

06594593

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

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

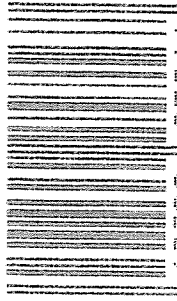
DUPONT
REGISTERED TRADE MARK OFF

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

SERIAL NO.
C6594593

ORDER NO.
5716

UPC



0 4700 25716 7



5716 C6594593

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594593

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		1/9/90	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	JS
617	Drill and Tap Sight Holes	1 10 91		EB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	KA
	C) Inspect Ejector Hole for Chamfer		1/28/91	KA
	D) Oil Firing Pin Ass'y		1/28/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		1/29/91	JA

op. #	BARBER - M24 0019975 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1/29/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			1/29/91	WB
	H) Trigger Pull Test & Retainability						1/29/91	WB
	I) Firing Pin Indent	.0205	.0205	.0205			1/29/91	WB
	J) Assemble Stock						1/29/91	KS
	K) Assemble Swivel Studs						2-21-91	KS
	L) Attach Front and Rear Sight Assemblies						1/29/91	KS
	M) Iron Sight Alignment						1/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/29/91	KS
	O) Attach Scope to Rifle						1/29/91	KS
	P) Detach & Attach Scope 20 Times						1/29/91	KS
640	Gallery Target & Test						2-5-91	DH
	A) Time						2-5-91	DH
	B) Malfunctions						2-5-91	DH
	C) Pierced Primers						2-5-91	DH
	D) Optical Clarity of Scope						2-5-91	DH
645	Inspect for Live Ammo						2-5-91	DH
655	Final Inspection							
	A) Headspace						2-21-91	KS
	B) Trigger Pull	2.78	2.78	2.78	2.73	2.80	2/18/91	WB
	C) Function						2-21-91	KS
660	Pack						3-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594593

DATE 1/29/91

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.26	2.33	2.78	MIN. SETTING,
PULL #2	2.32	2.32	2.46	2.78	NO AVG. OF 5
PULL #3	2.33	2.33	2.50	2.78	READINGS ACCEPT-
PULL #4	2.31	2.38	2.54	2.73	ABLE LESS THAN 2#
PULL #5	2.32	2.34	2.46	2.80	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.38		
PULL #2	3.49	3.43		
PULL #3	3.50	3.48		
PULL #4	3.51	3.47		
PULL #5	3.48	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.41		4.39
PULL #2	4.50	4.21		4.28
PULL #3	4.37	4.42		4.34
PULL #4	4.37	4.40		4.22
PULL #5	4.45	4.41		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594593
6 Feb 1991

Gov't

CENTROIDAL DISTANCES

0 TO	1	.56456
1 TO	2	.640013
1 TO	3	.232142
1 TO	4	.331941
1 TO	5	.740198

1
3
25

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0802
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1692
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .187245

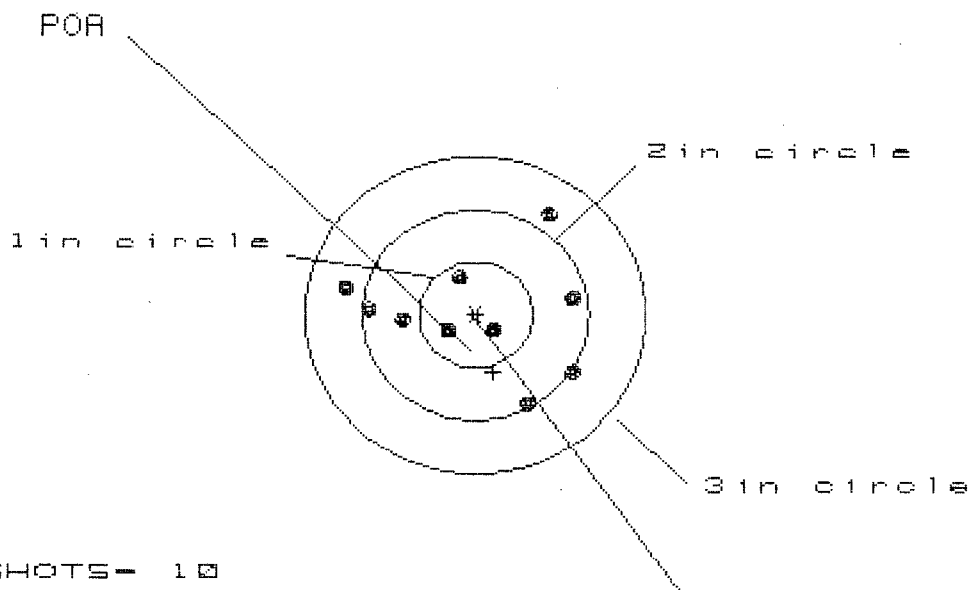
THE AMR FOR THIS RIFLE IS: .7824

Gov't

5 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594593

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.059

VS= 1.847

GS= 2.234

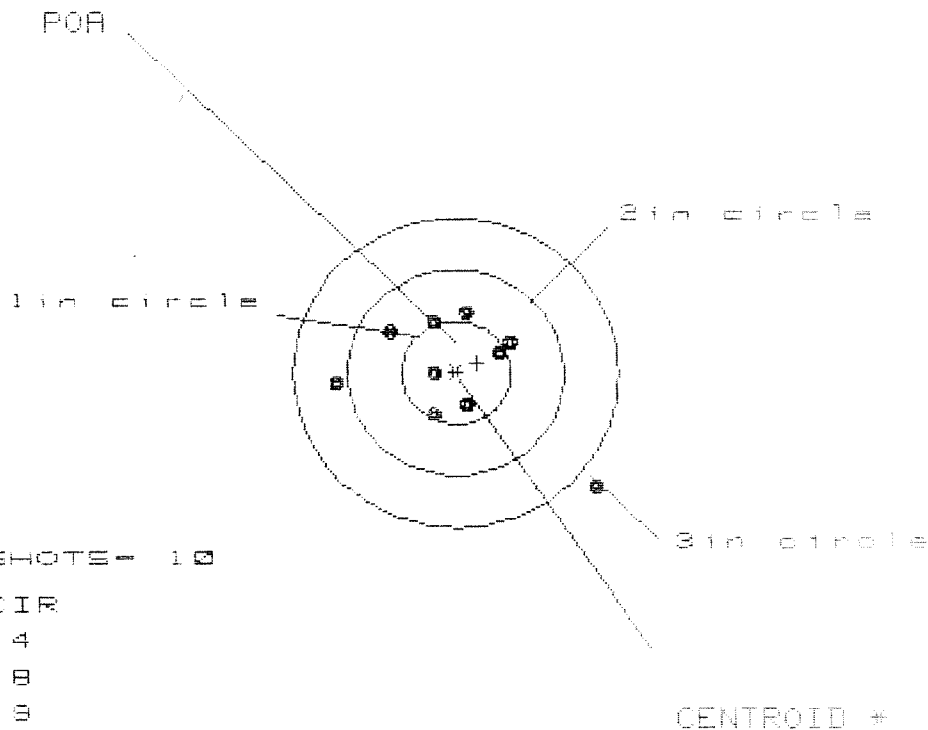
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.899	.770	.835
MINIMUM X	-1.161	-1.043	-.978
MAXIMUM Y	.965	.996	.475
MINIMUM Y	-.882	-.851	-.726
CENTROID X	-.158	-.029	-.094
CENTROID Y	.542	.511	.386
POA TO CENTROID in.	.564	.511	.397
MIN RADIUS	.243	.136	.123
MEAN RADIUS	.771	.722	.657
MAX RADIUS	1.194	1.126	1.008
HORIZONTAL SPREAD	2.059	1.813	1.813
VERTICAL SPREAD	1.847	1.847	1.201
EXTREME SPREAD	2.234	1.933	1.933
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

5 Feb 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS = 3.441

VS = 1.789

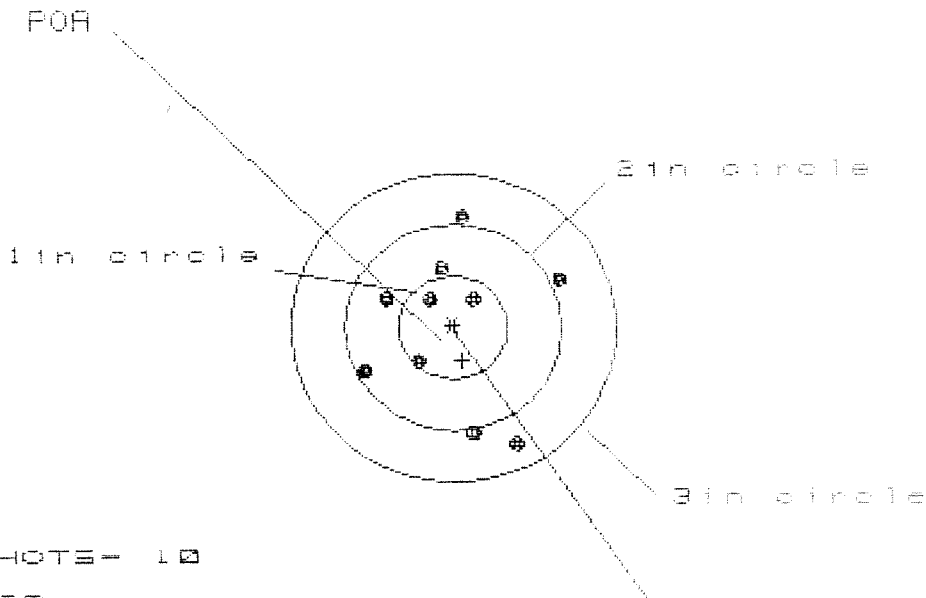
GS = 2.662

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	.636	.511
MINIMUM X	:	-1.140	-.995	-.572
MAXIMUM Y	:	.643	.516	.490
MINIMUM Y	:	-1.146	-.536	-.563
CENTROID X	:	-.194	-.339	-.214
CENTROID Y	:	-.097	.030	.056
POA TO CENTROID in.	:	.217	.340	.222
MIN RADIUS	:	.281	.177	.263
MEAN RADIUS	:	.679	.545	.473
MAX RADIUS	:	1.734	1.013	.604
HORIZONTAL SPREAD	:	2.441	1.631	1.083
VERTICAL SPREAD	:	1.789	1.052	1.052
EXTREME SPREAD	:	2.662	1.685	1.101
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Feb 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 1.779

VS= 2.173

GS= 2.226

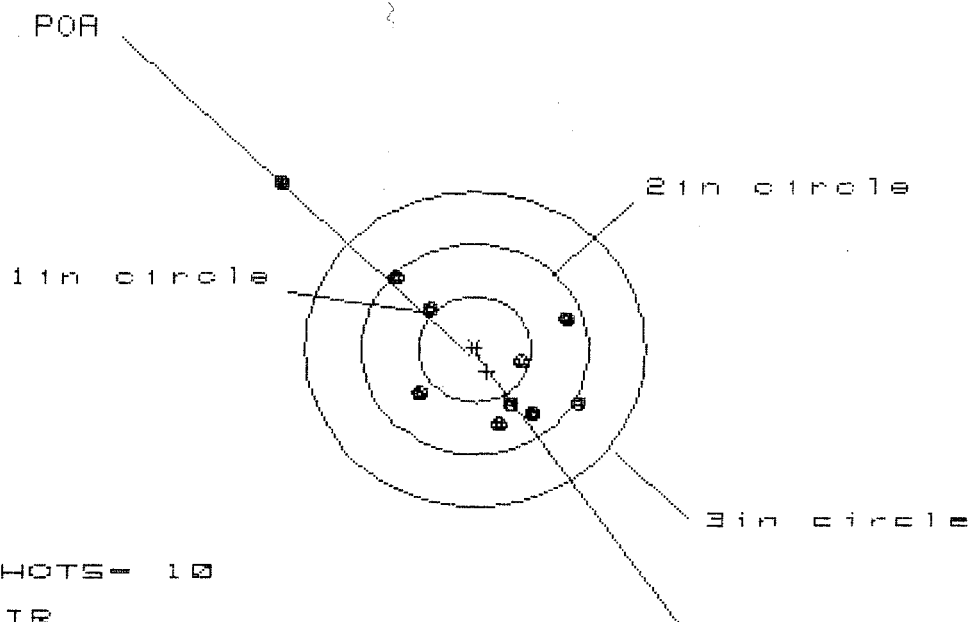
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	1.071	.428
MINIMUM X	:	-.776	-.708	-.574
MAXIMUM Y	:	1.042	.916	.954
MINIMUM Y	:	-1.131	-1.108	-1.070
CENTROID X	:	-.081	-.149	-.283
CENTROID Y	:	.323	.449	.411
POB TO CENTROID in.	:	.333	.473	.498
MIN RADIUS	:	.320	.224	.193
MEAN RADIUS	:	.781	.691	.625
MAX RADIUS	:	1.285	1.146	1.152
HORIZONTAL SPREAD	:	1.779	1.779	1.002
VERTICAL SPREAD	:	2.173	2.024	2.024
EXTREME SPREAD	:	2.226	2.026	2.026
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Feb 1981

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 2.612

VS= 2.333

GS= 3.355

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.929	.742	.699
MINIMUM X	:	-1.683	-.877	-.785
MAXIMUM Y	:	1.570	.893	.848
MINIMUM Y	:	-.763	-.588	-.633
CENTROID X	:	-.107	.080	-.013
CENTROID Y	:	.214	.039	.084
POA TO CENTROID in.	:	.239	.089	.085
MIN RADIUS	:	.376	.213	.283
MEAN RADIUS	:	.895	.668	.662
MAX RADIUS	:	2.302	1.252	1.155
HORIZONTAL SPREAD	:	2.612	1.619	1.483
VERTICAL SPREAD	:	2.333	1.481	1.481
EXTREME SPREAD	:	3.355	2.047	1.828
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Feb 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 2.406

VS = 1.404

GS = 2.410

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.270	1.029	.904
MINIMUM X	:	-1.136	-.995	-.925
MAXIMUM Y	:	.821	.875	.925
MINIMUM Y	:	-.583	-.529	-.479
CENTROID X	:	.139	-.002	.123
CENTROID Y	:	-.136	-.190	-.240
POA TO CENTROID in.	:	.195	.190	.269
MIN RADIUS	:	.242	.393	.307
MEAN RADIUS	:	.786	.731	.661
MAX RADIUS	:	1.360	1.071	.947
HORIZONTAL SPREAD	:	2.406	2.024	1.829
VERTICAL SPREAD	:	1.404	1.404	1.404
EXTREME SPREAD	:	2.410	2.075	1.839
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	