

06587679

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6587679

ORDER NO.
5716

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

01

LPC

0 47700 25716 7

5716 C6587679

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587679

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10	9 90	RW
607	Check Headspace	10	9 90	RW
610	Dis-assemble Gun	10	90	RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	K.R
615	Rollmark Caliber		10/11/90	J.B.
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel <i>WOB</i>		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-9-90	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 1/2	3 1/2			11/9/90	WB
	G) Safety Off Force	2	2	2			11/9/90	WB
	H) Trigger Pull Test & Retainability						11-9-90	JH
	I) Firing Pin Indent	.021	.021	.021			11/9/90	WB
	J) Assemble Stock						11/9/90	RW
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	RW
	M) Iron Sight Alignment						11/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	RW
	O) Attach Scope to Rifle						11/9/90	RW
	P) Detach & Attach Scope 20 Times						11/9/90	RW
640	Gallery Target & Test						11/9/90	KT
	A) Time						"	KT
	B) Malfunctions						"	HT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						11/9/90	KT
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.72	2.72	2.69	2.71	2.69	11/9/90	DH
	C) Function						11-19-90	DH
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 16587679DATE 11-9-90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.50	2.30	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.14	2.41	2.26	2.72	
PULL #3	2.46	2.46	2.40	2.69	
PULL #4	2.29	2.20	2.39	2.71	
PULL #5	2.46	2.19	2.43	2.69	
TOTAL	11.72	11.76	11.78		
AVG.	2.344	2.352	2.356		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.48		
PULL #2	3.25	3.48		
PULL #3	3.17	3.47		
PULL #4	3.35	3.50		
PULL #5	3.44	3.49		
TOTAL	16.67	17.42		
AVG.	3.334	3.484		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.25		4.26
PULL #2	4.39	4.25		4.34
PULL #3	4.36	4.23		4.33
PULL #4	4.38	4.27		4.33
PULL #5	4.41	4.25		4.38
TOTAL	21.85	21.25		21.64
AVG.	4.37	4.25		4.328

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587694
10 Nov 1990

CENTROIDAL DISTANCES

Ø TO	1	.149218
1 TO	2	.219447
1 TO	3	.169446
1 TO	4	.231873
1 TO	5	.279732

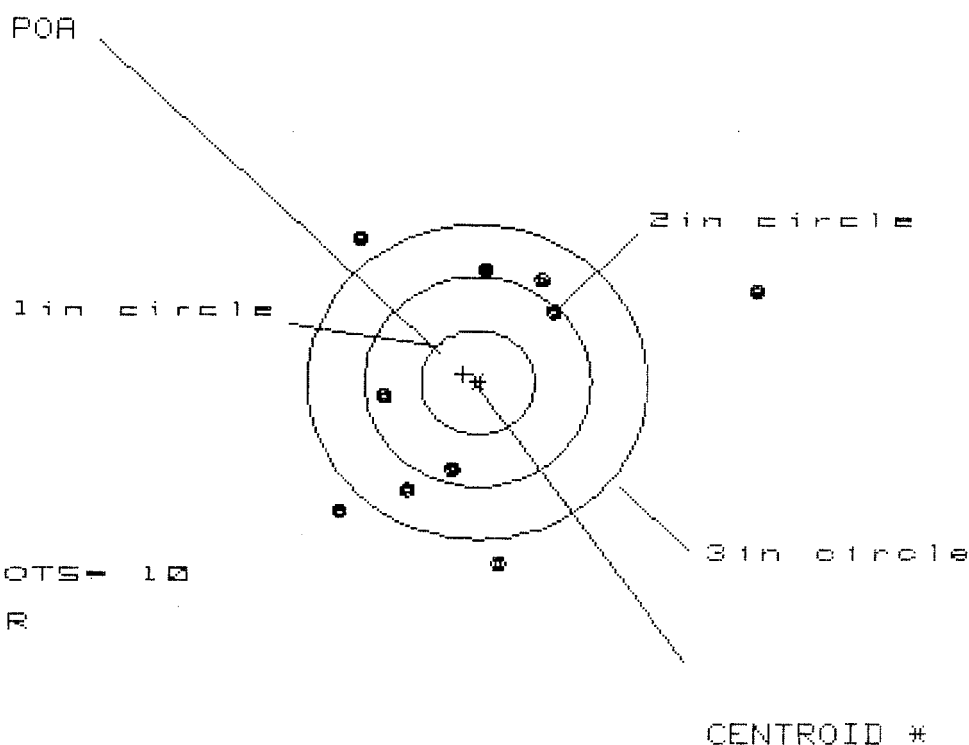
☉ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0406
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1274
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133713
THE AMR FOR THIS RIFLE IS: 1.214

9 Nov 1998

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CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS = 3.656

VS = 3.041

GS = 4.200

CENTROID #

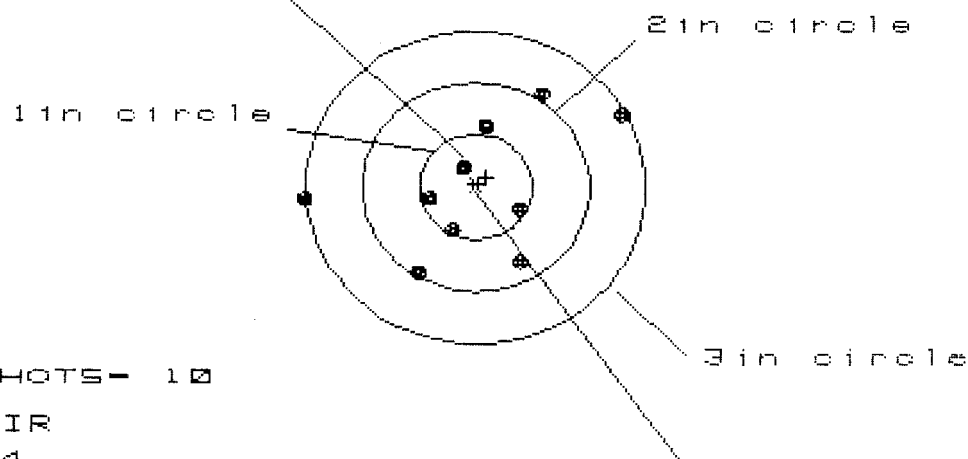
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.447	.897	.958
MINIMUM X	:	-1.209	-.937	-.876
MAXIMUM Y	:	1.353	1.450	1.251
MINIMUM Y	:	-1.688	-1.591	-1.299
CENTROID X	:	.129	-.143	-.204
CENTROID Y	:	-.075	-.172	.027
POA TO CENTROID in.	:	.149	.224	.206
MIN RADIUS	:	.841	.559	.554
MEAN RADIUS	:	1.370	1.196	1.131
MAX RADIUS	:	2.598	1.664	1.567
HORIZONTAL SPREAD	:	3.656	1.834	1.834
VERTICAL SPREAD	:	3.041	3.041	2.550
EXTREME SPREAD	:	4.200	3.285	2.811
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.762

VS = 1.646

GS = 2.889

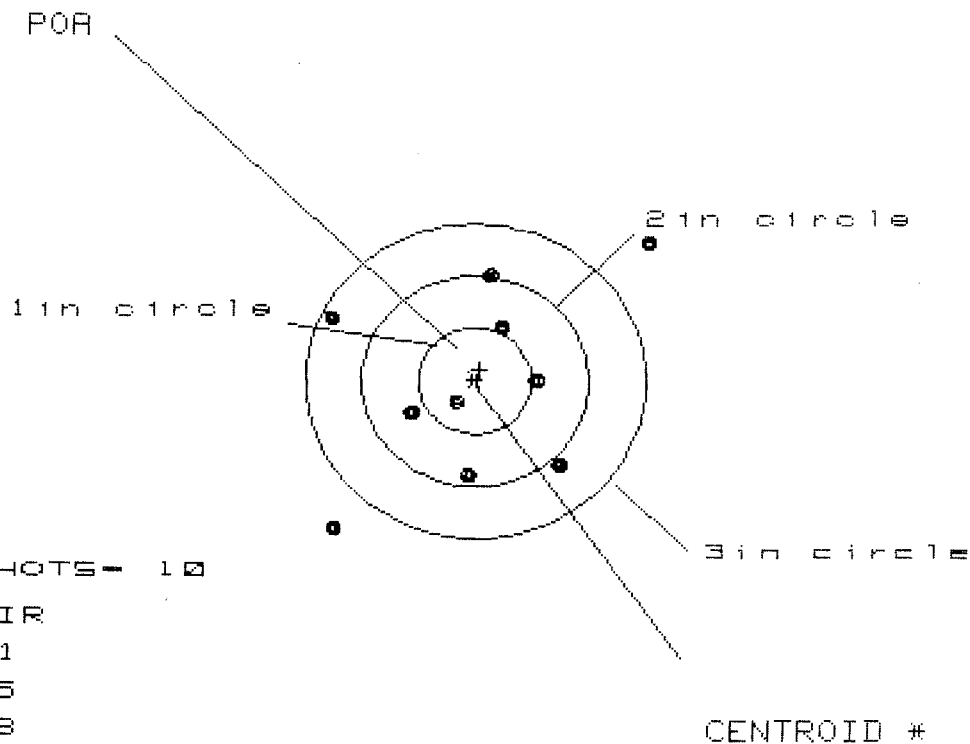
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.126	.612
MINIMUM X	:	-1.472	-.722	-.581
MAXIMUM Y	:	.842	.825	.910
MINIMUM Y	:	-.804	-.821	-.736
CENTROID X	:	-.090	.074	-.067
CENTROID Y	:	-.089	-.072	-.157
POA TO CENTROID in.	:	.126	.103	.171
MIN RADIUS	:	.206	.269	.276
MEAN RADIUS	:	.796	.723	.625
MAX RADIUS	:	1.480	1.314	1.097
HORIZONTAL SPREAD	:	2.762	1.848	1.193
VERTICAL SPREAD	:	1.646	1.646	1.646
EXTREME SPREAD	:	2.889	2.380	2.033
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in - 1

2in - 5

3in - 8

HS- 2.816

VS- 2.751

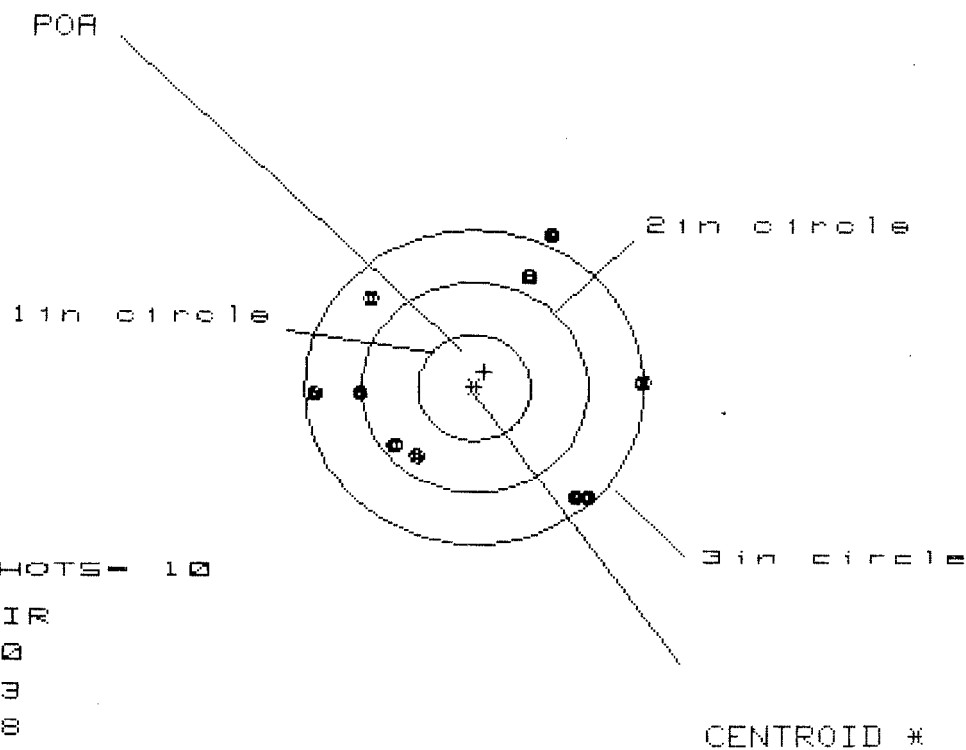
GS- 3.915

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.557	.893	.761
MINIMUM X	:	-1.259	-1.086	-1.218
MAXIMUM Y	:	1.326	1.170	1.010
MINIMUM Y	:	-1.425	-1.278	-.936
CENTROID X	:	-.037	-.210	-.078
CENTROID Y	:	-.109	-.256	-.096
POA TO CENTROID in.	:	.115	.331	.124
MIN RADIUS	:	.290	.066	.273
MEAN RADIUS	:	1.042	.903	.812
MAX RADIUS	:	2.045	1.657	1.369
HORIZONTAL SPREAD	:	2.816	1.979	1.979
VERTICAL SPREAD	:	2.751	2.448	1.946
EXTREME SPREAD	:	3.915	2.821	2.428
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 8

HS = 2.934

VS = 2.532

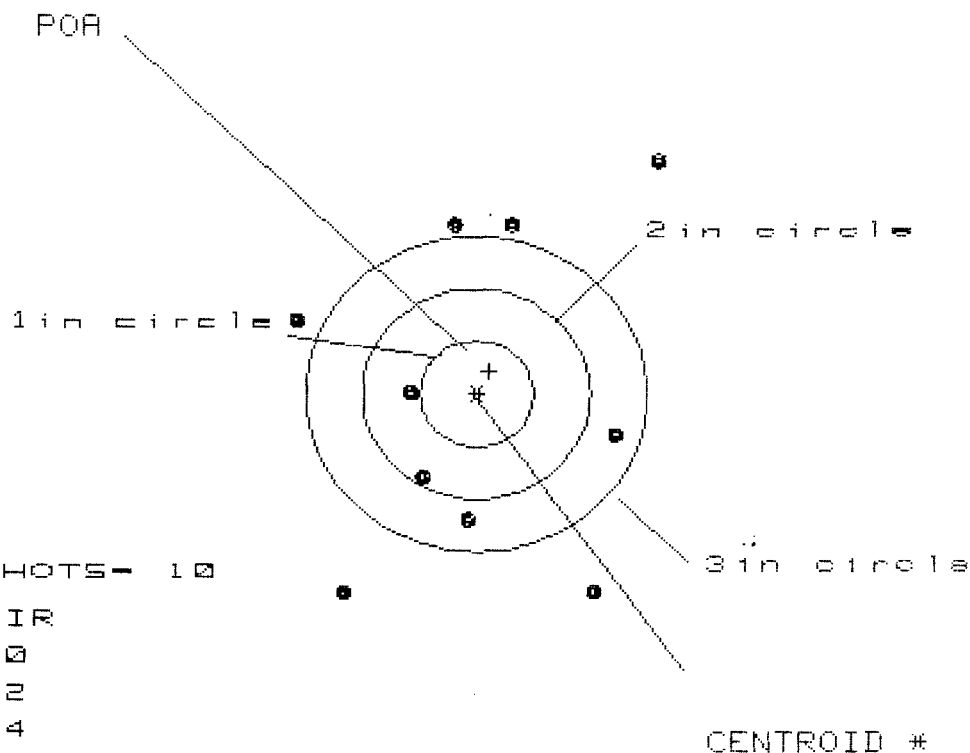
GS = 2.936

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	1.589	1.241
MINIMUM X	:	-1.420	-1.345	-1.146
MAXIMUM Y	:	1.453	1.221	1.251
MINIMUM Y	:	-1.079	-.918	-.888
CENTROID X	:	-.089	-.164	-.363
CENTROID Y	:	-.154	-.316	-.346
POA TO CENTROID in.	:	.178	.356	.502
MIN RADIUS	:	.830	.655	.530
MEAN RADIUS	:	1.250	1.182	1.081
MAX RADIUS	:	1.602	1.608	1.526
HORIZONTAL SPREAD	:	2.934	2.934	2.387
VERTICAL SPREAD	:	2.532	2.139	2.139
EXTREME SPREAD	:	2.936	2.936	2.667
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 4

HS= 3.201

VS= 4.164

GS= 5.022

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.594
MINIMUM X	-1.607
MAXIMUM Y	2.227
MINIMUM Y	-1.937
CENTROID X	-.116
CENTROID Y	-.210
POA TO CENTROID in.	.240
MIN RADIUS	.535
MEAN RADIUS	1.610
MAX RADIUS	2.739
HORIZONTAL SPREAD	3.201
VERTICAL SPREAD	4.164
EXTREME SPREAD	5.022
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	4