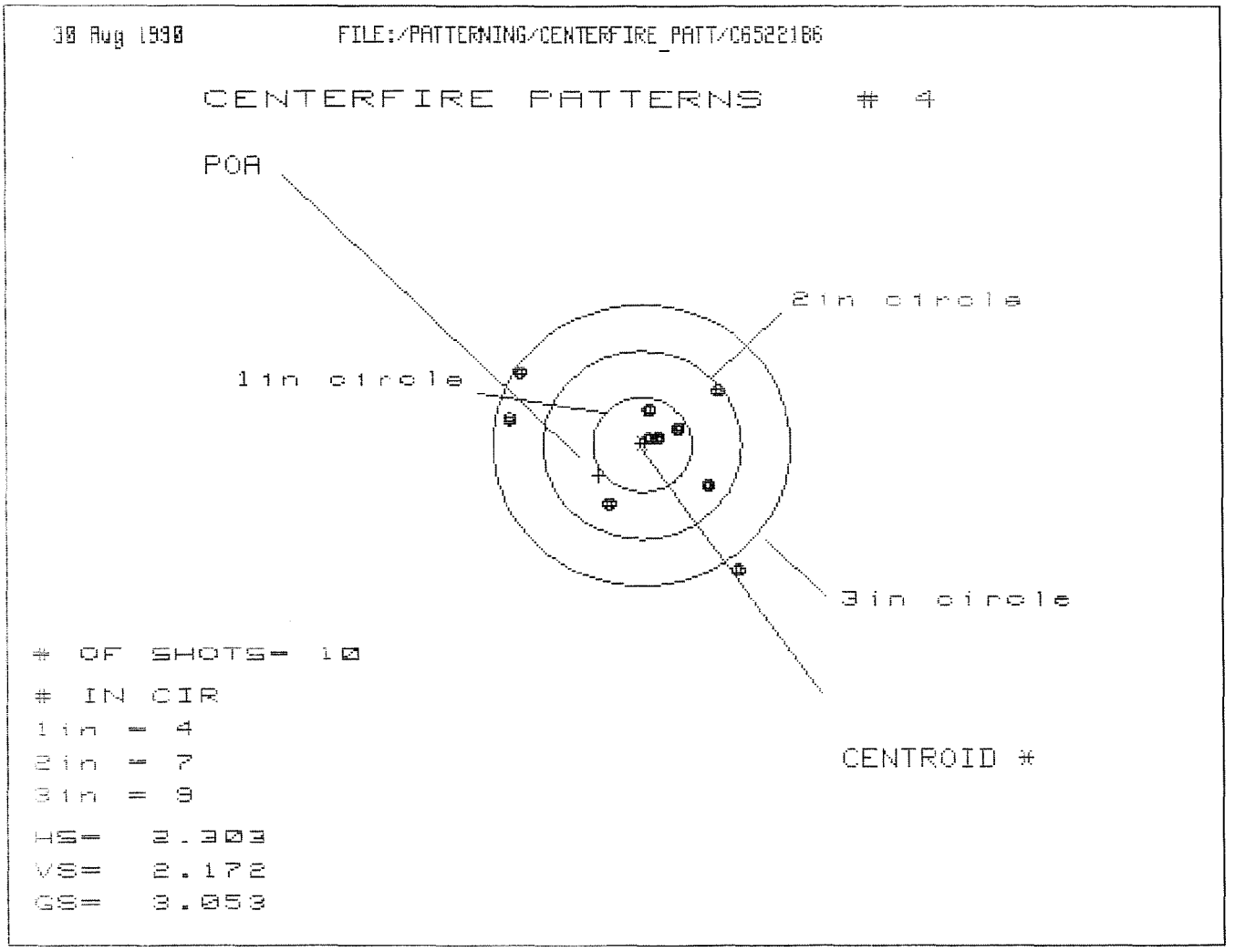
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.123	1.155	1.081
MINIMUM X	:	-.711	-.679	-.753
MAXIMUM Y	:	1.610	.852	.715
MINIMUM Y	:	-1.269	-1.090	-.740
CENTROID X	:	1.102	1.070	1.144
CENTROID Y	:	-.169	-.348	-.211
POA TO CENTROID in.	:	1.114	1.125	1.163
MIN RADIUS	:	.465	.567	.524
MEAN RADIUS	:	.985	.906	.856
MAX RADIUS	:	1.635	1.240	1.136
HORIZONTAL SPREAD	:	1.834	1.834	1.834
VERTICAL SPREAD	:	2.879	1.942	1.455
EXTREME SPREAD	:	3.019	2.206	2.032
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



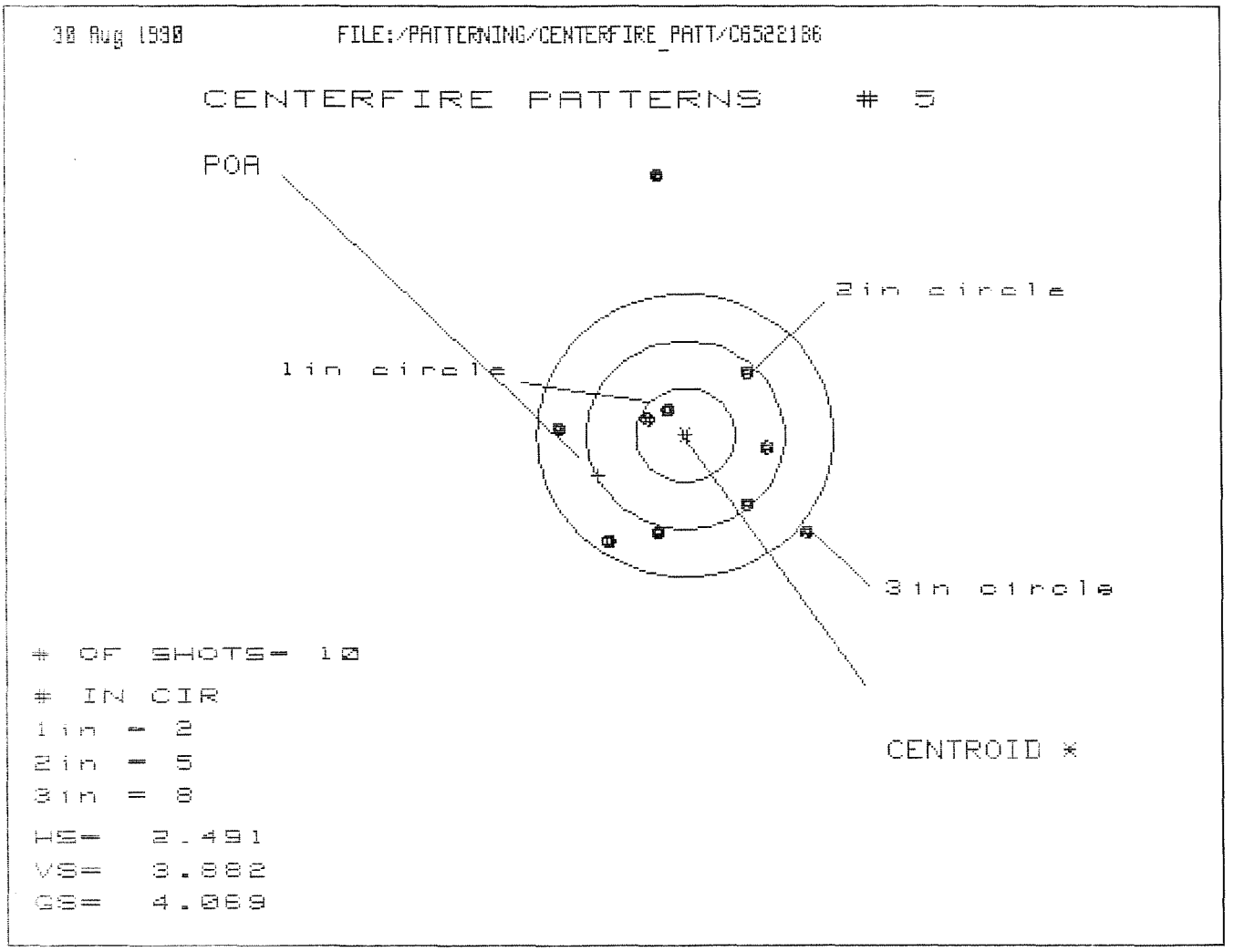
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.078	1.199
MINIMUM X	:	-1.068	-.820	-.699
MAXIMUM Y	:	1.789	1.140	.979
MINIMUM Y	:	-1.484	-1.285	-1.060
CENTROID X	:	.940	1.059	.938
CENTROID Y	:	-.071	-.270	-.109
POA TO CENTROID in.	:	.943	1.092	.944
MIN RADIUS	:	.069	.215	.042
MEAN RADIUS	:	1.061	.968	.836
MAX RADIUS	:	2.084	1.608	1.328
HORIZONTAL SPREAD	:	2.265	1.898	1.898
VERTICAL SPREAD	:	3.273	2.425	2.039
EXTREME SPREAD	:	3.918	2.872	2.264
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.577	.791	.887
MINIMUM X	:	-1.165	-.989	-.891
MAXIMUM Y	:	1.338	1.289	1.327
MINIMUM Y	:	-1.102	-1.151	-.990
CENTROID X	:	.760	.584	.485
CENTROID Y	:	-.070	-.021	-.182
POA TO CENTROID in.	:	.763	.585	.519
MIN RADIUS	:	.644	.545	.592
MEAN RADIUS	:	1.118	1.040	.978
MAX RADIUS	:	1.638	1.512	1.327
HORIZONTAL SPREAD	:	2.742	1.780	1.778
VERTICAL SPREAD	:	2.440	2.440	2.317
EXTREME SPREAD	:	2.802	2.802	2.413
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.940	.848	.710
MINIMUM X	:	-1.363	-1.258	-1.396
MAXIMUM Y	:	.815	.665	.533
MINIMUM Y	:	-1.357	-.819	-.736
CENTROID X	:	.437	.332	.470
CENTROID Y	:	.325	.475	.392
POA TO CENTROID in.	:	.544	.580	.612
MIN RADIUS	:	.035	.169	.040
MEAN RADIUS	:	.796	.717	.589
MAX RADIUS	:	1.651	1.286	1.419
HORIZONTAL SPREAD	:	2.303	2.106	2.106
VERTICAL SPREAD	:	2.172	1.484	1.269
EXTREME SPREAD	:	3.053	2.212	2.124
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.174	1.145	.946
MINIMUM X	:	-1.317	-1.346	-1.202
MAXIMUM Y	:	2.802	.951	.865
MINIMUM Y	:	-1.080	-.769	-.856
CENTROID X	:	.880	.909	.765
CENTROID Y	:	.428	.117	.203
POA TO CENTROID in.	:	.978	.916	.792
MIN RADIUS	:	.327	.627	.478
MEAN RADIUS	:	1.149	.947	.882
MAX RADIUS	:	2.814	1.390	1.230
HORIZONTAL SPREAD	:	2.491	2.491	2.148
VERTICAL SPREAD	:	3.882	1.720	1.720
EXTREME SPREAD	:	4.069	2.701	2.230
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522186
DATE 8/27/93
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.43	2.45	2.05	MIN. SETTING,
PULL #2	2.43	2.38	2.40	2.10	NO AVG. OF 5
PULL #3	2.41	2.43	2.36	2.10	READINGS ACCEPT-
PULL #4	2.46	2.38	2.43	2.05	ABLE LESS THAN 2#
PULL #5	2.43	2.41	2.41	2.05	
TOTAL	12.09	12.03	12.05	10.35	
AVG.	2.418	2.406	2.41	2.07	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.14		
PULL #2	3.19	3.15		
PULL #3	3.25	3.13		
PULL #4	3.19	3.17		
PULL #5	3.18	3.10		
TOTAL	16.04	15.69		
AVG.	3.208	3.138		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.34		4.42
PULL #2	4.36	4.43		4.47
PULL #3	4.38	4.41		4.45
PULL #4	4.35	4.43		4.43
PULL #5	4.44	4.44		4.50
TOTAL	22.01	22.05		22.28
AVG.	4.402	4.41		4.456

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522186

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	G.S.
617	Drill and Tap Sight Holes		8/10/90	KB
618	Polish Barrel RB		8/14/90	RB
620	Apply Coatings (Barrel Action)		8-22-90	RS
	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		8/27/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/27/90	RW
	G) Safety Off Force	3	3	3			8/27/90	RW
	H) Trigger Pull Test & Retainability						8/27/90	RW
	I) Firing Pin Indent	.024	.023	.023			8/27/90	RW
	J) Assemble Stock						8/27/90	RW
	K) Assemble Swivel Studs						9/5/90	RW
	L) Attach Front and Rear Sight Assemblies						8/27/90	RW
	M) Iron Sight Alignment						8/27/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/27/90	RW
	O) Attach Scope to Rifle						8/27/90	RW
	P) Detach & Attach Scope 20 Times						8/27/90	RW
640	Gallery Target & Test						8-30-90	DH
	A) Time						8-30-90	DH
	B) Malfunctions						8-30-90	DH
	C) Pierced Primers						8-30-90	DH
	D) Optical Clearity of Scope						8-30-90	DH
645	Inspect for Live Ammo						8-30-90	DH
655	Final Inspection A) Headspace						9/5/90	RW
	B) Trigger Pull	2.05	2.10	2.10	2.05	2.05	9/1/90	RW
	C) Function						9/5/90	RW
660	Pack						9-18-90	RW