

C6594583

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Civilian

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

MODEL 700™ H24

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

SERIAL NO.
C6594583

ORDER NO.
5716

20


5716 C6594583

UPC


0 47700 25716 7

MOD. _____		GA. CAL. _____	GUN # <u>458.3</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
	<u>2/26</u>	<u>5th Rd. Loads</u> <u>Handled</u>	<u>KS</u>
	2nd		
		<u>Rep'd</u>	<u>KS</u>
	3rd		
	4th		

FUNCTION

RD 6654

Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594583

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/27/90	K.S.
600	Proof		12/27/90	K.S.
607	Check Headspace		12/27/90	K.S.
610	Dis-assemble Gun		12/27/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/22/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/22/91	KA
	C) Inspect Ejector Hole for Chamfer		2/22/91	KA
	D) Oil Firing Pin Ass'y		2/22/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2-25-91	PH

BARBER - M24 0019716

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5 1/4			2-25-91	DH
	G) Safety Off Force	4	3	3			2-25-91	DH
	H) Trigger Pull Test & Retainability						2-25-91	DH
	I) Firing Pin Indent	.020	.020	.021			2-25-91	DH
	J) Assemble Stock						2/25/91	KH
	K) Assemble Swivel Studs						2/26/91	KH
	L) Attach Front and Rear Sight Assemblies						2/26/91	KH
	M) Iron Sight Alignment						2/26/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/26/91	KH
	O) Attach Scope to Rifle						2/25/91	KH
	P) Detach & Attach Scope 20 Times						2/25/91	KH
640	Gallery Target & Test						2-26-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-26-91	NF
655	Final Inspection						2-28-91	KH
	A) Headspace						2-28-91	KH
	B) Trigger Pull	2.26	2.46	2.48	2.46	2.49	2/27/91	JH
	C) Function						2-28-91	KH
660	Pack						3-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594583

DATE 2-25-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.40	2.67	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.43	2.71	2.46	
PULL #3	2.52	2.48	2.73	2.48	
PULL #4	2.41	2.43	2.70	2.46	
PULL #5	2.55	2.42	2.70	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.34		
PULL #2	3.37	3.39		
PULL #3	3.40	3.39		
PULL #4	3.34	3.38		
PULL #5	3.17	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.51		4.11
PULL #2	4.54	4.58		4.15
PULL #3	4.56	4.59		4.14
PULL #4	4.55	4.62		4.18
PULL #5	4.57	4.62		4.14
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594583
27 Feb 1991

CENTROIDAL DISTANCES

Ø TO	1	.218358
1 TO	2	.223063
1 TO	3	.364968
1 TO	4	.141152
1 TO	5	.0170294

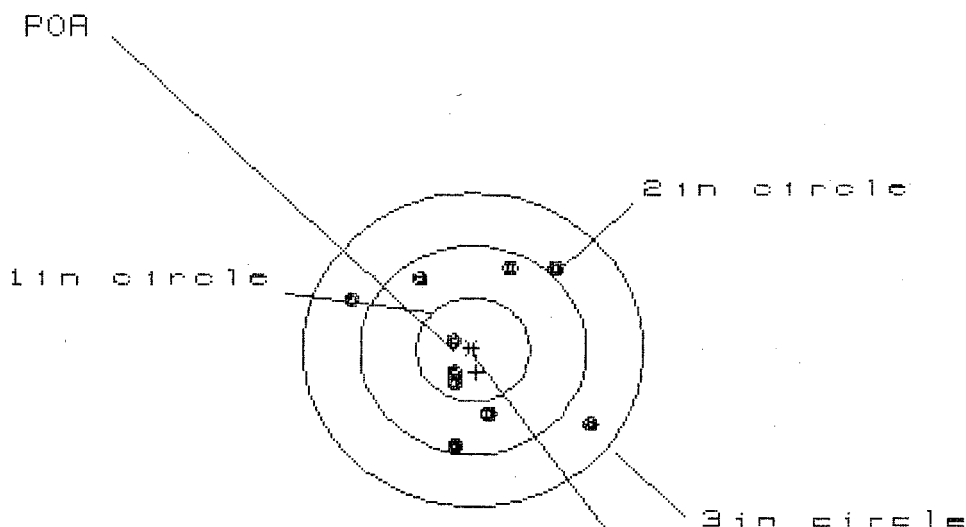
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0292
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104368
THE AMR FOR THIS RIFLE IS: .8538

27 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594583

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIRC

1 in = 3

2 in = 7

3 in = 10

HS = 2.141

VS = 1.748

GS = 2.451

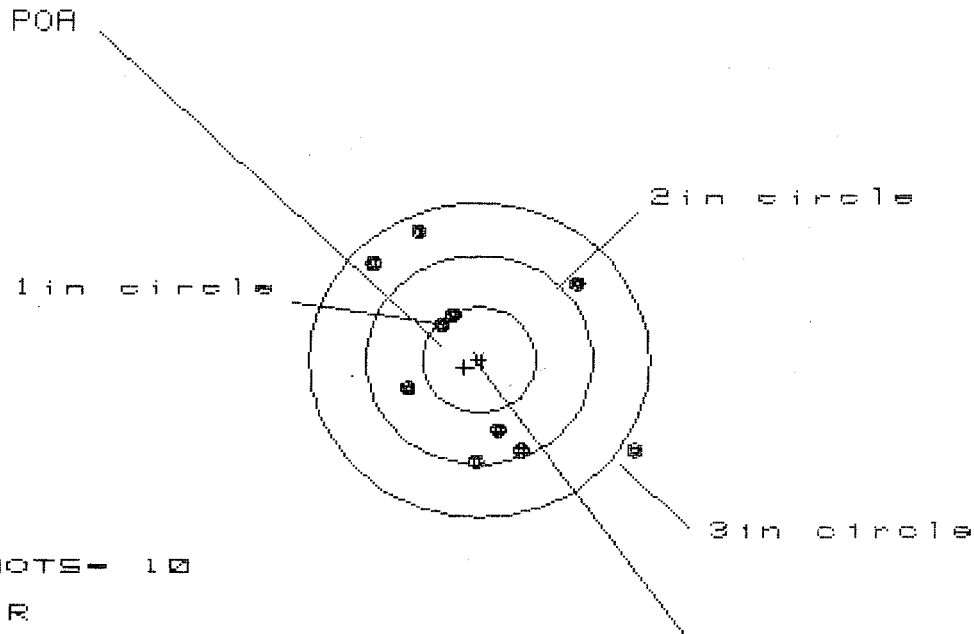
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.036	.856	.732
MINIMUM X	-1.105	-.990	-.464
MAXIMUM Y	.806	.726	.775
MINIMUM Y	-.942	-1.022	-.973
CENTROID X	-.032	-.147	-.023
CENTROID Y	.216	.296	.247
POA TO CENTROID in.	.219	.331	.248
MIN RADIUS	.186	.047	.180
MEAN RADIUS	.766	.694	.654
MAX RADIUS	1.261	1.099	1.040
HORIZONTAL SPREAD	2.141	1.846	1.196
VERTICAL SPREAD	1.748	1.748	1.748
EXTREME SPREAD	2.451	1.943	1.943
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 3

CENTROID *

HS= 2.266

VS= 2.144

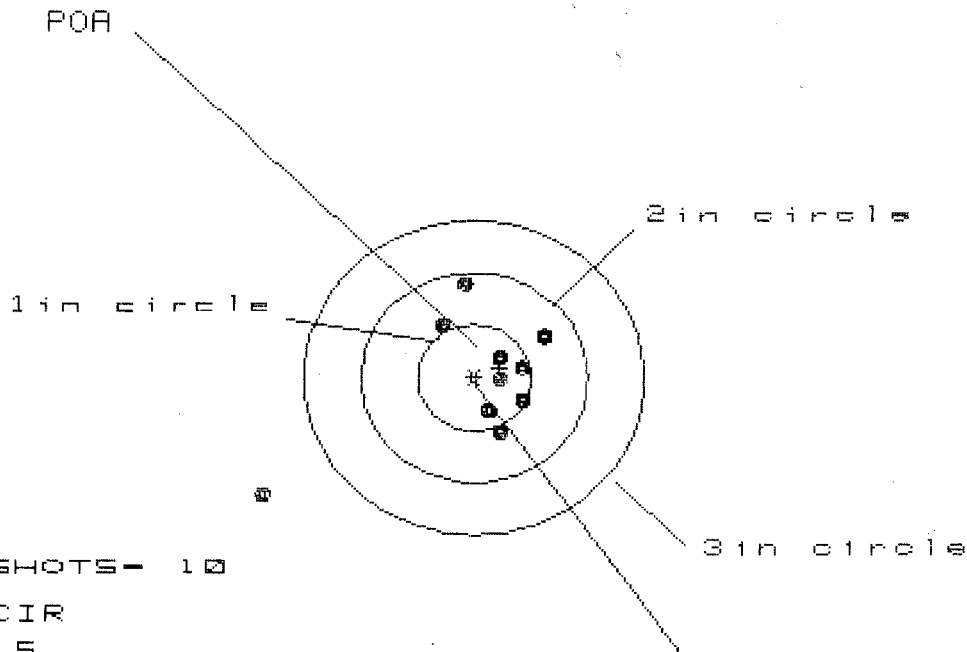
GS= 2.869

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.316	1.042	.942
MINIMUM X	:	-.950	-.804	-.623
MAXIMUM Y	:	1.190	1.096	1.198
MINIMUM Y	:	-.954	-1.048	-.946
CENTROID X	:	.134	-.012	.088
CENTROID Y	:	.067	.161	.059
POA TO CENTROID in.	:	.150	.162	.106
MIN RADIUS	:	.459	.288	.431
MEAN RADIUS	:	.970	.874	.846
MAX RADIUS	:	1.566	1.234	1.304
HORIZONTAL SPREAD	:	2.266	1.846	1.565
VERTICAL SPREAD	:	2.144	2.144	2.144
EXTREME SPREAD	:	2.869	2.260	2.260
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 9

3 in = 9

HS= 2.509

VS= 2.002

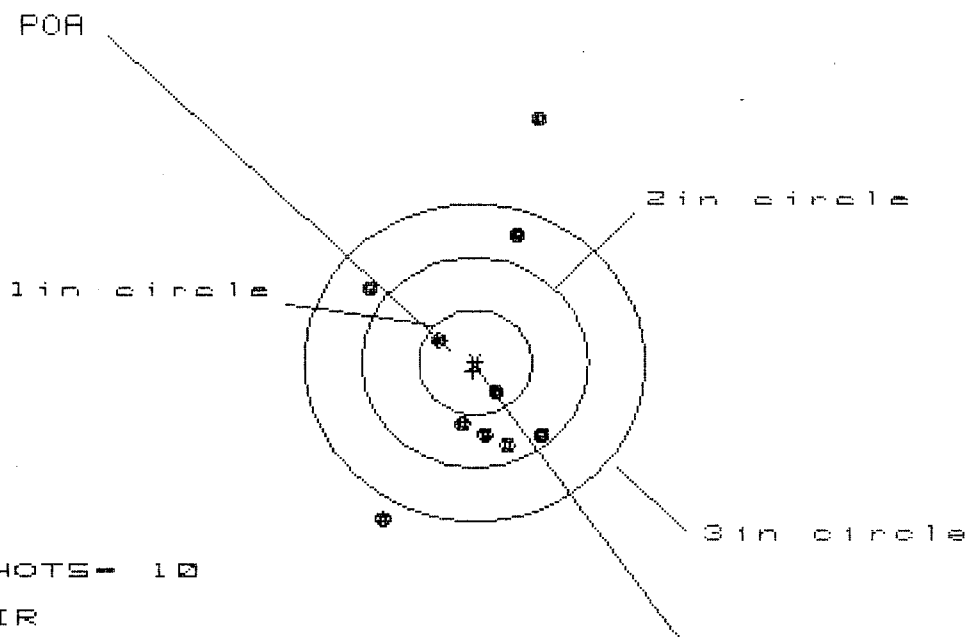
GS= 2.881

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.614	.404	.364
MINIMUM X	:	-1.095	-.523	-.563
MAXIMUM Y	:	.932	.813	.474
MINIMUM Y	:	-1.070	-.596	-.494
CENTROID X	:	-.223	-.013	.027
CENTROID Y	:	-.095	.024	-.078
POA TO CENTROID in.	:	.243	.027	.083
MIN RADIUS	:	.268	.119	.042
MEAN RADIUS	:	.678	.431	.351
MAX RADIUS	:	2.176	.872	.736
HORIZONTAL SPREAD	:	2.509	.927	.927
VERTICAL SPREAD	:	2.002	1.409	.968
EXTREME SPREAD	:	2.881	1.450	1.114
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.503

VS= 3.799

GS= 4.046

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.609	.625	.536
MINIMUM X	:	-.894	-.827	-.916
MAXIMUM Y	:	2.296	1.520	1.364
MINIMUM Y	:	-1.503	-1.248	-.678
CENTROID X	:	.018	-.049	.040
CENTROID Y	:	.084	-.171	-.015
POA TO CENTROID in.	:	.086	.178	.043
MIN RADIUS	:	.351	.289	.264
MEAN RADIUS	:	1.032	.817	.754
MAX RADIUS	:	2.375	1.586	1.411
HORIZONTAL SPREAD	:	1.503	1.452	1.452
VERTICAL SPREAD	:	3.799	2.768	2.042
EXTREME SPREAD	:	4.046	3.004	2.044
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.760

VS= 2.573

GS= 2.600

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.836	.765	.724
MINIMUM X	:	-.924	-.995	-1.036
MAXIMUM Y	:	1.438	1.157	1.035
MINIMUM Y	:	-1.135	-.975	-.903
CENTROID X	:	-.043	.028	.069
CENTROID Y	:	.229	.069	.191
POA TO CENTROID in.	:	.233	.075	.203
MIN RADIUS	:	.283	.357	.231
MEAN RADIUS	:	.823	.723	.661
MAX RADIUS	:	1.572	1.160	1.042
HORIZONTAL SPREAD	:	1.760	1.760	1.760
VERTICAL SPREAD	:	2.573	2.132	1.938
EXTREME SPREAD	:	2.600	2.146	1.939
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	