

C6522300

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

rear sight base
& stock needs
touch-up

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522300

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KA
600	Proof		7/10/90	KA
607	Check Headspace		7/10/90	KA
610	Dis-assemble Gun		7/10/90	KA
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	GS
617	Drill and Tap Sight Holes		7/22/90	EB
618	Polish Barrel AB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/90	KS
	C) Inspect Ejector Hole for Chamfer		8/22/90	KS
	D) Oil Firing Pin Ass'y		8/22/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/90	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			9/4/90	WB
	H) Trigger Pull Test & Retainability						9/1/90	JS
	I) Firing Pin Indent	.022	.0225	.0225			9/4/90	WB
	J) Assemble Stock						9/4/90	KS
	K) Assemble Swivel Studs						9/8/90	JS
	L) Attach Front and Rear Sight Assemblies						9/4/90	KS
	M) Iron Sight Alignment						9/4/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	KS
	O) Attach Scope to Rifle						9/4/90	KS
	P) Detach & Attach Scope 20 Times						9/4/90	KS
640	Gallery Target & Test						9/6/90	KJ
	A) Time						9/6/90	KJ
	B) Malfunctions						9/6/90	KJ
	C) Pierced Primers						9/6/90	KJ
	D) Optical Clarity of Scope						9/6/90	193
645	Inspect for Live Ammo						9/6/90	122
655	Final Inspection							
	A) Headspace						9/8/90	JS
	B) Trigger Pull	2.52	2.53	2.57	2.53	2.54	9-7-90	JS
	C) Function						9/8/90	JS
660	Pack						9-9-90	DA

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

SERIAL NO. 06522300DATE 9/1/90TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.33	2.20	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.15	2.22	2.30	2.53	
PULL #3	2.19	2.24	2.26	2.57	
PULL #4	2.44	2.26	2.27	2.53	
PULL #5	2.27	2.25	2.22	2.54	
TOTAL	11.45	11.30	11.25	12.69	
AVG.	2.29	2.26	2.25	2.538	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.14		
PULL #2	3.26	3.20		
PULL #3	3.22	3.11		
PULL #4	3.24	3.20		
PULL #5	3.23	3.13		
TOTAL	16.22	15.78		
AVG.	3.244	3.156		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.23		4.50
PULL #2	4.21	4.50		4.46
PULL #3	4.41	4.29		4.27
PULL #4	4.31	4.47		4.49
PULL #5	4.50	4.30		4.43
TOTAL	21.61	21.78		22.15
AVG.	4.322	4.356		4.43

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522300
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.050448
1 TO	2	.150602
1 TO	3	.0468722
1 TO	4	.1364
1 TO	5	.185421

⊙ (---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.024$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.0458$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0517073$
THE AMR FOR THIS RIFLE IS: $.764$

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/=CB522300

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.953

VS= 1.687

GS= 2.135

CENTROID *

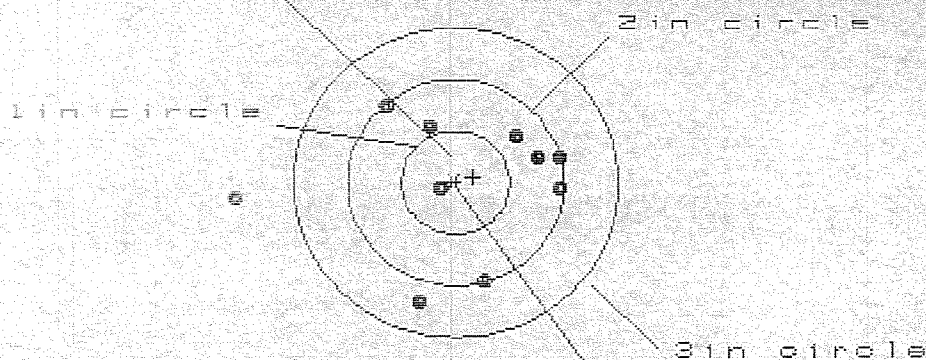
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.921	.806	.698
MINIMUM X	-1.032	-.868	-.955
MAXIMUM Y	.905	.828	.698
MINIMUM Y	-.781	-.859	-.756
CENTROID X	-.039	.076	.184
CENTROID Y	.032	.110	.007
POA TO CENTROID in.	.051	.134	.184
MIN RADIUS	.388	.485	.483
MEAN RADIUS	.845	.787	.727
MAX RADIUS	1.248	1.199	1.003
HORIZONTAL SPREAD	1.953	1.674	1.653
VERTICAL SPREAD	1.687	1.687	1.454
EXTREME SPREAD	2.135	2.127	1.790
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

6 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/=C6522300

CENTERFIRE PATTERNS # 2

POB



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.990

VS= 1.849

GS= 3.021

CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.950	.724	.649
MINIMUM X	:	-2.040	-.885	-.960
MAXIMUM Y	:	.742	.721	.580
MINIMUM Y	:	-1.107	-1.128	-1.155
CENTROID X	:	-.164	.062	.138
CENTROID Y	:	-.052	-.031	.110
POB TO CENTROID in.	:	.172	.070	.176
MIN RADIUS	:	.155	.382	.428
MEAN RADIUS	:	.946	.795	.704
MAX RADIUS	:	2.048	1.278	1.155
HORIZONTAL SPREAD	:	2.990	1.609	1.609
VERTICAL SPREAD	:	1.849	1.849	1.735
EXTREME SPREAD	:	3.021	1.971	1.971
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/=CB522300

CENTERFIRE PATTERNS # 3

POB

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.930

VS= 1.528

GS= 2.067

CENTROID #

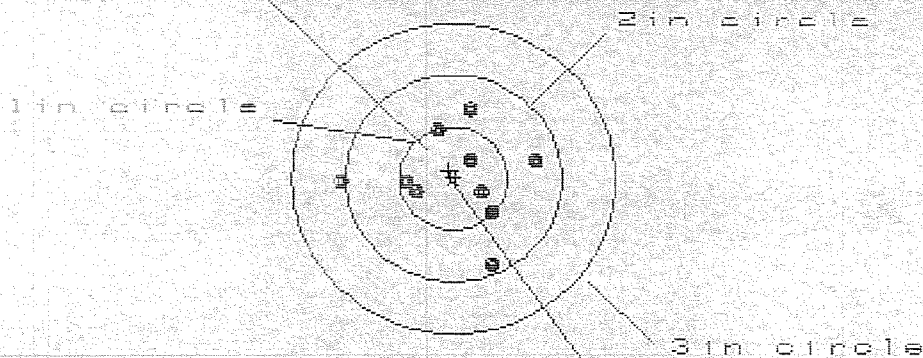
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.855	.735	.592
MINIMUM X	-1.075	-1.144	-.491
MAXIMUM Y	.811	.731	.767
MINIMUM Y	-.717	-.582	-.546
CENTROID X	-.030	.090	.233
CENTROID Y	-.014	.066	.030
POB TO CENTROID in.	.033	.111	.235
MIN RADIUS	.206	.111	.030
MEAN RADIUS	.664	.554	.452
MAX RADIUS	1.292	1.178	.910
HORIZONTAL SPREAD	1.930	1.079	1.083
VERTICAL SPREAD	1.528	1.313	1.313
EXTREME SPREAD	2.067	2.067	1.702
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

6 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/=06522300

CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 1.8009

VS= 1.495

GS= 1.825

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.731	.611	.642
MINIMUM X	:	-1.078	-.607	-.576
MAXIMUM Y	:	.675	.668	.564
MINIMUM Y	:	-.820	-.827	-.471
CENTROID X	:	.043	.163	.132
CENTROID Y	:	-.077	-.069	.035
POB TO CENTROID in.	:	.088	.177	.136
MIN RADIUS	:	.202	.134	.064
MEAN RADIUS	:	.571	.499	.445
MAX RADIUS	:	1.080	.864	.645
HORIZONTAL SPREAD	:	1.809	1.218	1.218
VERTICAL SPREAD	:	1.495	1.495	1.035
EXTREME SPREAD	:	1.825	1.508	1.227
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/=C6522300

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.920

VS= 1.287

GS= 2.920

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	.940	.796
MINIMUM X	:	-1.325	-1.147	-.595
MAXIMUM Y	:	.661	.592	.508
MINIMUM Y	:	-.626	-.666	-.687
CENTROID X	:	.070	-.108	.036
CENTROID Y	:	-.118	-.049	.035
POA TO CENTROID in.	:	.137	.118	.050
MIN RADIUS	:	.283	.305	.375
MEAN RADIUS	:	.794	.670	.579
MAX RADIUS	:	1.714	1.327	.813
HORIZONTAL SPREAD	:	2.920	2.087	1.391
VERTICAL SPREAD	:	1.287	1.258	1.195
EXTREME SPREAD	:	2.920	2.167	1.453
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®

MODEL 700™ M24

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

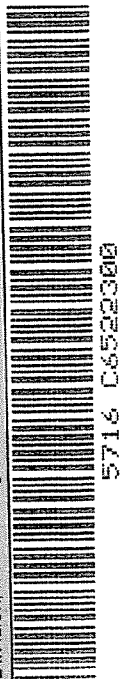
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6522300

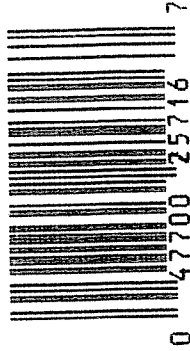
ORDER NO.
5716

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

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