

C6523356

MODEL 700™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

DUPONT

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

MODEL 700™ M24

SERIAL NO.
C6523356

ORDER NO.
5716

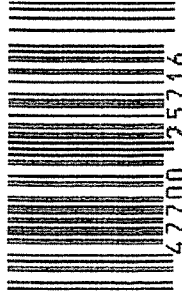
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6523356

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523356

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	RB
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		9-2-90	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	6	6	6			10/9/90	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			10/9/90	WB
	H) Trigger Pull Test & Retainability						10/9/90	WB
	I) Firing Pin Indent	.022	.022	.022			10/9/90	WB
	J) Assemble Stock						10/9/90	RW
	K) Assemble Swivel Studs						2/10/90	JS
	L) Attach Front and Rear Sight Assemblies						10/9/90	RW
	M) Iron Sight Alignment						10/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/9/90	RW
	O) Attach Scope to Rifle						10-9-90	K
	P) Detach & Attach Scope 20 Times						10-9-90	AC
640	Gallery Target & Test						10-11-90	DH
	A) Time						10-11-90	DH
	B) Malfunctions						10-11-90	DH
	C) Pierced Primers						10-11-90	DH
	D) Optical Clarity of Scope						10-11-90	DH
645	Inspect for Live Ammo						10-11-90	DH
655	Final Inspection							
	A) Headspace						2/10/90	JS
	B) Trigger Pull	2.62	2.65	2.72	2.70	2.73	2/10/90	JS
	C) Function						2/10/90	JS
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523356
12 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.770622
1 TO	2	1.05931
1 TO	3	.779567
1 TO	4	.432752
1 TO	5	.560828

1
2 <----POI

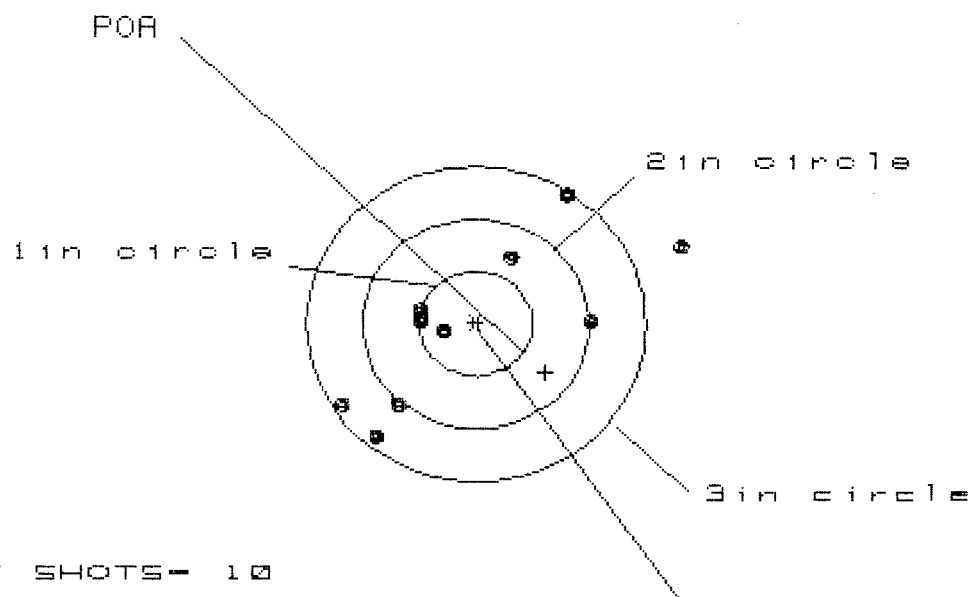
AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2448
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .066
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .253541
AMR FOR THIS RIFLE IS: .8716

2 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523356

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 2.997

VS= 2.256

GS= 3.323

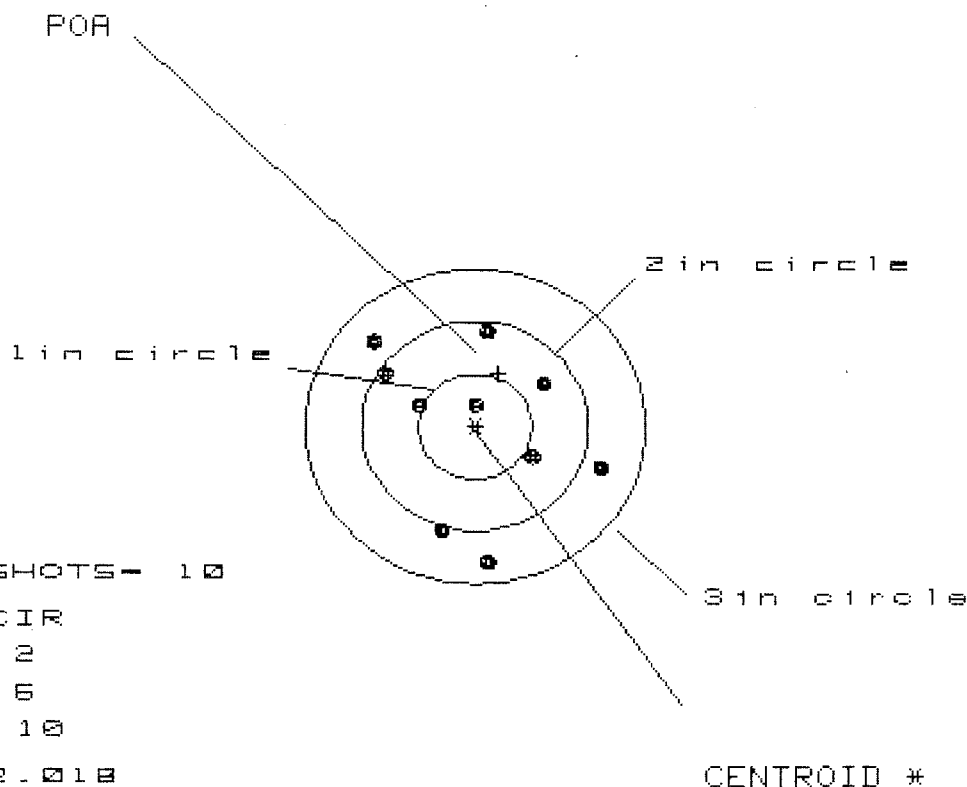
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.800	1.218	1.343
MINIMUM X	:	-1.196	-.996	-.871
MAXIMUM Y	:	1.225	1.304	.834
MINIMUM Y	:	-1.031	-.952	-.789
CENTROID X	:	-.613	-.813	-.938
CENTROID Y	:	.467	.388	.225
POA TO CENTROID in.	:	.770	.900	.965
MIN RADIUS	:	.325	.110	.133
MEAN RADIUS	:	1.017	.853	.733
MAX RADIUS	:	1.937	1.646	1.363
HORIZONTAL SPREAD	:	2.997	2.214	2.214
VERTICAL SPREAD	:	2.256	2.256	1.623
EXTREME SPREAD	:	3.323	2.802	2.325
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.018

VS= 2.177

GS= 2.327

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	1.146	.776
MINIMUM X	:	-.886	-.872	-.729
MAXIMUM Y	:	.925	.786	.720
MINIMUM Y	:	-1.252	-1.156	-1.222
CENTROID X	:	-.206	-.220	-.363
CENTROID Y	:	-.511	-.372	-.306
POA TO CENTROID in.	:	.551	.432	.475
MIN RADIUS	:	.250	.124	.212
MEAN RADIUS	:	.861	.791	.720
MAX RADIUS	:	1.258	1.259	1.230
HORIZONTAL SPREAD	:	2.018	2.018	1.505
VERTICAL SPREAD	:	2.177	1.942	1.942
EXTREME SPREAD	:	2.327	2.327	1.979
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.006

VS= 1.307

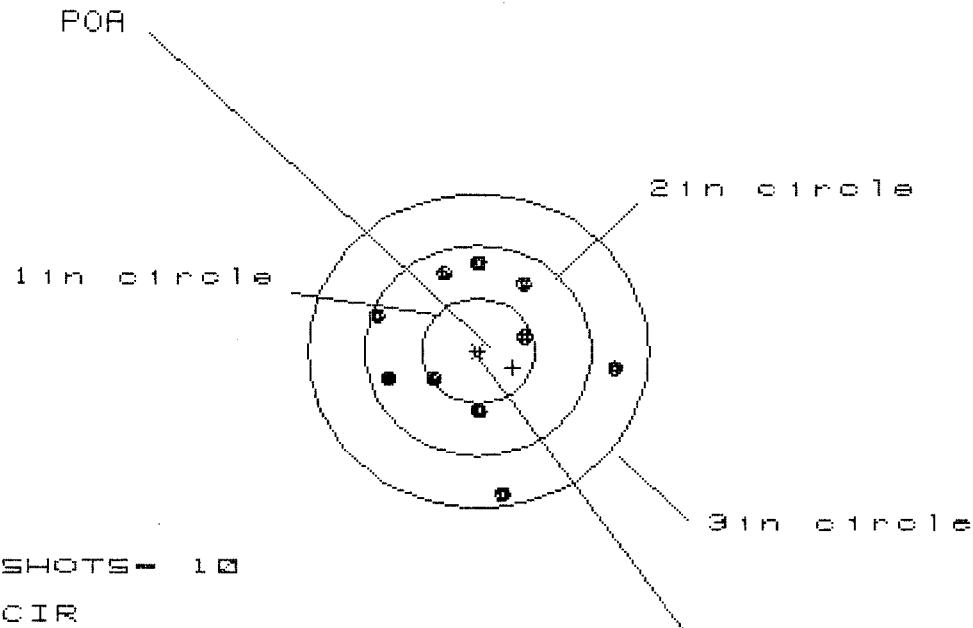
GS= 2.249

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.810	.677	.540
MINIMUM X	:	-1.196	-1.093	-1.042
MAXIMUM Y	:	.596	.511	.331
MINIMUM Y	:	-.711	-.645	-.581
CENTROID X	:	.062	.195	.332
CENTROID Y	:	.077	.011	-.053
POA TO CENTROID in.	:	.099	.195	.336
MIN RADIUS	:	.414	.346	.292
MEAN RADIUS	:	.818	.719	.609
MAX RADIUS	:	1.336	1.207	1.173
HORIZONTAL SPREAD	:	2.006	1.770	1.582
VERTICAL SPREAD	:	1.307	1.156	.912
EXTREME SPREAD	:	2.249	1.969	1.807
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 8

3 in - 10

HS - 2.121

VS - 2.197

GS - 2.207

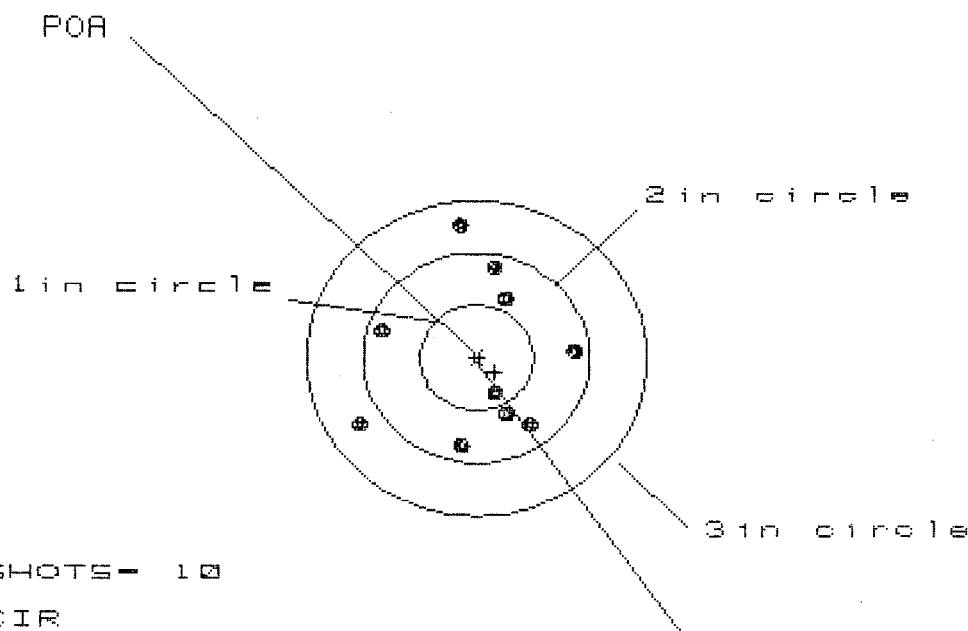
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.243	1.266	.628
MINIMUM X	:	-.878	-.855	-.697
MAXIMUM Y	:	.845	.695	.650
MINIMUM Y	:	-1.352	-.724	-.768
CENTROID X	:	-.306	-.329	-.487
CENTROID Y	:	.162	.312	.357
POA TO CENTROID in.	:	.346	.453	.604
MIN RADIUS	:	.449	.458	.503
MEAN RADIUS	:	.827	.752	.667
MAX RADIUS	:	1.367	1.315	.803
HORIZONTAL SPREAD	:	2.121	2.121	1.325
VERTICAL SPREAD	:	2.197	1.419	1.419
EXTREME SPREAD	:	2.207	2.190	1.510
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 8

3 in - 10

HS - 1.860

VS = 2.152

GS = 2.152

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.841	.828	.699
MINIMUM X	:	-1.020	-1.032	-.987
MAXIMUM Y	:	1.289	.961	.899
MINIMUM Y	:	-.863	-.720	-.782
CENTROID X	:	-.161	-.149	-.020
CENTROID Y	:	.135	-.008	.054
POA TO CENTROID in.	:	.210	.149	.058
MIN RADIUS	:	.401	.279	.272
MEAN RADIUS	:	.835	.759	.694
MAX RADIUS	:	1.294	1.147	1.035
HORIZONTAL SPREAD	:	1.860	1.860	1.686
VERTICAL SPREAD	:	2.152	1.681	1.681
EXTREME SPREAD	:	2.152	2.008	1.703
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6523356

DATE 10/9/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.31	2.43	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.25	2.30	2.65	
PULL #3	2.39	2.24	2.30	2.72	
PULL #4	2.45	2.19	2.31	2.70	
PULL #5	2.39	2.24	2.12	2.73	
TOTAL	12.09	11.23	11.46		
AVG.	2.42	2.24	2.29		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.15		
PULL #2	3.28	3.19		
PULL #3	3.27	3.23		
PULL #4	3.26	3.13		
PULL #5	3.27	3.19		
TOTAL	16.37	15.89		
AVG.	3.27	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.04		4.26
PULL #2	4.21	4.21		4.22
PULL #3	4.24	4.21		4.26
PULL #4	4.21	4.24		4.20
PULL #5	4.15	4.22		4.23
TOTAL	21.09	20.92		21.07
AVG.	4.22	4.18		4.21