

C6522173

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smead®

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522173

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12	90	RW
600	Proof	7 12	90	RW
607	Check Headspace	7 12	90	RW
610	Dis-assemble Gun	7 12	90	RW
612	Magnaflux Barrel Action		7-17-90	HR
	Magnaflux Bolt		7-17-90	HR
615	Rollmark Caliber		7-17-90	LS
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel <i>LB</i>		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-16-90	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/90	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/16/90	RL
	G) Safety Off Force	3	3	3			8/16/90	RL
	H) Trigger Pull Test & Retainability						8/17/90	RL
	I) Firing Pin Indent	.0215	.021	.021			8/16/90	RL
	J) Assemble Stock						8/20/90	RL
	K) Assemble Swivel Studs						8/29/90	RL
	L) Attach Front and Rear Sight Assemblies						8/20/90	RL
	M) Iron Sight Alignment						8/20/90	RL
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	RL
	O) Attach Scope to Rifle						8/20/90	RL
	P) Detach & Attach Scope 20 Times						8/20/90	RL
640	Gallery Target & Test						8/20/90	RF
	A) Time						8/20/90	RF
	B) Malfunctions						8/20/90	RF
	C) Pierced Primers						8/20/90	RF
	D) Optical Clarity of Scope						8/20/90	RF
645	Inspect for Live Ammo						8/20/90	RF
655	Final Inspection							
	A) Headspace						8/29/90	RL
	B) Trigger Pull	2.46	2.40	2.48	2.38	2.50	8/22/90	RL
	C) Function						8/29/90	RL
660	Pack						9/20/90	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522173

DATE 8/17/92

TESTER gll

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.25	2.50	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.31	2.51	2.40	
PULL #3	2.32	2.30	2.50	2.48	
PULL #4	2.26	2.25	2.50	2.38	
PULL #5	2.31	2.28	2.35	2.50	
TOTAL	11.66	11.39	12.36	12.22	
AVG.	2.332	2.278	2.472	2.444	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.29		
PULL #2	3.32	3.30		
PULL #3	3.42	3.28		
PULL #4	3.40	3.30		
PULL #5	3.43	3.47		
TOTAL	16.98	16.64		
AVG.	3.396	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.27		4.38
PULL #2	4.20	4.28		4.50
PULL #3	4.33	4.31		4.31
PULL #4	4.27	4.27		4.33
PULL #5	4.34	4.32		4.40
TOTAL	21.49	21.45		21.92
AVG.	4.298	4.29		4.384

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6522173
 21 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.399566
1 TO	2	.474482
1 TO	3	.775542
1 TO	4	.1386
1 TO	5	.653723

$\begin{matrix} \text{P} \\ \text{t} \\ \text{a} \end{matrix} \begin{matrix} 5 \\ 1 \\ 3 \end{matrix} \quad \text{<----POA}$

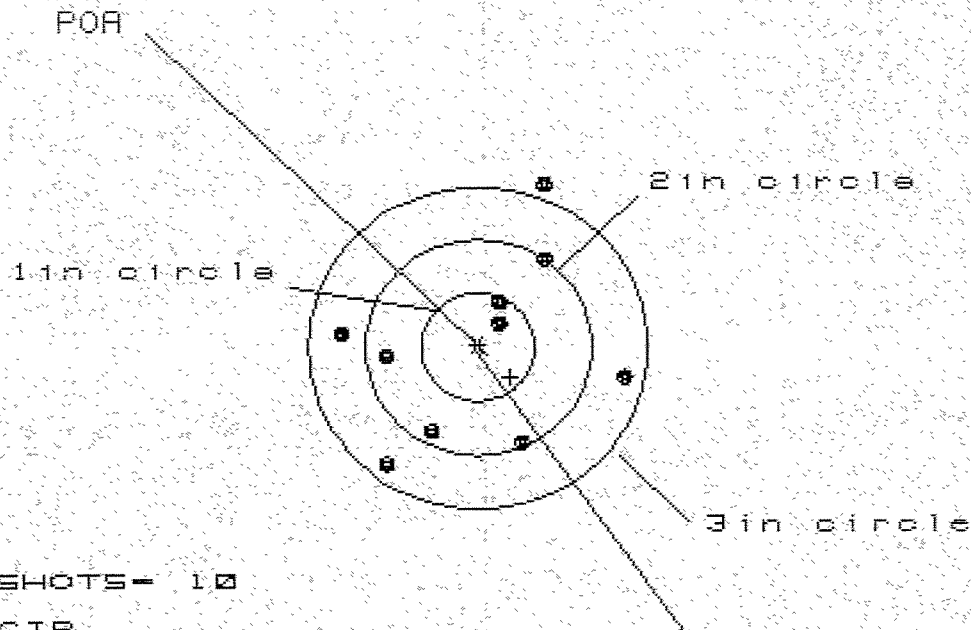
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0382
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0388
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0544489
 THE AMR FOR THIS RIFLE IS: .9976

28 Aug 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C6522173

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.500

VS = 2.545

GS = 2.908

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.317	1.379	1.280
MINIMUM X	-1.183	-1.121	-1.220
MAXIMUM Y	1.473	.984	.870
MINIMUM Y	-1.072	-.908	-.800
CENTROID X	-.287	-.349	-.250
CENTROID Y	.278	.114	.228
POA TO CENTROID in.	.400	.367	.338
MIN RADIUS	.258	.429	.282
MEAN RADIUS	.982	.916	.862
MAX RADIUS	1.573	1.387	1.307
HORIZONTAL SPREAD	2.500	2.500	2.500
VERTICAL SPREAD	2.545	1.892	1.670
EXTREME SPREAD	2.908	2.536	2.536
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

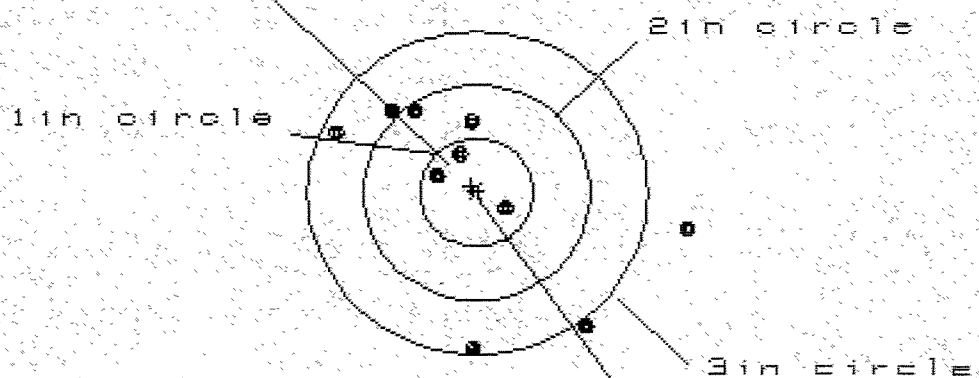
28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522173

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.035

VS= 2.270

GS= 3.178

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.821	1.139	.629
MINIMUM X	:	-1.214	-1.012	-.870
MAXIMUM Y	:	.781	.737	.572
MINIMUM Y	:	-1.489	-1.533	-1.698
CENTROID X	:	.046	-.156	-.298
CENTROID Y	:	-.060	-.016	.149
POA TO CENTROID in.	:	.075	.157	.334
MIN RADIUS	:	.302	.169	.049
MEAN RADIUS	:	.998	.863	.689
MAX RADIUS	:	1.862	1.747	1.729
HORIZONTAL SPREAD	:	3.035	2.151	1.499
VERTICAL SPREAD	:	2.270	2.270	2.270
EXTREME SPREAD	:	3.178	2.027	2.368
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.760

VS= 2.525

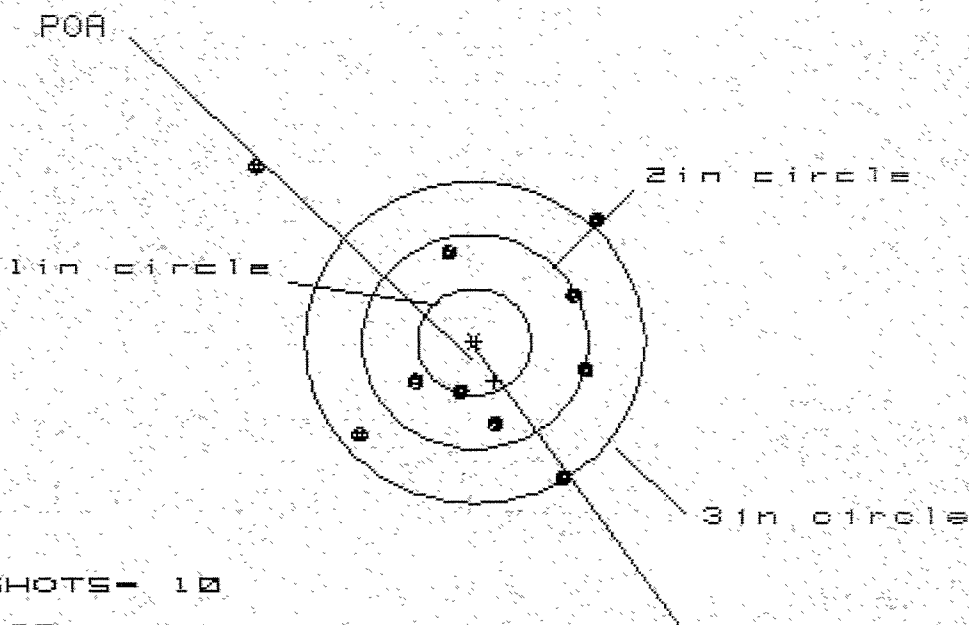
GS= 2.643

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.636	.620	.590
MINIMUM X	:	-1.124	-1.140	-1.062
MAXIMUM Y	:	1.133	.979	1.075
MINIMUM Y	:	-1.392	-1.179	-1.057
CENTROID X	:	-.114	-.098	-.176
CENTROID Y	:	-.478	-.324	-.446
POA TO CENTROID in.	:	.492	.338	.479
MIN RADIUS	:	.381	.474	.451
MEAN RADIUS	:	.951	.889	.858
MAX RADIUS	:	1.399	1.350	1.221
HORIZONTAL SPREAD	:	1.760	1.760	1.652
VERTICAL SPREAD	:	2.525	2.158	2.132
EXTREME SPREAD	:	2.643	2.448	2.132
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

29 Aug 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.978

VS= 2.923

GS= 3.942

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.070	.858	.867
MINIMUM X	-1.908	-1.225	-1.118
MAXIMUM Y	1.624	1.289	1.171
MINIMUM Y	-1.299	-1.118	-.957
CENTROID X	-.176	.036	-.071
CENTROID Y	.361	.180	.019
POA TO CENTROID in.	.401	.184	.074
MIN RADIUS	.518	.491	.312
MEAN RADIUS	1.174	.987	.890
MAX RADIUS	2.506	1.548	1.250
HORIZONTAL SPREAD	2.978	2.083	1.985
VERTICAL SPREAD	2.923	2.407	2.128
EXTREME SPREAD	3.942	2.894	2.345
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

28 Aug 1998

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.720

VS= 2.555

GS= 2.562

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.641	.631	.594
MINIMUM X	-1.079	-1.089	-1.126
MAXIMUM Y	1.356	.840	.709
MINIMUM Y	-1.199	-1.049	-1.002
CENTROID X	.340	.350	.387
CENTROID Y	.093	-.057	.074
POA TO CENTROID in.	.352	.355	.394
MIN RADIUS	.141	.285	.151
MEAN RADIUS	.883	.839	.777
MAX RADIUS	1.359	1.109	1.176
HORIZONTAL SPREAD	1.720	1.720	1.720
VERTICAL SPREAD	2.555	1.889	1.711
EXTREME SPREAD	2.562	2.031	1.930
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

Remington®

MODEL 700™ H24

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

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

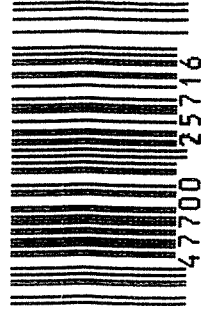
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6522173	ORDER NO. 5716
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5716 C6522173

UPC



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