

C6522327

MODEL 700™ M24

Model **SWS**™

Action **1**

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700 TM M24	SERIAL NO. C6522327
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.	ORDER NO. 5716



5716 C6522327

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # ;06522327
14 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.254372
1 TO	2	.780641
1 TO	3	.316901
1 TO	4	.289638
1 TO	5	.631709

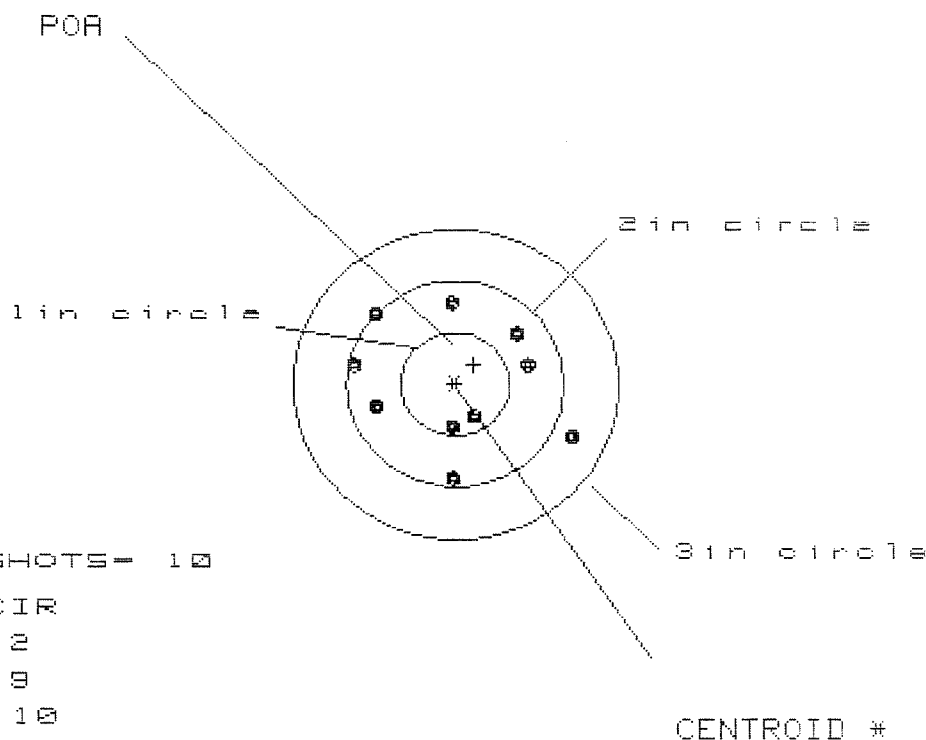
2
3,4
1
5
(----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1728
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .276927
THE AMR FOR THIS RIFLE IS: .7606

14 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522327

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 1.998

VS= 1.651

GS= 2.114

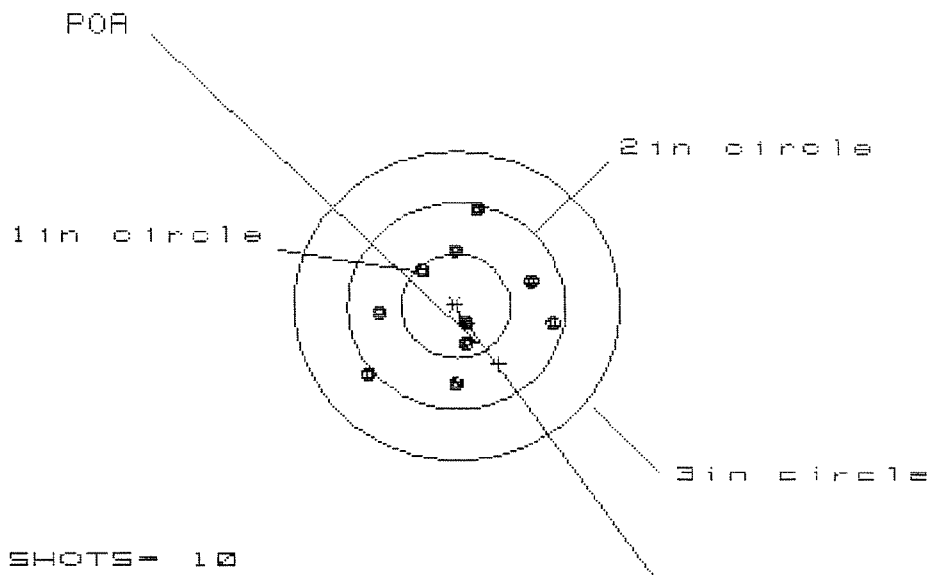
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.055	.814	.742
MINIMUM X	:	-.943	-.826	-.898
MAXIMUM Y	:	.762	.709	.791
MINIMUM Y	:	-.889	-.942	-.860
CENTROID X	:	-.168	-.285	-.213
CENTROID Y	:	-.191	-.138	-.220
POA TO CENTROID in.	:	.254	.317	.306
MIN RADIUS	:	.298	.405	.295
MEAN RADIUS	:	.772	.731	.694
MAX RADIUS	:	1.156	.944	.916
HORIZONTAL SPREAD	:	1.998	1.640	1.640
VERTICAL SPREAD	:	1.651	1.651	1.651
EXTREME SPREAD	:	2.114	1.723	1.652
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522327

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.667

VS= 1.680

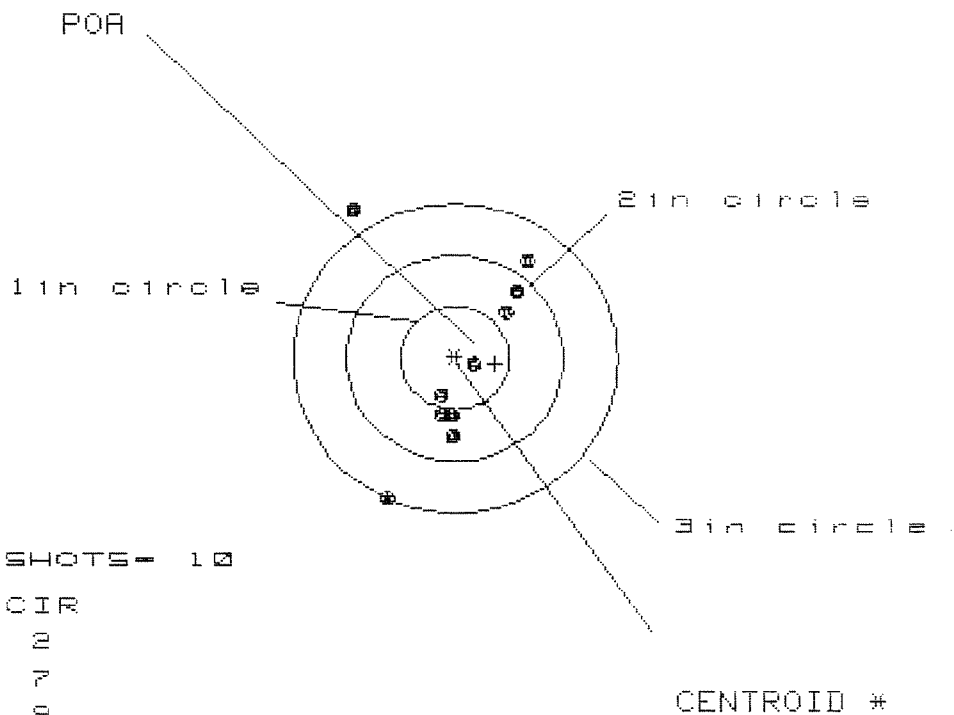
GS= 1.901

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.846	.754	.765
MINIMUM X	-.821	-.844	-.833
MAXIMUM Y	.955	.881	.617
MINIMUM Y	-.725	-.799	-.689
CENTROID X	-.388	-.296	-.387
CENTROID Y	.558	.632	.522
POA TO CENTROID in.	.679	.698	.605
MIN RADIUS	.185	.220	.114
MEAN RADIUS	.672	.628	.577
MAX RADIUS	1.056	.885	.834
HORIZONTAL SPREAD	1.667	1.598	1.598
VERTICAL SPREAD	1.680	1.680	1.306
EXTREME SPREAD	1.901	1.691	1.601
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

14 Aug 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.557

VS= 2.819

GS= 2.836

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.656	.556	.470
MINIMUM X	:	-.901	-.694	-.314
MAXIMUM Y	:	1.492	1.102	.957
MINIMUM Y	:	-1.327	-1.161	-.717
CENTROID X	:	-.369	-.269	-.183
CENTROID Y	:	.054	-.112	.033
POA TO CENTROID in.	:	.373	.292	.186
MIN RADIUS	:	.201	.141	.039
MEAN RADIUS	:	.825	.679	.601
MAX RADIUS	:	1.743	1.353	1.066
HORIZONTAL SPREAD	:	1.557	1.250	.784
VERTICAL SPREAD	:	2.819	2.263	1.674
EXTREME SPREAD	:	2.836	2.585	1.818
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Aug 1998

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.097

VS= 1.415

GS= 2.190

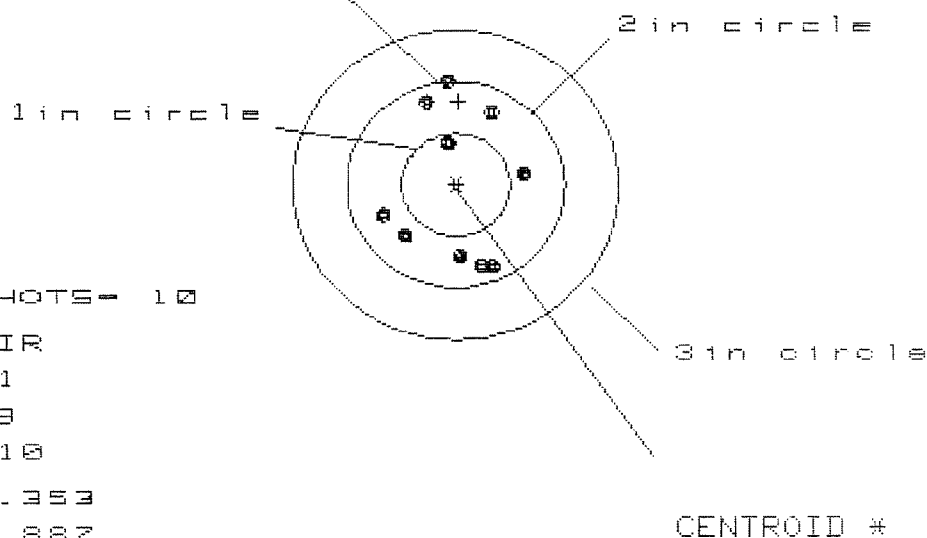
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	1.099	1.029
MINIMUM X	:	-.715	-.562	-.603
MAXIMUM Y	:	.738	.750	.548
MINIMUM Y	:	-.677	-.665	-.571
CENTROID X	:	-.129	-.282	-.212
CENTROID Y	:	-.478	-.490	-.584
POA TO CENTROID in.	:	.495	.566	.621
MIN RADIUS	:	.256	.212	.315
MEAN RADIUS	:	.782	.690	.665
MAX RADIUS	:	1.386	1.100	1.038
HORIZONTAL SPREAD	:	2.097	1.661	1.632
VERTICAL SPREAD	:	1.415	1.415	1.119
EXTREME SPREAD	:	2.190	1.806	1.666
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Aug 1998

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CENTERFIRE PATTERNS # 5

POA



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.647	.637	.682
MINIMUM X	:	-.706	-.716	-.671
MAXIMUM Y	:	1.049	.936	.845
MINIMUM Y	:	-.838	-.721	-.733
CENTROID X	:	-.028	-.018	-.063
CENTROID Y	:	-.807	-.924	-.833
POA TO CENTROID in.	:	.807	.924	.836
MIN RADIUS	:	.394	.509	.411
MEAN RADIUS	:	.752	.708	.692
MAX RADIUS	:	1.053	.975	.876
HORIZONTAL SPREAD	:	1.353	1.353	1.353
VERTICAL SPREAD	:	1.887	1.657	1.578
EXTREME SPREAD	:	1.944	1.774	1.648
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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

SERIAL NO C6522327DATE 9-12-90TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.30	2.33	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.30	2.27	2.39	
PULL #3	2.39	2.32	2.24	2.44	
PULL #4	2.42	2.33	2.29	2.46	
PULL #5	2.27	2.33	2.29	2.50	
TOTAL	11.48	11.58	11.42	12.18	
AVG.	2.296	2.316	2.284	2.436	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.27		
PULL #2	3.22	3.27		
PULL #3	3.27	3.27		
PULL #4	3.25	3.27		
PULL #5	3.30	3.28		
TOTAL	16.24	16.36		
AVG.	3.248	3.272		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.28		4.33
PULL #2	4.28	4.15		4.30
PULL #3	4.22	4.27		4.34
PULL #4	4.24	4.34		4.45
PULL #5	4.27	4.31		4.34
TOTAL	21.36	21.35		21.76
AVG.	4.272	4.27		4.352

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522327

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	LS
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	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-12-90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			8/8/90	SL
	G) Safety Off Force	2	2	2			8/8/90	SL
	H) Trigger Pull Test & Retainability						9-12-90	SL
	I) Firing Pin Indent	.0225	.022	.022			8/8/90	SL
	J) Assemble Stock						8/14/90	RW
	K) Assemble Swivel Studs						9/17/90	928
	L) Attach Front and Rear Sight Assemblies						8/14/90	RW
	M) Iron Sight Alignment						8/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/14/90	RW
	O) Attach Scope to Rifle						8/14/90	RW
	P) Detach & Attach Scope 20 Times						8/14/90	RW
640	Gallery Target & Test						8/14/90	NE
	A) Time						8/14/90	NE
	B) Malfunctions						8/14/90	NE
	C) Pierced Primers						8/14/90	NE
	D) Optical Clarity of Scope						8/14/90	NE
645	Inspect for Live Ammo						8/14/90	NE
655	Final Inspection							
	A) Headspace						9/13/90	928
	B) Trigger Pull	2.39	2.39	2.44	2.46	2.50	9/12/90	SL
	C) Function						9/13/90	928
660	Pack						9-19-90	DF