C6225594

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

M-24

Scans 0065

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225594

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	89	RW
600	Proof	4 12	89	RW
607	Check Headspace	4 12	89	RW
610	Dis-assemble Gun	4 12	89	RW
612	Magnaflux Barrel Action		4/13/89	KCR
	Magnaflux Bolt		4/14/89	KCR
615	Rollmark Caliber		4/14/89	KCR
617	Drill and Tap Sight Holes	4 14	89	FB
618	Polish Barrel RB	4 14	89	FB
620	Apply Coatings (Barrel Action)		4/19-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/8/89	RW
	C) Inspect Ejector Hole for Chamfer		5/8/89	RW
	D) Oil Firing Pin Ass'y		5/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/11/89	WB

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	5/12/89	JL
	G) Safety Off Force	2	3	3	5/12/89	JL
	H) Trigger Pull Test & Retainability				5/11/89	WB
	I) Firing Pin Indent	.022	.021.5	.020.5	5/12/89	JL
	J) Assemble Stock				5/12/89	RW
	K) Assemble Swivel Studs				16 May 89	GS
	L) Attach Front and Rear Sight Assemblies				5/12/89	RW
	M) Iron Sight Alignment				5/12/89	RW
	N) Detach Front & Rear Sights & place in numbered container				5/12/89	RW
	O) Attach Scope to Rifle				5/12/89	JL
	P) Detach & Attach Scope 20 Times				5/15/89	JL
640	Gallery Target & Test	60 R 100L			5/15/89	DH
	A) Time				5/15/89	DH
	B) Malfunctions				5/15/89	DH
	C) Pierced Primers				5/15/89	DH
	D) Optical Clearity of Scope				5/15/89	DH
645	Inspect for Live Ammo				5/15/89	DH
655	Final Inspection A) Headspace				16 May 89	GS
	B) Trigger Pull	2.70	2.72	2.65	2.66 2.72	16 May 89 GS
	C) Function				16 May 89	GS
660	Pack				26 June 89	GS

SWS TRIGGER PULL TEST

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

SERIAL NO. C625594
DATE 3-28-90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2,50#		COMMENTS
PULL #1	2.47	2.43		2.24	MIN. SETTING,
PULL #2	2.56	2.42		2.40	NO AVG. OF 5
PULL #3	2.39	2.46		2.44	READINGS ACCEPT-
PULL #4	2.46	2.38		2.45	ABLE LESS THAN 2#
PULL #5	2.42	2.40		2.40	
TOTAL	12.30	12.09		11.93	
AVG.	2.46	2.418		2.386	

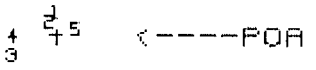
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.37		—
PULL #2	3.58	3.44		
PULL #3	3.32	3.40		
PULL #4	3.48	3.44		
PULL #5	3.40	3.46		
TOTAL	17.31	17.11		
AVG.	3.462	3.422		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.26		
PULL #2	4.26	4.25		
PULL #3	4.28	4.30		
PULL #4	4.25	4.23		
PULL #5	4.28	4.24		
TOTAL	21.36	21.28		
AVG.	4.272	4.256		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225594
16 May 1989

CENTROIDAL DISTANCES

0	TO	1	.4634
1	TO	2	.209914
1	TO	3	1.11397
1	TO	4	.891278
1	TO	5	.506495

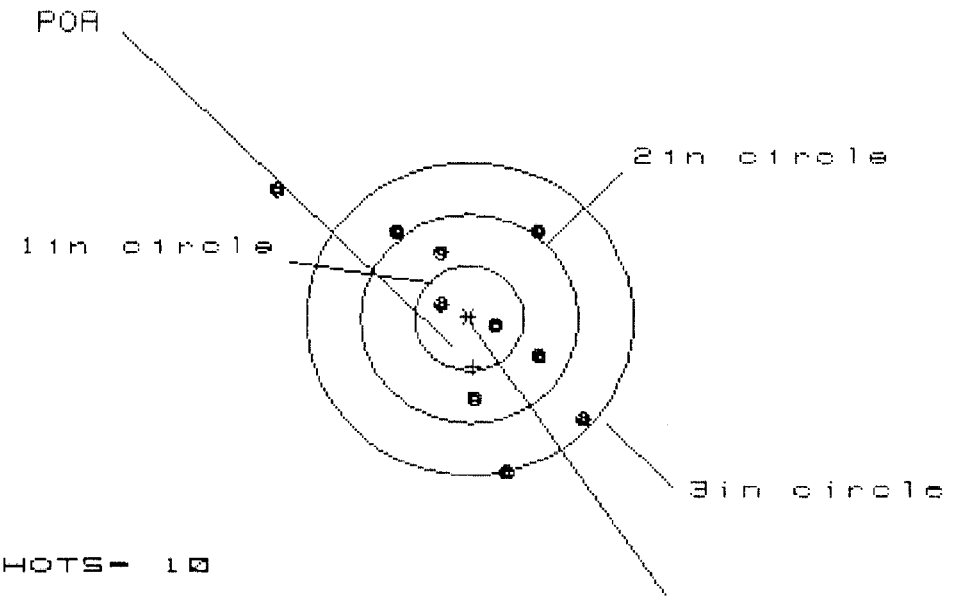


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .106
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .307451

THE AMR FOR THIS RIFLE IS: .9166

15 May 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C6225594

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 6
3in = 9
HS= 2.747
VS= 2.695
GS= 3.558

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.822	.836
MINIMUM X	:	-1.732	-.829	-.815
MAXIMUM Y	:	1.271	.939	.779
MINIMUM Y	:	-1.424	-1.283	-1.009
CENTROID X	:	-.036	.157	.143
CENTROID Y	:	.462	.321	.481
POA TO CENTROID in.	:	.463	.357	.502
MIN RADIUS	:	.281	.085	.143
MEAN RADIUS	:	.987	.829	.767
MAX RADIUS	:	2.148	1.287	1.310
HORIZONTAL SPREAD	:	2.747	1.651	1.651
VERTICAL SPREAD	:	2.695	2.222	1.788
EXTREME SPREAD	:	3.558	2.428	2.428
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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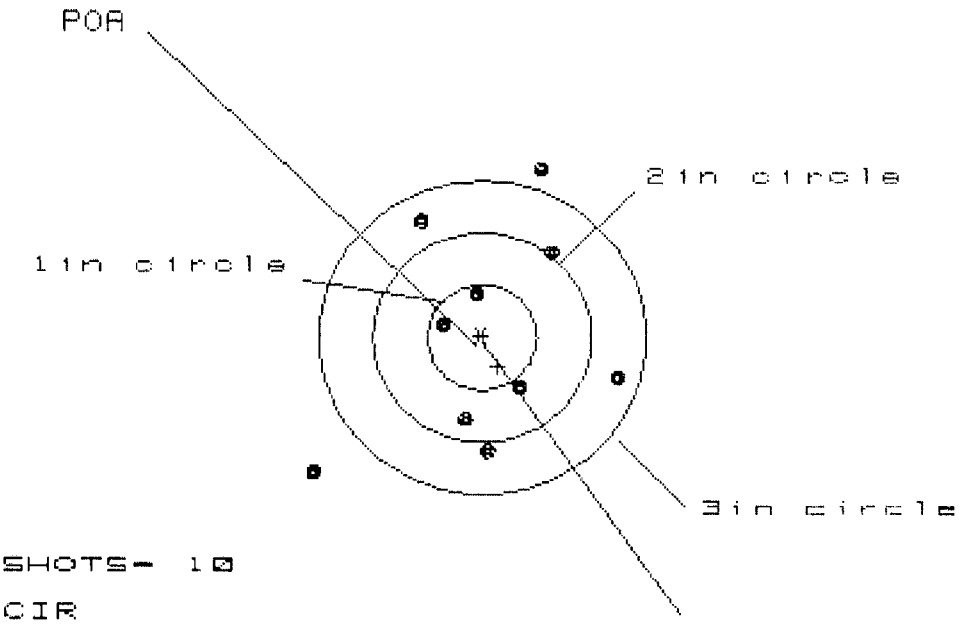
CENTERFIRE PATTERNS # 2



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 4
3in = 8
HS= 2.830
VS= 2.946
GS= 3.627

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.237	1.060	1.103
MINIMUM X	:	-1.593	-.754	-.711
MAXIMUM Y	:	1.637	1.492	1.152
MINIMUM Y	:	-1.308	-1.256	-1.069
CENTROID X	:	-.144	.033	-.010
CENTROID Y	:	.282	.427	.240
POA TO CENTROID in.	:	.316	.428	.241
MIN RADIUS	:	.376	.332	.433
MEAN RADIUS	:	1.070	.956	.864
MAX RADIUS	:	2.062	1.532	1.354
HORIZONTAL SPREAD	:	2.830	1.814	1.814
VERTICAL SPREAD	:	2.946	2.748	2.221
EXTREME SPREAD	:	3.627	2.795	2.371
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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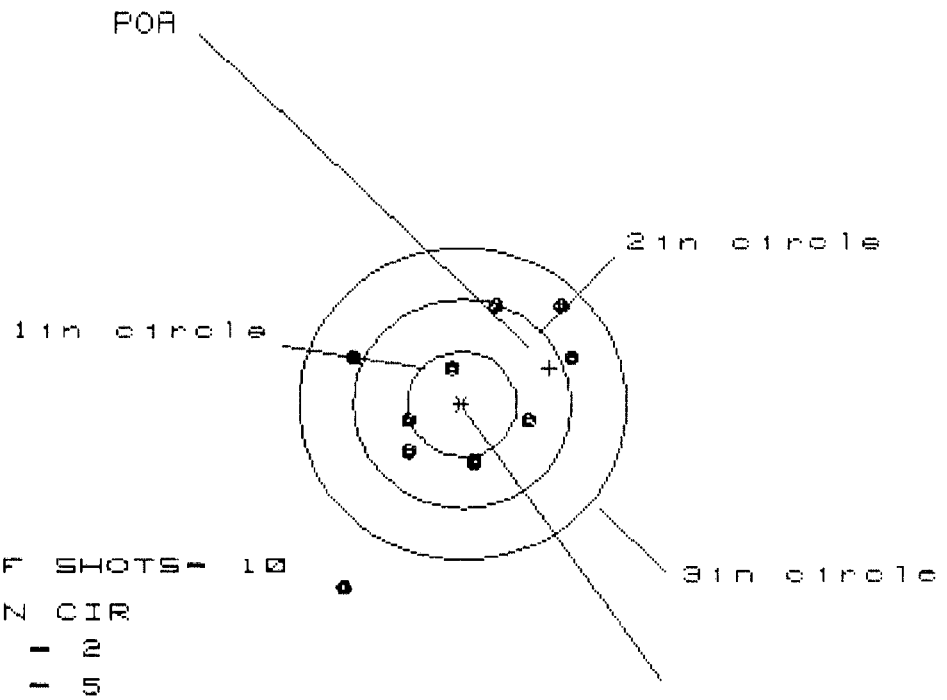
CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 5
3in = 9
HS= 2.043
VS= 2.697
GS= 3.283

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.996	.880	.979
MINIMUM X	:	-1.047	-1.088	-.989
MAXIMUM Y	:	.967	.775	.864
MINIMUM Y	:	-1.730	-.798	-.709
CENTROID X	:	-.806	-.690	-.789
CENTROID Y	:	-.343	-.151	-.240
POA TO CENTROID in.	:	.876	.706	.825
MIN RADIUS	:	.379	.247	.281
MEAN RADIUS	:	.935	.799	.753
MAX RADIUS	:	2.022	1.107	1.054
HORIZONTAL SPREAD	:	2.043	1.968	1.968
VERTICAL SPREAD	:	2.697	1.573	1.573
EXTREME SPREAD	:	3.283	1.986	1.970
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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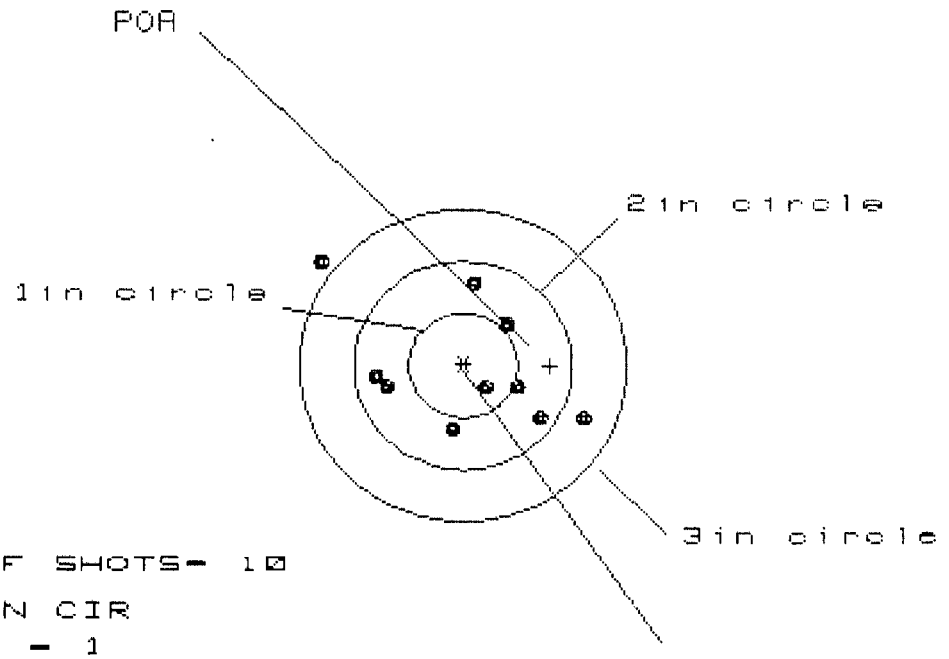
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR	
1in	1
2in	8
3in	9

HS= 2.362
VS= 1.598
GS= 2.786

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	.922	.631
MINIMUM X	:	-1.296	-.915	-.800
MAXIMUM Y	:	1.009	.945	.900
MINIMUM Y	:	-.589	-.477	-.522
CENTROID X	:	-.800	-.656	-.771
CENTROID Y	:	.003	-.109	-.064
POA TO CENTROID in.	:	.800	.665	.774
MIN RADIUS	:	.319	.138	.254
MEAN RADIUS	:	.800	.663	.637
MAX RADIUS	:	1.643	.988	.902
HORIZONTAL SPREAD	:	2.362	1.837	1.431
VERTICAL SPREAD	:	1.598	1.422	1.422
EXTREME SPREAD	:	2.786	1.881	1.488
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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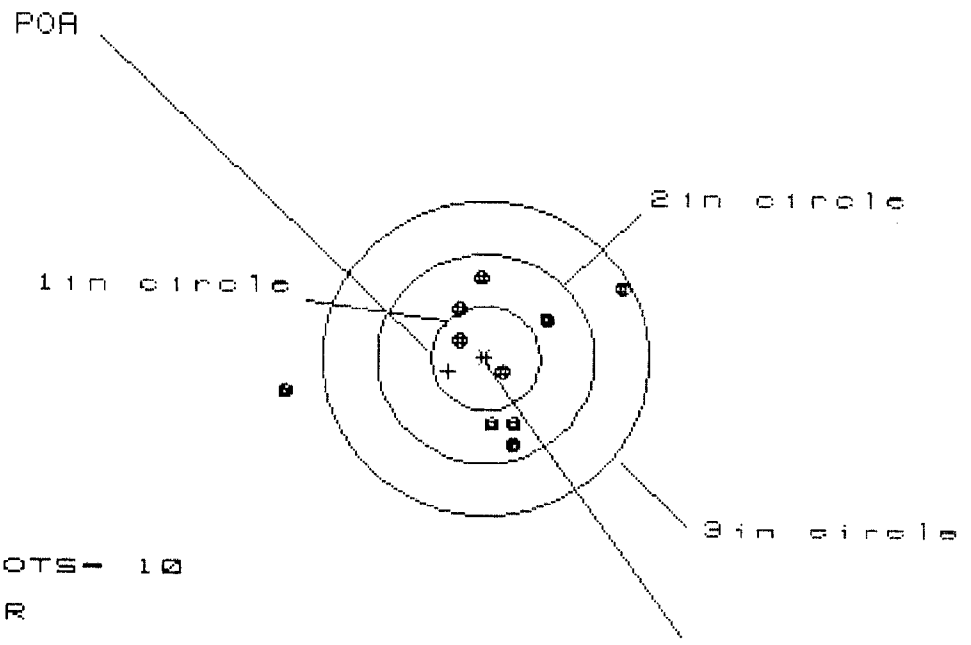
CENTERFIRE PATTERNS # 5

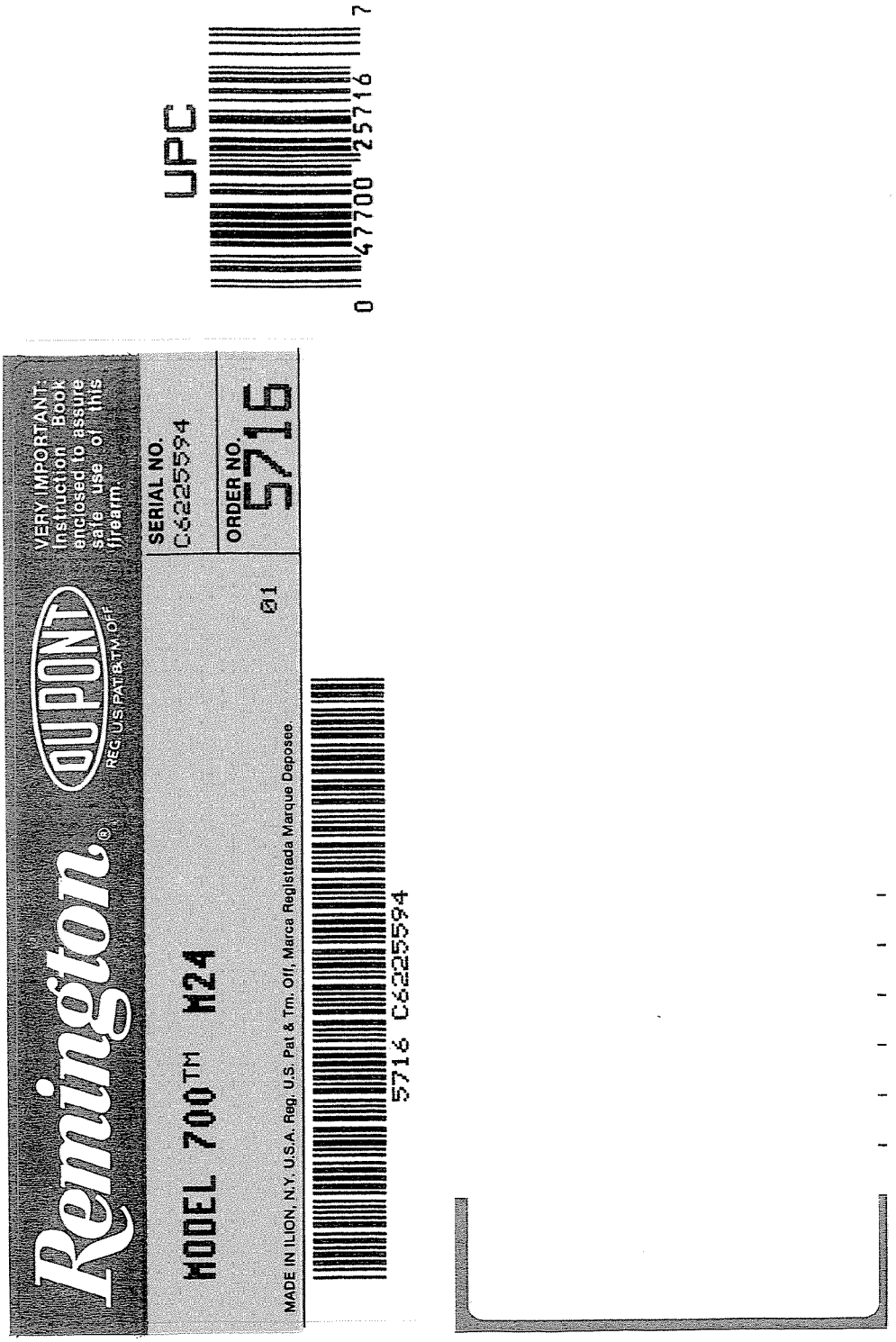


OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 9

HS= 3.084
VS= 1.625
GS= 3.241

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.218	1.011	.440
MINIMUM X	:	-1.866	-.489	-.363
MAXIMUM Y	:	.819	.781	.858
MINIMUM Y	:	-.806	-.844	-.767
CENTROID X	:	.343	.550	.424
CENTROID Y	:	.126	.164	.087
POA TO CENTROID in.	:	.365	.574	.433
MIN RADIUS	:	.199	.157	.111
MEAN RADIUS	:	.791	.658	.570
MAX RADIUS	:	1.897	1.184	.868
HORIZONTAL SPREAD	:	3.084	1.500	.803
VERTICAL SPREAD	:	1.625	1.625	1.625
EXTREME SPREAD	:	3.241	1.755	1.652
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24
SERIAL NO.
C6225594
ORDER NO.
5716
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5716 C6225594
UPC
0 47700 25716 7