

C6522355

MODEL 700™ M24

Model **SWS**™

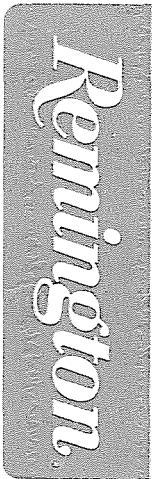
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]

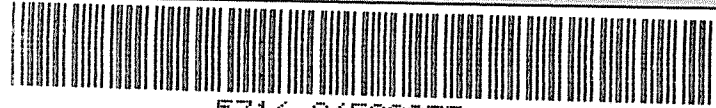

REG. U.S. PAT. & TM. OFF.

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

MODEL 700 TM M24	SERIAL NO. C6522355
	ORDER NO. 5716

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

01



5716 C6522355

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522355
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.295169
1 TO	2	.567101
1 TO	3	.0798123
1 TO	4	.527978
1 TO	5	.762342

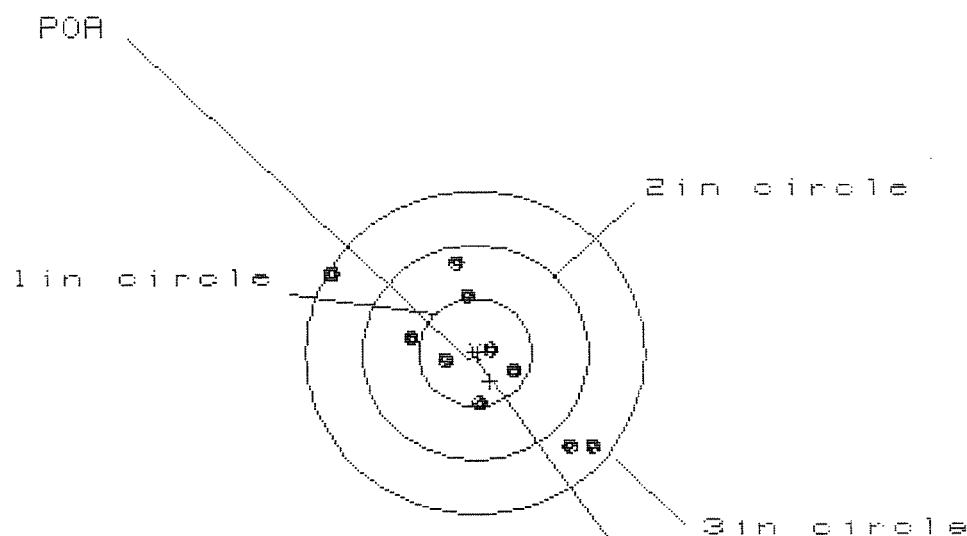
$\begin{matrix} 3 \\ 4 \\ 5 \end{matrix} \begin{matrix} + \\ - \\ + \end{matrix} 2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1598
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0176
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .160766
THE AMR FOR THIS RIFLE IS: .8208

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522355

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.374

VS= 1.690

GS= 2.876

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.074	.930	.759
MINIMUM X	:	-1.300	-.748	-.632
MAXIMUM Y	:	.807	.889	.789
MINIMUM Y	:	-.883	-.801	-.835
CENTROID X	:	-.130	.014	-.102
CENTROID Y	:	.265	.183	.283
POA TO CENTROID in.	:	.295	.183	.301
MIN RADIUS	:	.153	.126	.121
MEAN RADIUS	:	.733	.642	.554
MAX RADIUS	:	1.496	1.227	1.128
HORIZONTAL SPREAD	:	2.374	1.678	1.391
VERTICAL SPREAD	:	1.690	1.690	1.624
EXTREME SPREAD	:	2.876	2.103	1.889
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.427

VS= 1.959

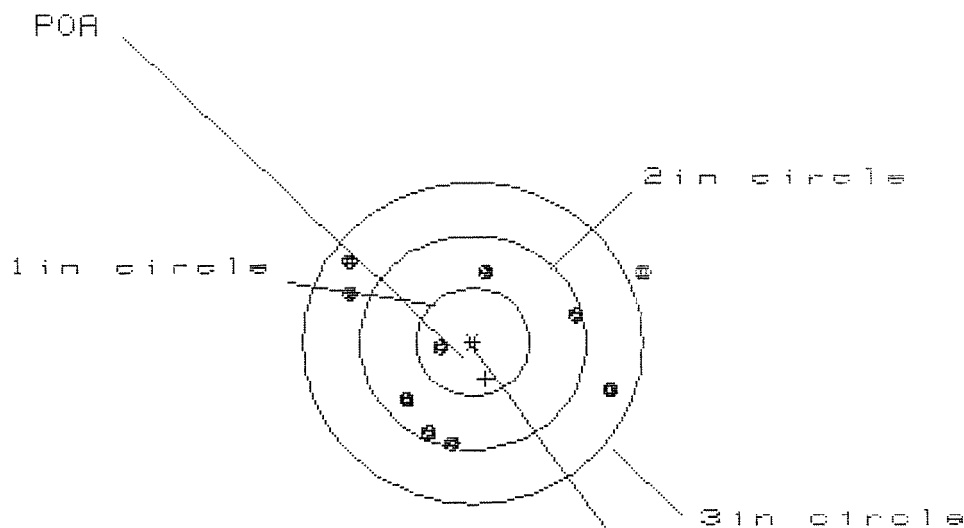
CS= 3.009

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.472	.309
MINIMUM X	:	-1.417	-1.305	-.368
MAXIMUM Y	:	.672	.529	.573
MINIMUM Y	:	-1.287	-.750	-.707
CENTROID X	:	.270	.158	.321
CENTROID Y	:	-.137	.006	-.037
POA TO CENTROID in.	:	.303	.158	.323
MIN RADIUS	:	.069	.144	.148
MEAN RADIUS	:	.645	.546	.420
MAX RADIUS	:	1.636	1.350	.710
HORIZONTAL SPREAD	:	2.427	1.777	.677
VERTICAL SPREAD	:	1.959	1.279	1.279
EXTREME SPREAD	:	3.009	1.887	1.282
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.611

VS= 1.615

GS= 2.618

CENTROID *

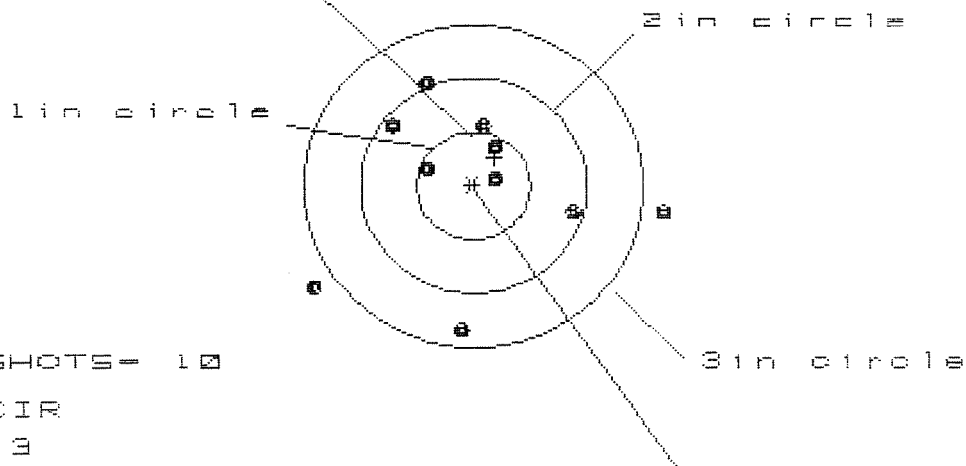
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	1.354	1.236
MINIMUM X	:	-1.112	-.945	-1.063
MAXIMUM Y	:	.708	.782	.781
MINIMUM Y	:	-.907	-.833	-.735
CENTROID X	:	-.109	-.276	-.158
CENTROID Y	:	.342	.268	.170
POA TO CENTROID in.	:	.359	.384	.232
MIN RADIUS	:	.291	.120	.262
MEAN RADIUS	:	.989	.879	.842
MAX RADIUS	:	1.642	1.416	1.277
HORIZONTAL SPREAD	:	2.611	2.299	2.299
VERTICAL SPREAD	:	1.615	1.615	1.516
EXTREME SPREAD	:	2.618	2.587	2.498
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.163

VS= 2.292

GS= 3.239

CENTROID #

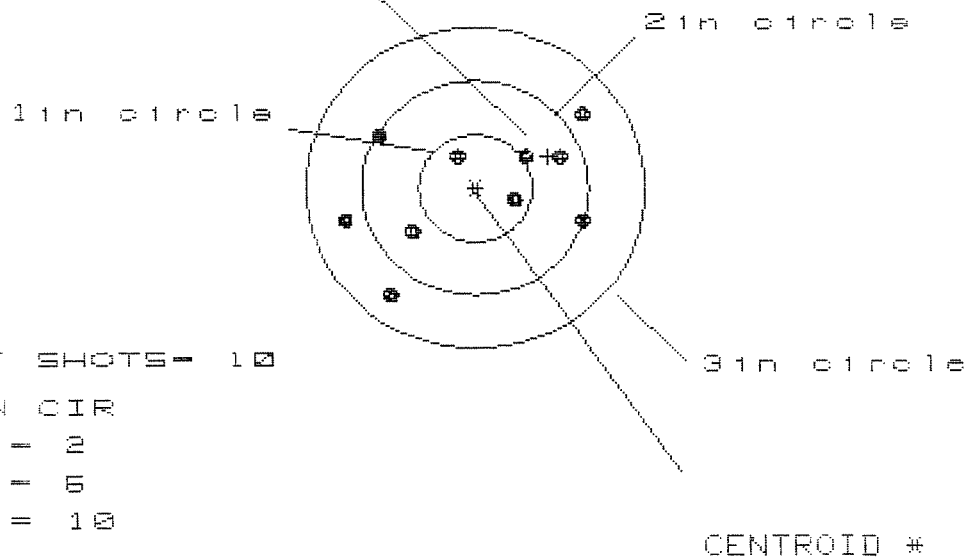
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.714	1.058	.901
MINIMUM X	-1.449	-1.259	-.637
MAXIMUM Y	.978	.956	.842
MINIMUM Y	-1.314	-1.336	-1.450
CENTROID X	-.186	-.376	-.219
CENTROID Y	-.260	-.238	-.124
POA TO CENTROID in.	.320	.445	.252
MIN RADIUS	.196	.238	.258
MEAN RADIUS	.916	.825	.686
MAX RADIUS	1.725	1.556	1.456
HORIZONTAL SPREAD	3.163	2.317	1.538
VERTICAL SPREAD	2.292	2.292	2.292
EXTREME SPREAD	3.239	2.414	2.302
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.044

VS = 1.722

GS = 2.411

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.923	.839	.688
MINIMUM X	:	-1.121	-1.205	-1.123
MAXIMUM Y	:	.688	.573	.525
MINIMUM Y	:	-1.034	-.486	-.534
CENTROID X	:	-.644	-.560	-.409
CENTROID Y	:	-.298	-.183	-.135
POA TO CENTROID in.	:	.710	.589	.431
MIN RADIUS	:	.277	.246	.223
MEAN RADIUS	:	.821	.747	.652
MAX RADIUS	:	1.286	1.265	1.175
HORIZONTAL SPREAD	:	2.044	2.044	1.811
VERTICAL SPREAD	:	1.722	1.059	1.059
EXTREME SPREAD	:	2.411	2.257	1.954
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
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. 06522355

DATE 8/15/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.43	2.50	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.37	2.53	2.17	
PULL #3	2.25	2.35	2.43	2.17	
PULL #4	2.31	2.22	2.50	2.19	
PULL #5	2.22	2.36	2.53	2.15	
TOTAL	11.52	11.73	12.49	10.89	
AVG.	2.304	2.346	2.498	2.178	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.20		
PULL #2	3.23	3.34		
PULL #3	3.12	3.30		
PULL #4	3.20	3.35		
PULL #5	3.26	3.30		
TOTAL	16.04	16.49		
AVG.	3.208	3.298		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.17		4.28
PULL #2	4.34	4.20		4.34
PULL #3	4.33	4.16		4.30
PULL #4	4.28	4.29		4.37
PULL #5	4.22	4.23		4.34
TOTAL	21.40	21.05		21.83
AVG.	4.28	4.21		4.366

B31
- Needs
Touch up
at muzzle
going

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522355

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KS
600	Proof		7/10/90	KS
607	Check Headspace		7/10/90	KS
610	Dis-assemble Gun		7/10/90	KS
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	LS
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	PA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	KS
	C) Inspect Ejector Hole for Chamfer		8/16/90	KS
	D) Oil Firing Pin Ass'y		8/16/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/90	DM

BARBER - M24 0005655

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/13/90	JL
	G) Safety Off Force	2	2	2			8/13/90	JL
	H) Trigger Pull Test & Retainability						8/17/90	JL
	I) Firing Pin Indent	.0225	.0225	.0225			8/13/90	JL
	J) Assemble Stock						8/17/90	KS
	K) Assemble Swivel Studs						8/29/90	JS
	L) Attach Front and Rear Sight Assemblies						8/17/90	KS
	M) Iron Sight Alignment						8/17/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/17/90	KS
	O) Attach Scope to Rifle						8/17/90	KS
	P) Detach & Attach Scope 20 Times						8/17/90	KS
640	Gallery Target & Test						8-20-90	A
	A) Time						8-20-90	A
	B) Malfunctions						8-20-90	A
	C) Pierced Primers						8-20-90	A
	D) Optical Clarity of Scope						8-20-90	A
645	Inspect for Live Ammo						8-20-90	A
655	Final Inspection						8/29/90	JS
	A) Headspace						8/22/90	JL
	B) Trigger Pull	2.21	2.17	2.17	2.19	2.15	8/22/90	JL
	C) Function						8/29/90	JS
660	Pack						1/20/90	AF