

06523419

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6523419

ORDER NO.
5716

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

01

5716 C6523419

UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523419

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	JS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		9-25-90	JS
	Apply Coating (Bolt)		10	JS
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		10/15/90	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	5 1/2	5 1/2	5 1/2			10/13/90	WLB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			10/13/90	WLB
	H) Trigger Pull Test & Retainability						10/15/90	WLB
	I) Firing Pin Indent	0.070	0.070	0.070			10/13/90	WLB
	J) Assemble Stock						10/17/90	RW
	K) Assemble Swivel Studs						2/16/90	JSB
	L) Attach Front and Rear Sight Assemblies						10/17/90	RW
	M) Iron Sight Alignment						10/17/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/17/90	RW
	O) Attach Scope to Rifle						10/19/90	RW
	P) Detach & Attach Scope 20 Times						10/19/90	RW
640	Gallery Target & Test						10/24/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						10/24/90	AF
655	Final Inspection							
	A) Headspace						2/16/90	JSB
	B) Trigger Pull	232	240	234	220	213	2/16/90	JSB
	C) Function						2/16/90	JSB
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. C6523419DATE 10/15/90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.31	2.40	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.47	2.43	2.40	
PULL #3	2.37	2.42	2.36	2.34	
PULL #4	2.40	2.28	2.47	2.20	
PULL #5	2.40	2.42	2.40	2.13	
TOTAL	11.87	11.90	12.06		
AVG.	2.374	2.38	2.412		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.35		
PULL #2	3.22	3.26		
PULL #3	3.14	3.21		
PULL #4	3.20	3.42		
PULL #5	3.23	3.26		
TOTAL	15.89	16.5		
AVG.	3.179	3.3		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.26		4.52
PULL #2	4.37	4.27		4.14
PULL #3	4.43	4.26		4.45
PULL #4	4.36	4.24		4.48
PULL #5	4.39	4.09		4.32
TOTAL	22.03	21.12		21.91
AVG.	4.406	4.224		4.382

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6523419
 25 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0587282
1 TO	2	.0948472
1 TO	3	.0796304
1 TO	4	.494434
1 TO	5	.467603

+ 2₅ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0794
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0442
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0908735
 THE AMR FOR THIS RIFLE IS: 1.178

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523419

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.731

VS= 2.041

GS= 2.939

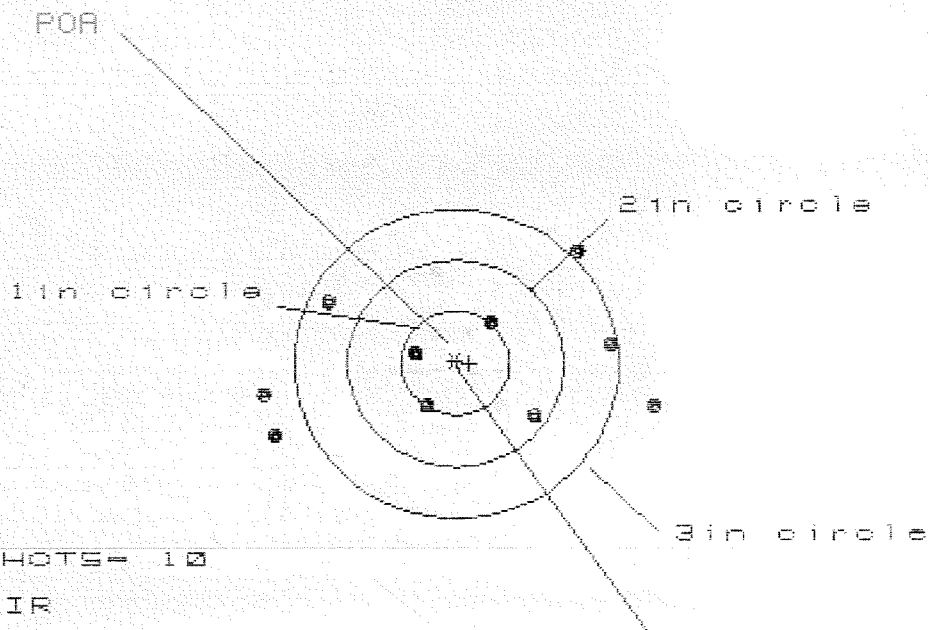
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.523	1.148	.986
MINIMUM X	-1.208	-1.039	-.896
MAXIMUM Y	.867	.901	.765
MINIMUM Y	-1.174	-1.140	-1.276
CENTROID X	-.040	-.209	-.352
CENTROID Y	-.018	-.052	.004
POA TO CENTROID in.	.043	.215	.362
MIN RADIUS	.274	.125	.076
MEAN RADIUS	.972	.879	.749
MAX RADIUS	1.553	1.580	1.303
HORIZONTAL SPREAD	2.731	2.187	1.882
VERTICAL SPREAD	2.041	2.041	2.041
EXTREME SPREAD	2.939	2.939	2.326
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 6

HS = 3.613

VS = 1.804

GS = 3.616

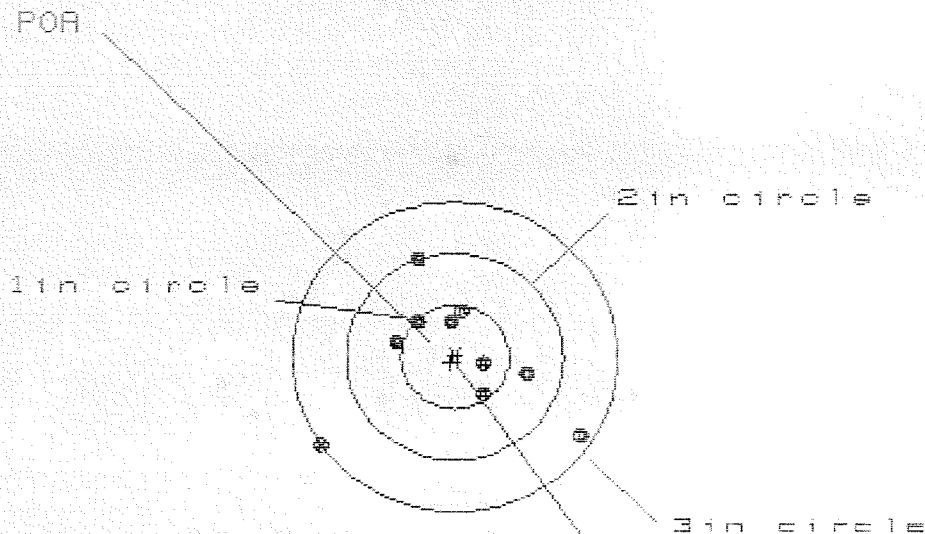
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.817	1.581	1.395
MINIMUM X	-1.795	-1.593	-1.779
MAXIMUM Y	1.054	1.004	.904
MINIMUM Y	-.750	-.800	-.640
CENTROID X	-.126	-.328	-.142
CENTROID Y	.003	.053	.153
POA TO CENTROID in.	.126	.332	.209
MIN RADIUS	.407	.199	.382
MEAN RADIUS	1.216	1.125	1.050
MAX RADIUS	1.872	1.687	1.830
HORIZONTAL SPREAD	3.612	3.174	3.174
VERTICAL SPREAD	1.804	1.804	1.544
EXTREME SPREAD	3.616	3.365	3.237
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS= 2.345

VS= 1.774

GS= 2.346

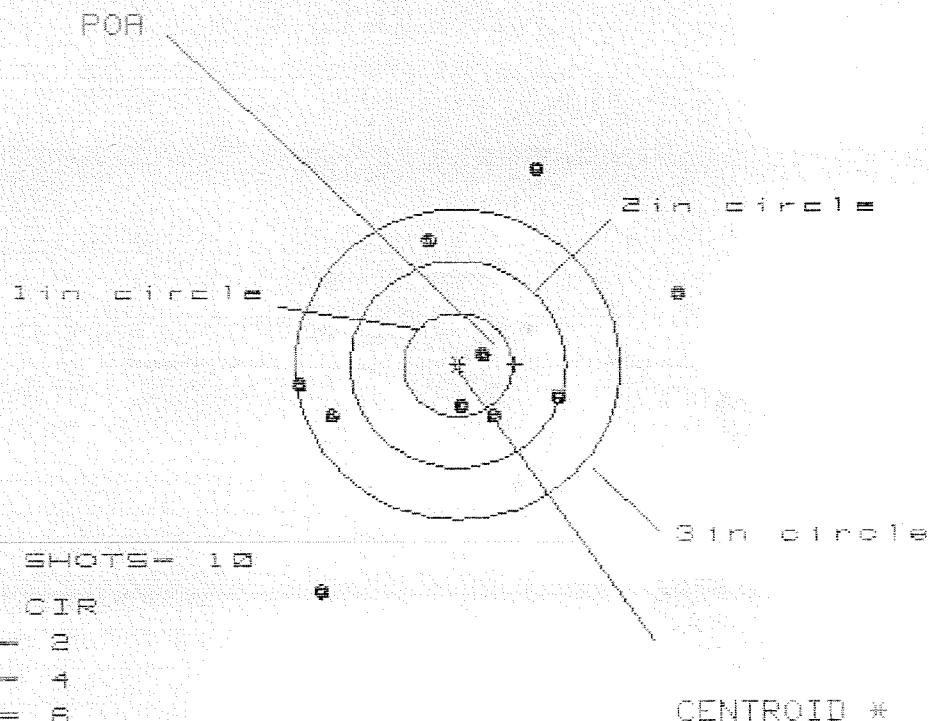
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	1.004	.702
MINIMUM X	:	-1.206	-.714	-.588
MAXIMUM Y	:	.970	.880	.778
MINIMUM Y	:	-.804	-.815	-.581
CENTROID X	:	.039	.173	.047
CENTROID Y	:	.053	.143	.245
POA TO CENTROID in.	:	.066	.224	.249
MIN RADIUS	:	.290	.227	.148
MEAN RADIUS	:	.714	.613	.500
MAX RADIUS	:	1.450	1.293	.837
HORIZONTAL SPREAD	:	2.345	1.718	1.290
VERTICAL SPREAD	:	1.774	1.695	1.359
EXTREME SPREAD	:	2.346	2.222	1.541
NUMBER IN ONE INCH CIRCLE	=		5	
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 = 4

3 in = 6

HS= 3.486

VS= 4.086

GS= 4.520

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.989	1.852	1.020
MINIMUM X	-1.497	-1.634	-1.402
MAXIMUM Y	1.928	1.688	1.752
MINIMUM Y	-2.158	-1.765	-1.781
CENTROID X	-.532	-.395	-.627
CENTROID Y	-.086	.234	.170
POA TO CENTROID in.	.532	.459	.650
MIN RADIUS	.211	.151	.293
MEAN RADIUS	1.298	1.172	1.076
MAX RADIUS	2.485	1.922	1.924
HORIZONTAL SPREAD	3.486	3.486	2.422
VERTICAL SPREAD	4.086	2.453	2.453
EXTREME SPREAD	4.520	3.602	3.100
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 5.810

VS= 3.982

GS= 5.951

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.909	2.586	1.794
MINIMUM X	-2.901	-2.665	-2.341
MAXIMUM Y	1.320	1.440	1.430
MINIMUM Y	-2.662	-2.542	-2.552
CENTROID X	.262	.585	.261
CENTROID Y	-.314	-.434	-.424
POA TO CENTROID in.	.409	.728	.498
MIN RADIUS	.108	.265	.062
MEAN RADIUS	1.691	1.550	1.368
MAX RADIUS	3.096	3.029	2.743
HORIZONTAL SPREAD	5.810	5.251	4.135
VERTICAL SPREAD	3.982	3.982	3.982
EXTREME SPREAD	5.951	5.468	4.801
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		5	