

C6498819

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498819

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	R.B.
617	Drill and Tap Sight Holes		7/13/90	RB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TA
	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		8/18/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			8/10/90	JM
	G) Safety Off Force	2	2	2			8/10/90	JM
	H) Trigger Pull Test & Retainability						8/18/90	JM
	I) Firing Pin Indent	.225	.022	.0225			8/10/90	JM
	J) Assemble Stock						8/21/90	RW
	K) Assemble Swivel Studs						8/21/90	RW
	L) Attach Front and Rear Sight Assemblies						8/21/90	RW
	M) Iron Sight Alignment						8/21/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/90	RW
	O) Attach Scope to Rifle						8/21/90	RW
	P) Detach & Attach Scope 20 Times						8/21/90	RW
640	Gallery Target & Test						8/21/90	NF
	A) Time						8/21/90	NF
	B) Malfunctions						8/21/90	NF
	C) Pierced Primers						8/21/90	NF
	D) Optical Clarity of Scope						8/21/90	NF
645	Inspect for Live Ammo						8/21/90	NF
655	Final Inspection						8/29/90	JM
	A) Headspace						8/22/90	JM
	B) Trigger Pull	2.42	2.42	2.40	2.40	2.20	8/22/90	JM
	C) Function						8/29/90	JM
660	Pack						9/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C64988/19

DATE 8/18/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.34	2.35	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.35	2.27	2.42	
PULL #3	2.38	2.38	2.35	2.40	
PULL #4	2.34	2.35	2.33	2.40	
PULL #5	2.27	2.35	2.39	2.20	
TOTAL	11.80	11.77	11.69	11.84	
AVG.	2.36	2.354	2.338	2.368	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.31		
PULL #2	3.31	3.34		
PULL #3	3.34	3.32		
PULL #4	3.36	3.36		
PULL #5	3.33	3.30		
TOTAL	16.65	16.63		
AVG.	3.33	3.326		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.41		4.31
PULL #2	4.41	4.38		4.30
PULL #3	4.28	4.29		4.40
PULL #4	4.44	4.35		4.34
PULL #5	4.38	4.37		4.32
TOTAL	21.82	21.80		21.67
AVG.	4.364	4.36		4.334

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498819
22 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.707764
1 TO	2	.645776
1 TO	3	.83764
1 TO	4	.386167
1 TO	5	.535239

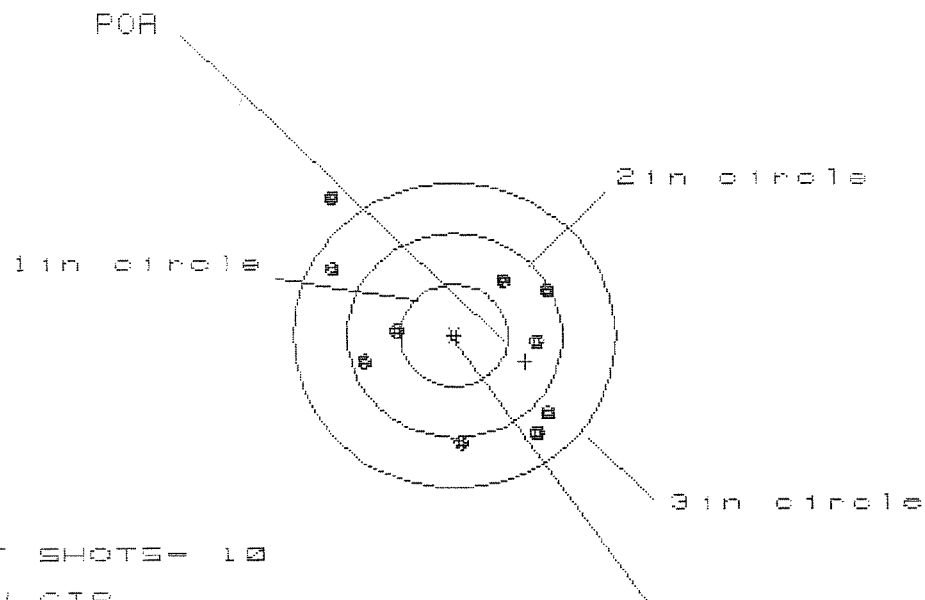
1 5
4 300 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.306
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0234
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .306893
THE AMR FOR THIS RIFLE IS: 1.029

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498819

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.040

VS = 2.416

GS = 3.046

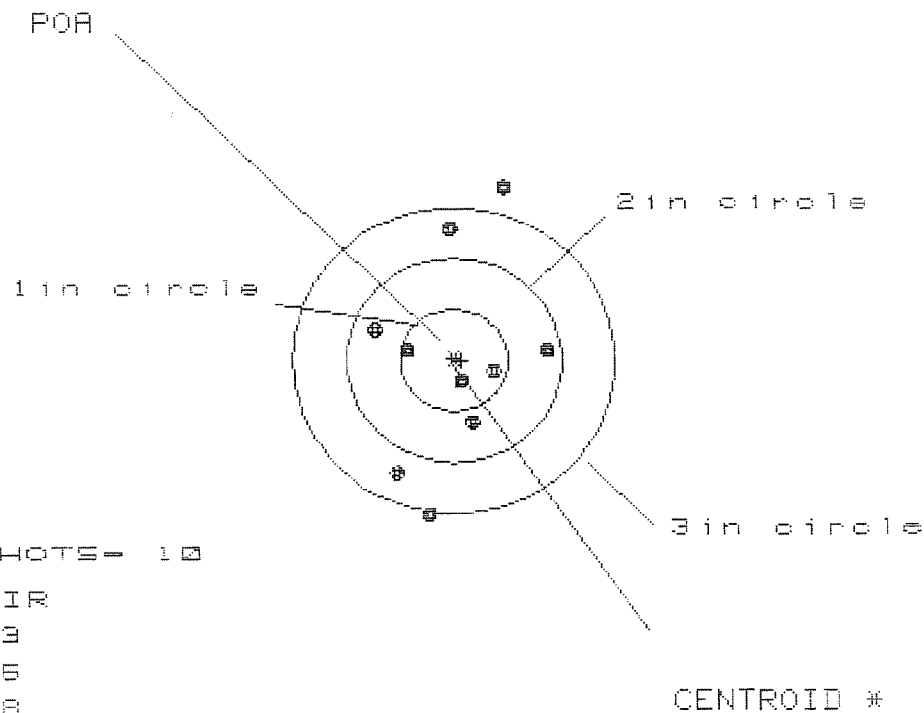
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.873	.744	.582
MINIMUM X	-1.167	-1.296	-1.159
MAXIMUM Y	1.381	.795	.754
MINIMUM Y	-1.035	-.881	-.782
CENTROID X	-.661	-.532	-.370
CENTROID Y	.253	.099	.000
POA TO CENTROID in.	.708	.541	.370
MIN RADIUS	.571	.679	.547
MEAN RADIUS	1.045	.939	.838
MAX RADIUS	1.803	1.520	1.159
HORIZONTAL SPREAD	2.040	2.040	1.741
VERTICAL SPREAD	2.416	1.676	1.536
EXTREME SPREAD	3.046	2.519	1.892
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.604

VS= 3.243

GS= 3.332

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.885	.940	.914
MINIMUM X	-.719	-.664	-.690
MAXIMUM Y	1.727	1.452	1.286
MINIMUM Y	-1.516	-1.324	-1.060
CENTROID X	-.066	-.121	-.095
CENTROID Y	.002	-.190	-.024
POR TO CENTROID in.	.066	.225	.098
MIN RADIUS	.189	.089	.172
MEAN RADIUS	.916	.793	.725
MAX RADIUS	1.797	1.453	1.286
HORIZONTAL SPREAD	1.604	1.604	1.604
VERTICAL SPREAD	3.243	2.776	2.346
EXTREME SPREAD	3.332	2.789	2.401
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.833

VS= 2.070

GS= 2.265

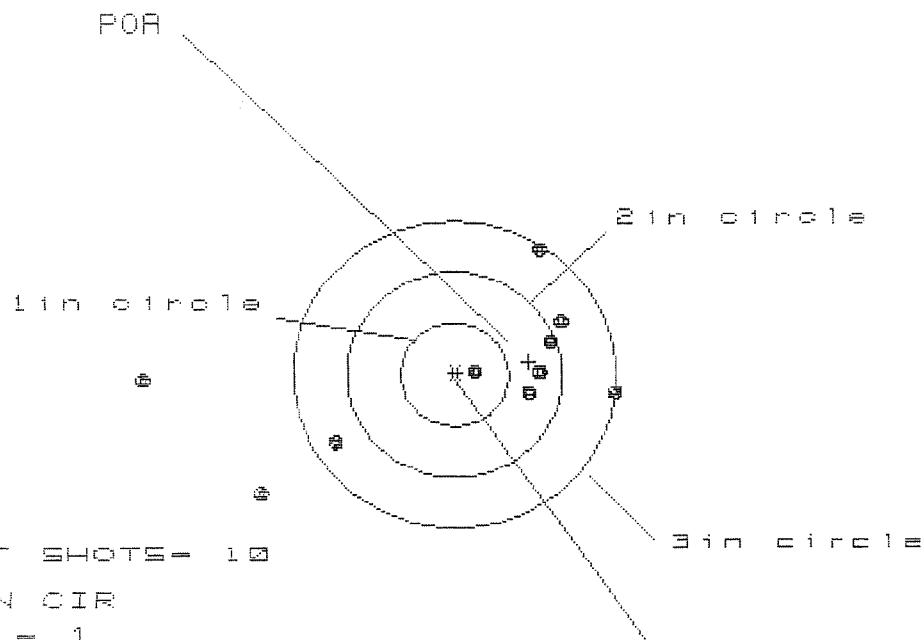
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.899	.986	.990
MINIMUM X	-.934	-.847	-.843
MAXIMUM Y	.974	.790	.667
MINIMUM Y	-1.096	-.988	-.716
CENTROID X	.014	-.073	-.077
CENTROID Y	-.243	-.351	-.228
POA TO CENTROID in.	.243	.359	.240
MIN RADIUS	.212	.274	.153
MEAN RADIUS	.795	.735	.682
MAX RADIUS	1.253	1.059	1.024
HORIZONTAL SPREAD	1.833	1.833	1.833
VERTICAL SPREAD	2.070	1.778	1.383
EXTREME SPREAD	2.265	1.904	1.904
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4

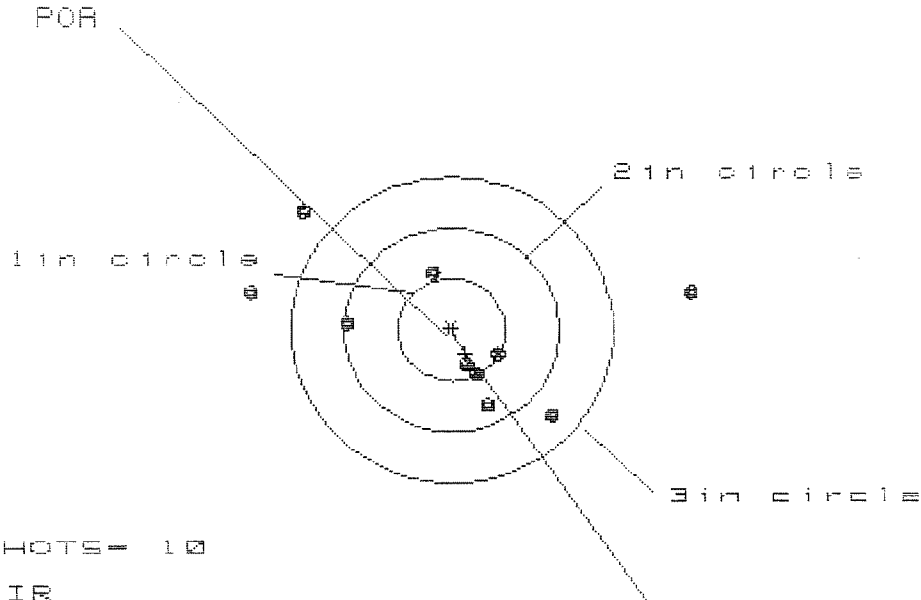


PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.465
MINIMUM X	-2.904
MAXIMUM Y	1.265
MINIMUM Y	-1.152
CENTROID X	-.691
CENTROID Y	-.132
POR TO CENTROID in.	.703
MIN RADIUS	.209
MEAN RADIUS	1.302
MAX RADIUS	2.907
HORIZONTAL SPREAD	4.369
VERTICAL SPREAD	2.417
EXTREME SPREAD	4.370
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 7

HS = 4.130

VS = 2.033

GS = 4.130

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.261	1.224	1.022
MINIMUM X	:	-1.869	-1.618	-1.277
MAXIMUM Y	:	1.167	1.204	1.256
MINIMUM Y	:	-.866	-.829	-.777
CENTROID X	:	-.126	-.377	-.175
CENTROID Y	:	.237	.200	.148
POA TO CENTROID in.	:	.269	.427	.229
MIN RADIUS	:	.350	.458	.286
MEAN RADIUS	:	1.088	.970	.822
MAX RADIUS	:	2.286	1.671	1.791
HORIZONTAL SPREAD	:	4.130	2.842	2.299
VERTICAL SPREAD	:	2.033	2.033	2.033
EXTREME SPREAD	:	4.130	3.104	3.069
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

Remington



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

MODEL 700TM M24

SERIAL NO.
C6498819

ORDER NO.
5716

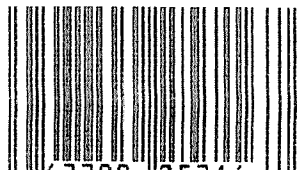
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5716 C6498819

UPC



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BARBER - M24 0008346

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0008346008385