C6587580

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

MOD. ______ GA. CAL. ______ GUN # C6587580

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Mag. box will not hold 5 Rds +	KS
	2nd	Safe binds	
	3rd	Repaired KS.	11/30/90
	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		

Remington® DU PONT REG U.S. PAT & TM OFF

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

MODEL 700™ M24

SERIAL NO. C6587580

ORDER NO. 5716

01

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

5716 C6587580

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL # C6587580

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	DJS
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-20-90	[illegible]
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/90	WB
	C) Inspect Ejector Hole for Chamfer		11/27/90	WB
	D) Oil Firing Pin Ass'y		11/27/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		11/28/90	[illegible]

Op. #	Op. Name	Readings					Date	Init
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			11/28/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/28/90	WB
	H) Trigger Pull Test & Retainability						11/28/90	[illegible]
	I) Firing Pin Indent	.021	.022	.022			11/28/90	WB
	J) Assemble Stock						11/28/90	KS
	K) Assemble Swivel Studs						12-1-90	[illegible]
	L) Attach Front and Rear Sight Assemblies						11/28/90	KS
	M) Iron Sight Alignment						11/28/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/28/90	KS
	O) Attach Scope to Rifle						11/28/90	KS
	P) Detach & Attach Scope 20 Times						11/28/90	KS
640	Gallery Target & Test						11-29-90	[illegible]
	A) Time						"	[illegible]
	B) Malfunctions						"	[illegible]
	C) Pierced Primers						"	[illegible]
	D) Optical Clearity of Scope						"	[illegible]
645	Inspect for Live Ammo						11-29-90	AC
655	Final Inspection A) Headspace						12-1-90	[illegible]
	B) Trigger Pull	2.15	214	207	210	238	12-1-90	[illegible]
	C) Function						12-1-90	[illegible]
660	Pack						12/18/90	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6587580
DATE 11-28-90
TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.23	2.20	2.15	MIN. SETTING,
PULL #2	2.38	2.16	2.21	2.14	NO AVG. OF 5
PULL #3	2.35	2.16	2.22	2.07	READINGS ACCEPT-
PULL #4	2.21	2.17	2.25	2.10	ABLE LESS THAN 2#
PULL #5	2.23	2.28	2.24	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.41		
PULL #2	3.19	3.33		
PULL #3	3.20	3.42		
PULL #4	3.17	3.45		
PULL #5	3.33	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.48		4.45
PULL #2	4.41	4.47		4.47
PULL #3	4.46	4.46		4.16
PULL #4	4.24	4.30		4.39
PULL #5	4.45	4.45		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587580
29 Nov 1990

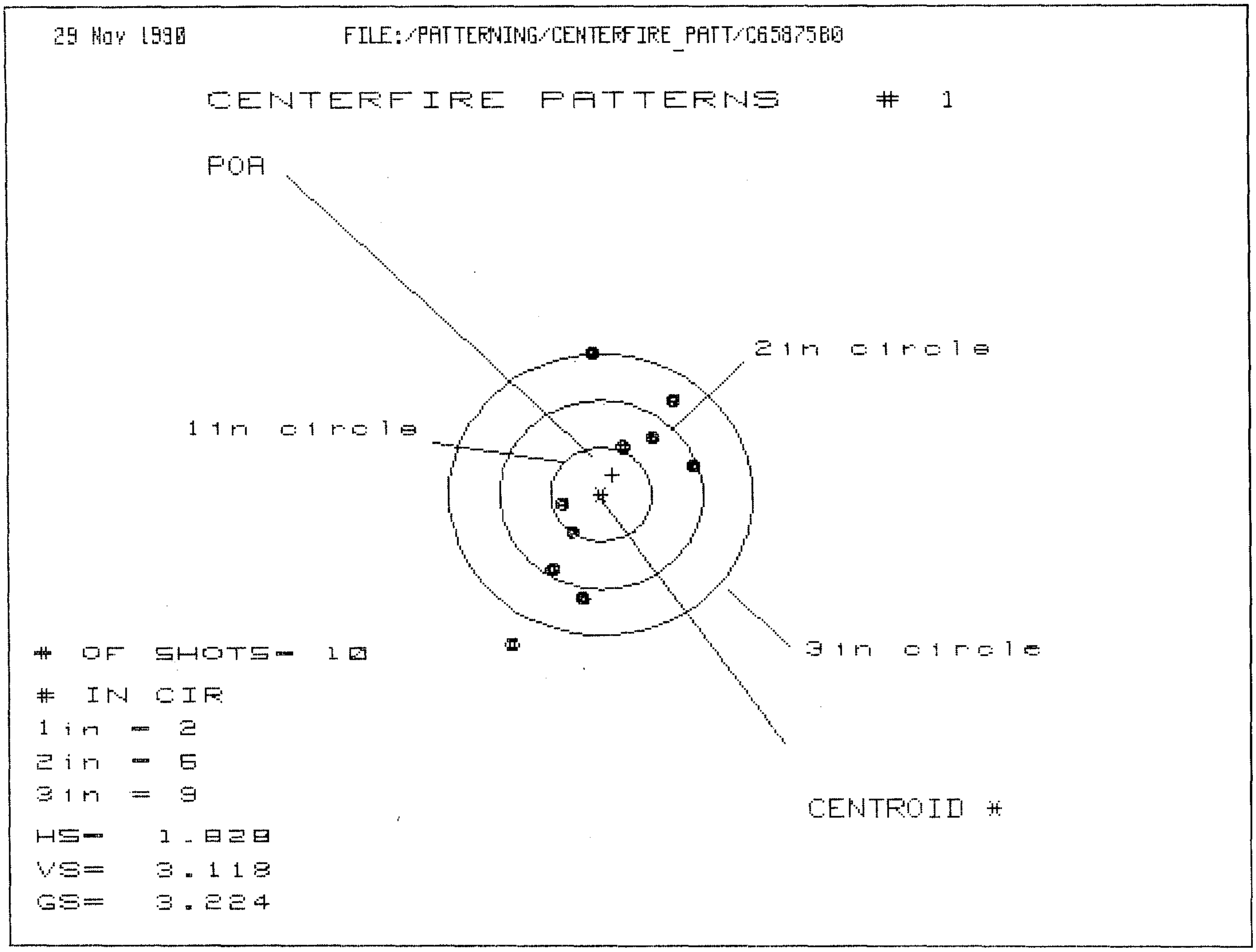
CENTROIDAL DISTANCES

0	TO	1	.2336
1	TO	2	.153209
1	TO	3	.586008
1	TO	4	.481453
1	TO	5	.49823

4 1 3 2 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .153
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.092
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .17853

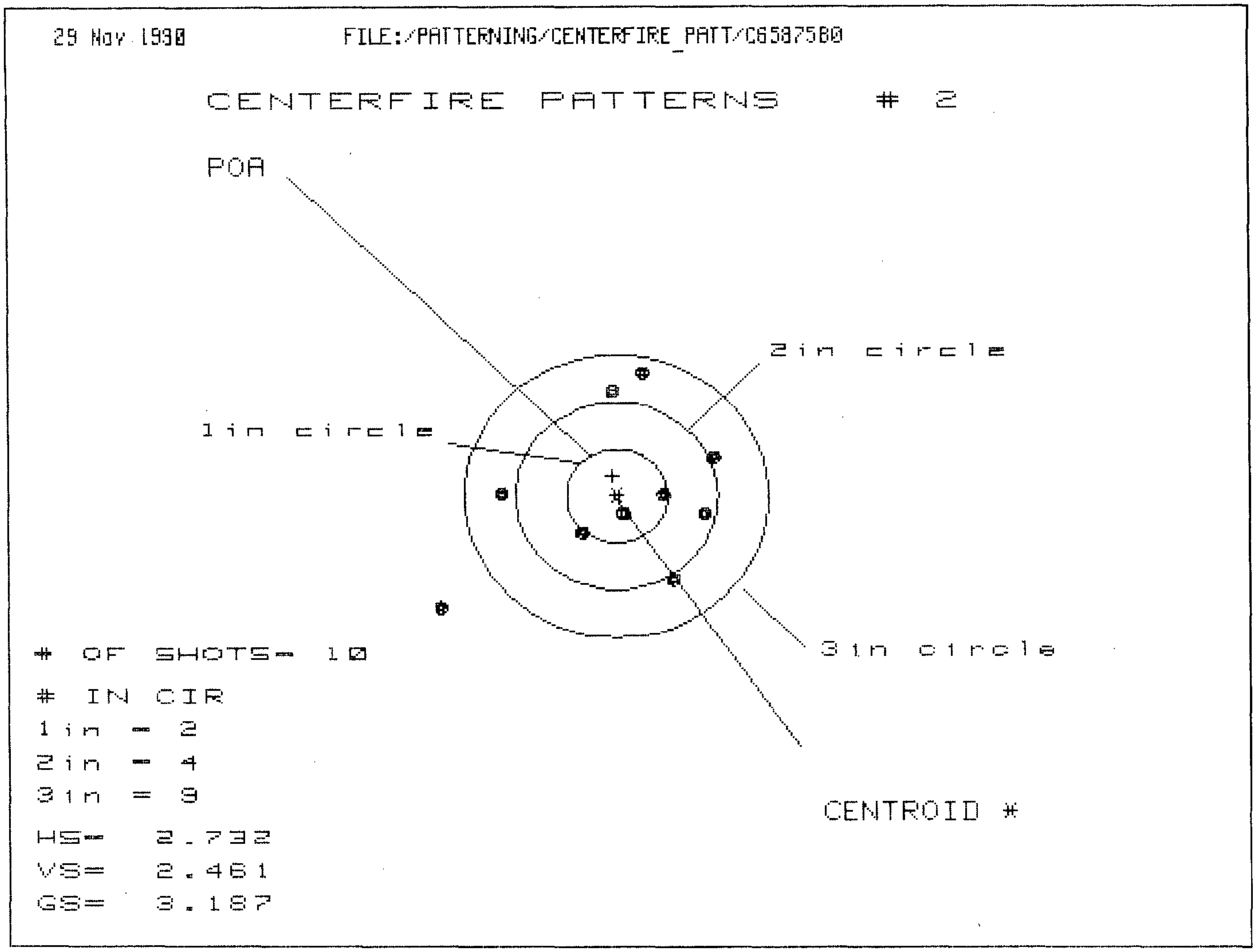
THE AMR FOR THIS RIFLE IS: .9752



PATTERN # : **1**

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.940	.842	.821
MINIMUM X	:	-.888	-.625	-.646
MAXIMUM Y	:	1.497	1.317	1.034
MINIMUM Y	:	-1.621	-1.247	-1.083
CENTROID X	:	-.112	-.014	.007
CENTROID Y	:	-.205	-.025	-.190
POA TO CENTROID in.	:	.234	.028	.190
MIN RADIUS	:	.380	.368	.499
MEAN RADIUS	:	.986	.874	.815
MAX RADIUS	:	1.848	1.327	1.176
HORIZONTAL SPREAD	:	1.828	1.467	1.467
VERTICAL SPREAD	:	3.118	2.564	2.116
EXTREME SPREAD	:	3.224	2.568	2.295

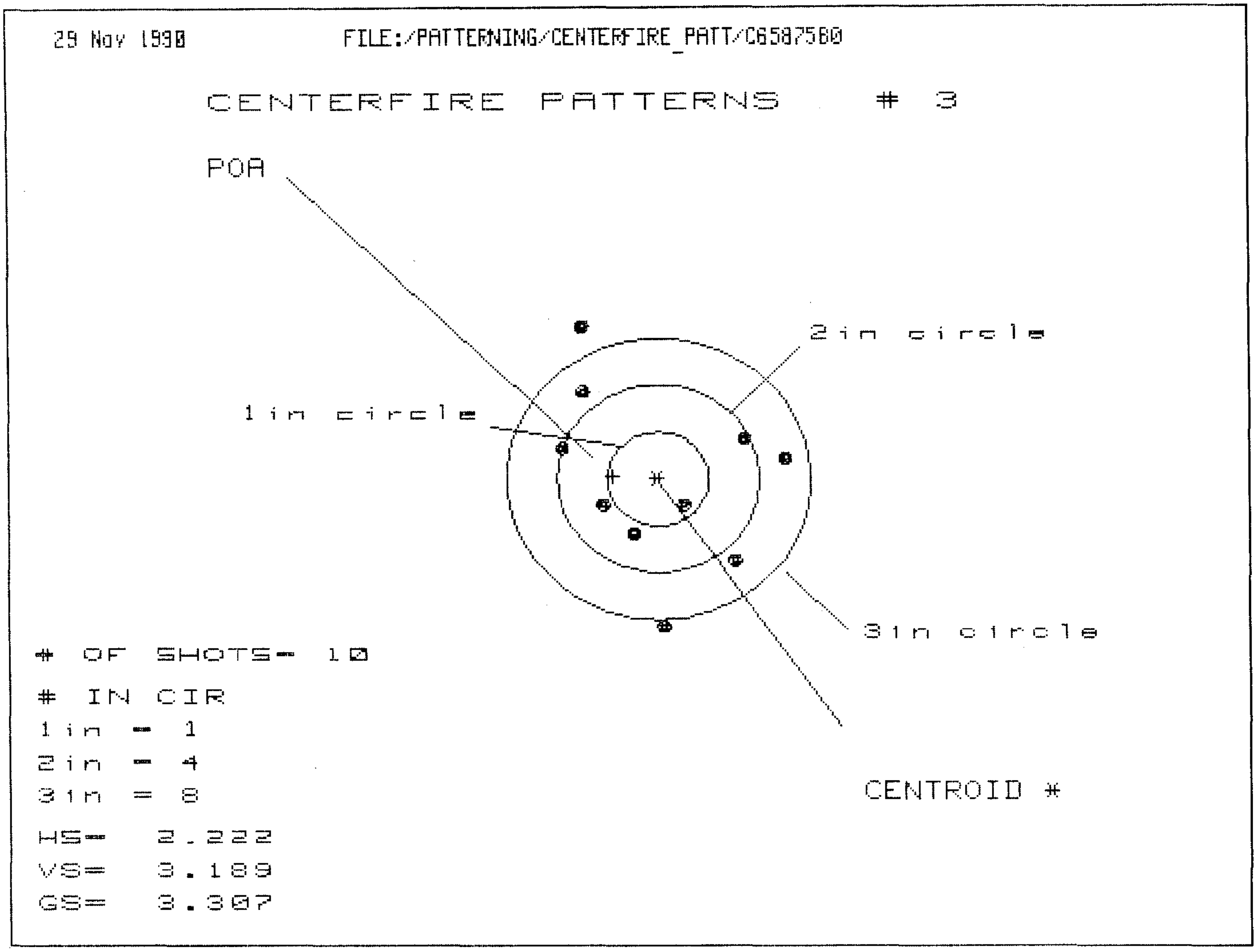
NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9



PATTERN # : 2

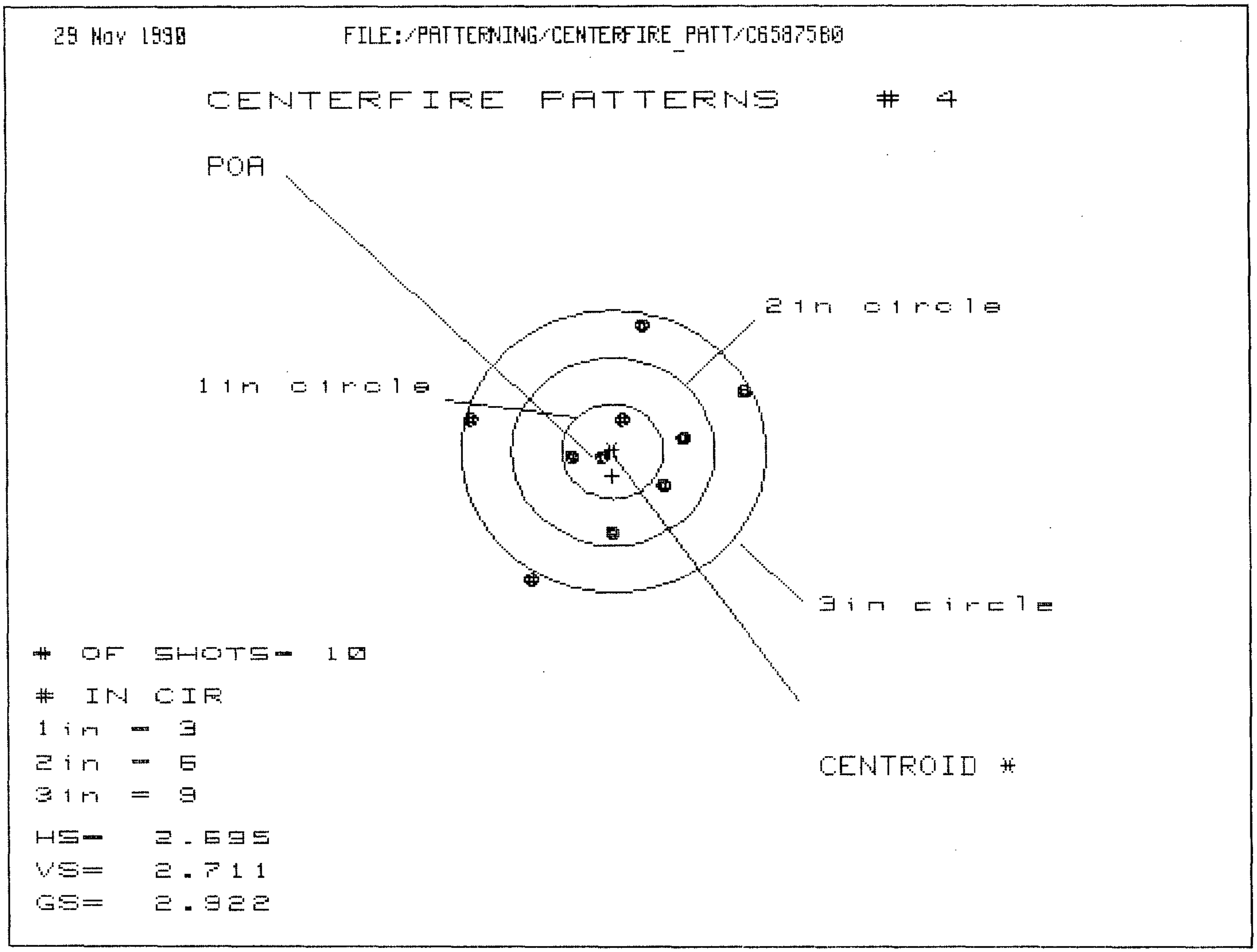
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.008	.816	.826
MINIMUM X	:	-1.724	-1.355	-1.345
MAXIMUM Y	:	1.271	1.139	1.106
MINIMUM Y	:	-1.190	-1.050	-.908
CENTROID X	:	.041	.233	.223
CENTROID Y	:	-.213	-.081	-.223
POA TO CENTROID in.	:	.217	.246	.316
MIN RADIUS	:	.227	.295	.210
MEAN RADIUS	:	.992	.846	.780
MAX RADIUS	:	2.095	1.361	1.345
HORIZONTAL SPREAD	:	2.732	2.171	2.171
VERTICAL SPREAD	:	2.461	2.189	2.014
EXTREME SPREAD	:	3.187	2.217	2.217

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 9



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.281	1.195	1.197
MINIMUM X	:	-.941	-1.027	-1.025
MAXIMUM Y	:	1.621	1.147	.974
MINIMUM Y	:	-1.568	-1.388	-.879
CENTROID X	:	.449	.535	.533
CENTROID Y	:	-.026	-.206	-.033
POA TO CENTROID in.	:	.449	.573	.534
MIN RADIUS	:	.326	.149	.269
MEAN RADIUS	:	1.063	.948	.905
MAX RADIUS	:	1.797	1.434	1.298
HORIZONTAL SPREAD	:	2.222	2.222	2.222
VERTICAL SPREAD	:	3.189	2.535	1.853
EXTREME SPREAD	:	3.307	2.681	2.416

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 8

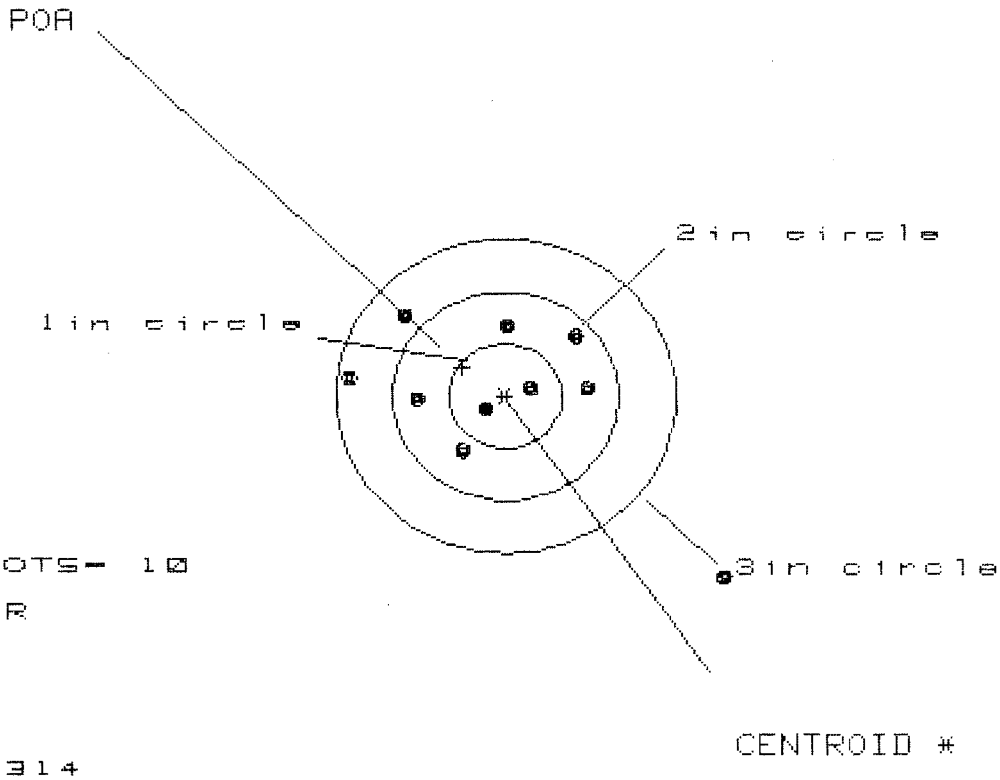


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.253	1.160	.968
MINIMUM X	:	-1.442	-1.535	-.734
MAXIMUM Y	:	1.324	1.170	1.192
MINIMUM Y	:	-1.387	-1.008	-.986
CENTROID X	:	.009	.102	.294
CENTROID Y	:	.261	.415	.393
POA TO CENTROID in.	:	.261	.427	.491
MIN RADIUS	:	.092	.177	.290
MEAN RADIUS	:	.897	.816	.721
MAX RADIUS	:	1.622	1.545	1.193
HORIZONTAL SPREAD	:	2.695	2.695	1.702
VERTICAL SPREAD	:	2.711	2.178	2.178
EXTREME SPREAD	:	2.922	2.712	2.197

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9

29 Nov 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C65875B0

CENTERFIRE PATTERNS # 5



\# OF SHOTS= 10

\# IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.314

VS= 2.475

GS= 3.820

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.953	.981	.838
MINIMUM X	:	-1.361	-1.144	-.815
MAXIMUM Y	:	.792	.605	.609
MINIMUM Y	:	-1.683	-.731	-.727
CENTROID X	:	.381	.164	.307
CENTROID Y	:	-.277	-.090	-.094
POA TO CENTROID in.	:	.471	.187	.321
MIN RADIUS	:	.225	.346	.323
MEAN RADIUS	:	.938	.742	.673
MAX RADIUS	:	2.578	1.144	1.017
HORIZONTAL SPREAD	:	3.314	2.125	1.653
VERTICAL SPREAD	:	2.475	1.336	1.336
EXTREME SPREAD	:	3.820	2.132	1.814

NUMBER IN ONE INCH CIRCLE = 2

NUMBER IN TWO INCH CIRCLE = 7

NUMBER IN THREE INCH CIRCLE = 9