

C6523365

MODEL 700TM M24

Model **SWS**TM

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. C6520365

ORDER NO. 5716

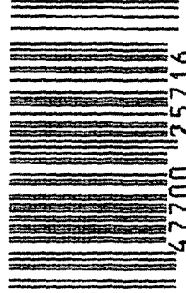
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6520365

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523365

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		9-23-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	JB
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	JA
	Apply Coating (Bolt)		10-2-90	JA
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		10/12/90	JB

op. #	OP. NAME	READINGS				DATE	INIT
625 nt.	F) Safety On Force	5	5	5		10/12/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2		10/12/90	WB
	H) Trigger Pull Test & Retainability					10/22/90	JH
	I) Firing Pin Indent	.024	.024	.024		10/12/90	WB
	J) Assemble Stock					10/12/90	RW
	K) Assemble Swivel Studs					2/18/90	JSS
	L) Attach Front and Rear Sight Assemblies					10/12/90	RW
	M) Iron Sight Alignment					10/12/90	RW
	N) Detach Front & Rear Sights & place in numbered container					10/12/90	RW
	O) Attach Scope to Rifle					10/12/90	RW
	P) Detach & Attach Scope 20 Times					10/12/90	RW
640	Gallery Target & Test					10-16-90	KT
	A) Time					10-16-90	KT
	B) Malfunctions					10-16-90	KT
	C) Pierced Primers					10-16-90	KT
	D) Optical Clarity of Scope					10-16-90	KT
645	Inspect for Live Ammo					10-16-90	KT
655	Final Inspection						
	A) Headspace					2/18/90	JSS
	B) Trigger Pull	211	207	204	201	210	2/18/90
	C) Function					2/18/90	JSS
660	Pack					2/17/90	DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523365
17 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.163248
1 TO	2	.211851
1 TO	3	.225887
1 TO	4	.283185
1 TO	5	.175285

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0772

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .133

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153782

THE AMR FOR THIS RIFLE IS: .957

16 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523365

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.737

VS= 2.717

GS= 3.513

CENTROID *

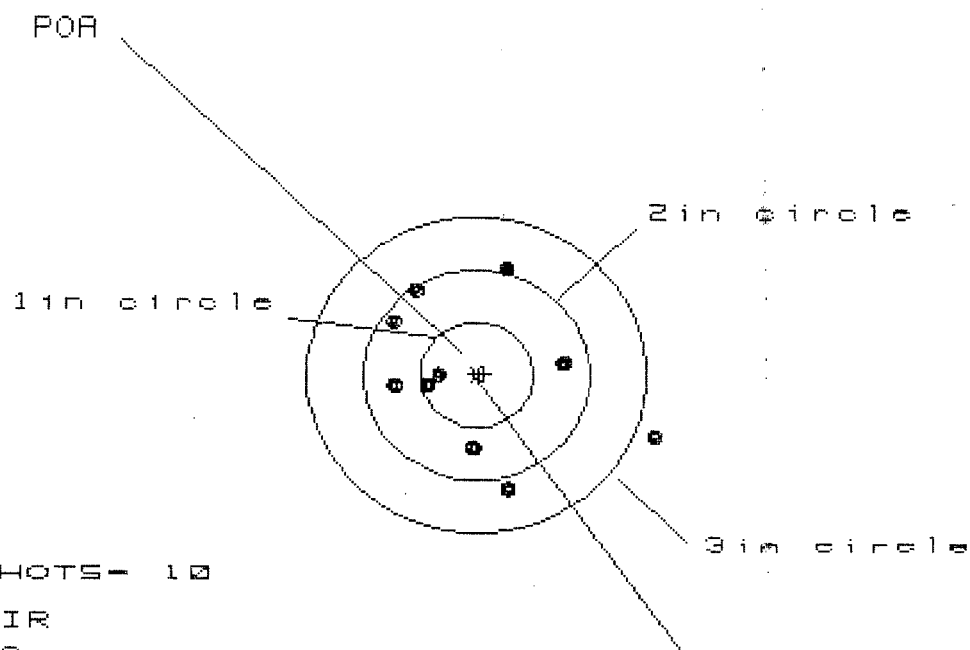
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.026	1.139	.940
MINIMUM X	:	-1.711	-1.598	-1.192
MAXIMUM Y	:	1.778	1.080	1.051
MINIMUM Y	:	-.939	-.742	-.771
CENTROID X	:	.071	-.042	.157
CENTROID Y	:	.147	-.050	-.021
POA TO CENTROID in.	:	.164	.066	.159
MIN RADIUS	:	.301	.302	.121
MEAN RADIUS	:	1.012	.867	.738
MAX RADIUS	:	2.051	1.614	1.196
HORIZONTAL SPREAD	:	2.737	2.737	2.132
VERTICAL SPREAD	:	2.717	1.822	1.822
EXTREME SPREAD	:	3.513	2.871	2.244
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

16 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523365

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in = 9

HS= 2.344

VS= 2.102

GS= 2.584

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.584	.949	1.003
MINIMUM X	:	-.760	-.584	-.529
MAXIMUM Y	:	1.038	.973	.881
MINIMUM Y	:	-1.064	-1.129	-.888
CENTROID X	:	-.069	-.245	-.299
CENTROID Y	:	-.012	.053	.195
POA TO CENTROID in.	:	.070	.250	.357
MIN RADIUS	:	.345	.165	.186
MEAN RADIUS	:	.874	.733	.663
MAX RADIUS	:	1.688	1.212	1.005
HORIZONTAL SPREAD	:	2.344	1.533	1.523
VERTICAL SPREAD	:	2.102	2.102	1.719
EXTREME SPREAD	:	2.584	2.102	1.747
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523365

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 6

3 in - 8

HS = 2.315

VS = 3.085

GS = 3.395

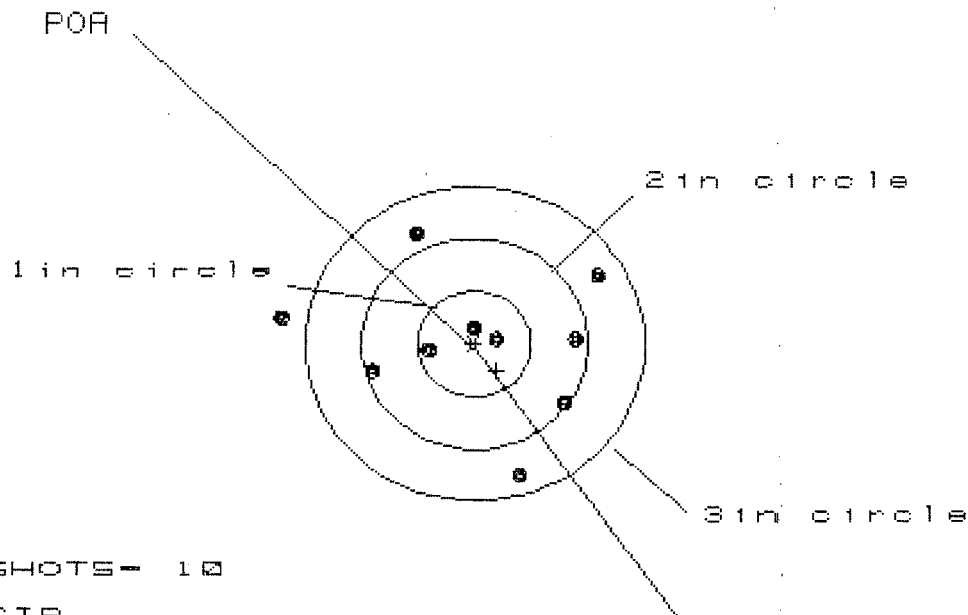
CENTROID #

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.822
MINIMUM X	:	-1.493
MAXIMUM Y	:	2.048
MINIMUM Y	:	-1.037
CENTROID X	:	-.133
CENTROID Y	:	.244
POA TO CENTROID in.	:	.278
MIN RADIUS	:	.406
MEAN RADIUS	:	.975
MAX RADIUS	:	2.207
HORIZONTAL SPREAD	:	2.315
VERTICAL SPREAD	:	3.085
EXTREME SPREAD	:	3.395
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	8

18 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523365

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in - 9

HS- 2.750

VS- 2.347

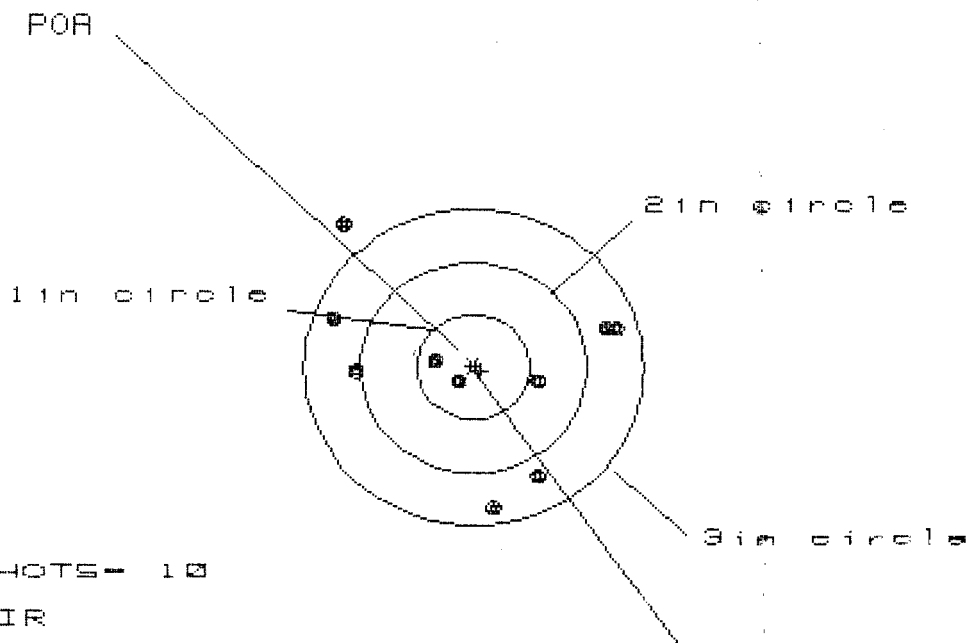
GS- 2.771

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.082	.897	.927
MINIMUM X	:	-1.668	-1.118	-1.088
MAXIMUM Y	:	1.075	1.108	.953
MINIMUM Y	:	-1.272	-1.239	-.654
CENTROID X	:	-.192	-.007	-.037
CENTROID Y	:	.252	.219	.374
POA TO CENTROID in.	:	.317	.219	.376
MIN RADIUS	:	.103	.062	.181
MEAN RADIUS	:	.896	.790	.727
MAX RADIUS	:	1.693	1.283	1.152
HORIZONTAL SPREAD	:	2.750	2.015	2.015
VERTICAL SPREAD	:	2.347	2.347	1.607
EXTREME SPREAD	:	2.771	2.509	2.202
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523365

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS= 2.499

VS= 2.708

GS= 2.983

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.305	1.183	1.211
MINIMUM X	-1.194	-1.316	-1.168
MAXIMUM Y	1.383	.646	.717
MINIMUM Y	-1.325	-1.171	-1.100
CENTROID X	-.063	.059	-.089
CENTROID Y	.034	-.120	-.191
POR TO CENTROID in.	.071	.134	.211
MIN RADIUS	.249	.301	.162
MEAN RADIUS	1.028	.936	.856
MAX RADIUS	1.766	1.466	1.371
HORIZONTAL SPREAD	2.499	2.499	2.379
VERTICAL SPREAD	2.708	1.817	1.817
EXTREME SPREAD	2.983	2.500	2.384
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6523365

DATE 10/12/90

TESTER 991

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.34	2.30	2.11	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.39	2.40	2.07	
PULL #3	2.42	2.33	2.36	2.04	
PULL #4	2.32	2.36	2.42	2.01	
PULL #5	2.36	2.33	2.32	2.10	
TOTAL	11.7	11.75	11.80		
AVG.	2.34	2.35	2.36		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.27		
PULL #2	3.22	3.23		
PULL #3	3.19	3.24		
PULL #4	3.50	3.25		
PULL #5	3.50	3.30		
TOTAL	16.74	16.29		
AVG.	3.348	3.258		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.25		4.29
PULL #2	4.26	4.27		4.28
PULL #3	4.25	4.25		4.31
PULL #4	4.16	4.23		4.31
PULL #5	4.24	4.32		4.32
TOTAL	21.24	21.32		21.51
AVG.	4.248	4.264		4.302