C6349157

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

Sitmad®

Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24
SERIAL NO.
C6349157
ORDER NO.
5716
01
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.
5716 C6349157
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349157

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	90	RW
600	Proof	5 2	90	RW
607	Check Headspace	5 2	90	RW
610	Dis-assemble Gun	5 2	90	RW
612	Magnaflux Barrel Action	5-8-90		KCR
	Magnaflux Bolt	5-8-90		KCR
615	Rollmark Caliber		5/8/90	GS
617	Drill and Tap Sight Holes		5/9/90	F-B
618	Polish Barrel RB		5/10/90	WB
620	Apply Coatings (Barrel Action)		5/16-90	TJA
	Apply Coating (Bolt)		5/16	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/90	RW

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 1/2	3 3/4	5/23/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4	5/23/90	WB
	H) Trigger Pull Test & Retainability				5/23/90	RW
	I) Firing Pin Indent	.074	.074	.074	5/23/90	WB
	J) Assemble Stock				5/23/90	RW
	K) Assemble Swivel Studs				24 May 90	DS
	L) Attach Front and Rear Sight Assemblies				5/23/90	RW
	M) Iron Sight Alignment				5/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container				5/23/90	RW
	O) Attach Scope to Rifle				5/23/90	WB
	P) Detach & Attach Scope 20 Times				5/23/90	WB
640	Gallery Target & Test				5-24-90	[illegible]
	A) Time				"	[illegible]
	B) Malfunctions				"	[illegible]
	C) Pierced Primers				"	[illegible]
	D) Optical Clearity of Scope				"	[illegible]
645	Inspect for Live Ammo				5-24-90	[illegible]
655	Final Inspection A) Headspace				24 May 90	DS
	B) Trigger Pull	271	276	265 277 279	24 May 90	DS
	C) Function				24 May 90	DS
660	Pack				6-29-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349157

DATE 5/23/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.23	2.36	271	MIN. SETTING,
PULL #2	2.50	2.17	2.56	276	NO AVG. OF 5
PULL #3	2.28	2.22	2.34	265	READINGS ACCEPT-
PULL #4	2.24	2.24	2.34	277	ABLE LESS THAN 2#
PULL #5	2.27	2.38	2.34	279	
TOTAL	11.81	11.24	11.94		
AVG.	2.362	2.248	2.388		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.25		
PULL #2	3.25	3.12		
PULL #3	3.22	3.26		
PULL #4	3.23	3.27		
PULL #5	3.23	3.26		
TOTAL	16.14	16.15		
AVG.	3.228	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.37		4.35
PULL #2	4.31	4.36		4.39
PULL #3	4.35	4.37		4.39
PULL #4	4.33	4.28		4.33
PULL #5	4.10	4.39		4.32
TOTAL	21.43	21.75		21.78
AVG.	4.286	4.35		4.356

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349157
25 May 1990

CENTROIDAL DISTANCES

0	TO	1	.334389
1	TO	2	.156247
1	TO	3	.72808
1	TO	4	.704165
1	TO	5	.300528

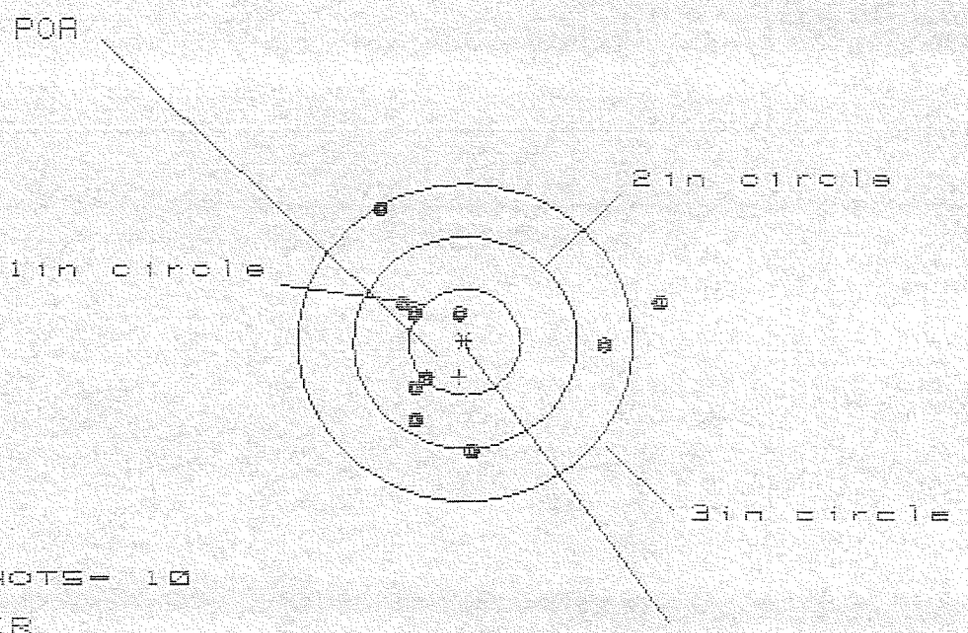
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0326
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .035479

THE AMR FOR THIS RIFLE IS: .9216

24 May 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C8345157

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

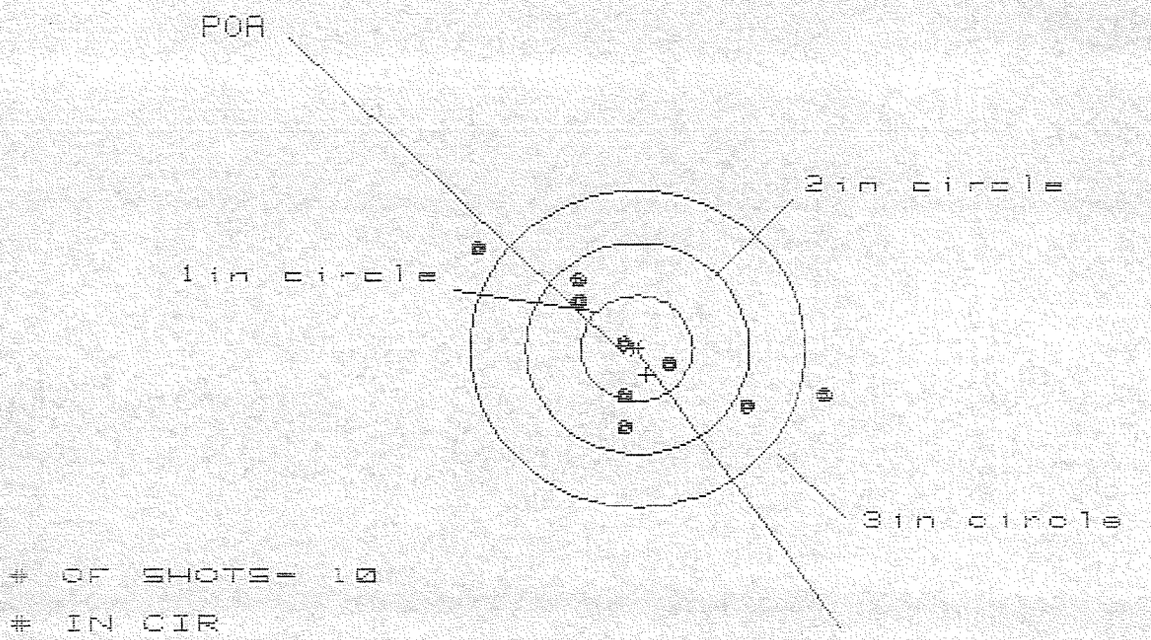
# IN CIR	
1in =	1
2in =	6
3in =	9

HS= 2.556
VS= 2.246
GS= 2.701

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.784	1.481	1.409
MINIMUM X	:	-.772	-.573	-.400
MAXIMUM Y	:	1.226	1.266	.578
MINIMUM Y	:	-1.020	-.980	-.822
CENTROID X	:	.054	-.145	-.073
CENTROID Y	:	.330	.290	.132
POA TO CENTROID in.	:	.334	.324	.151
MIN RADIUS	:	.278	.356	.315
MEAN RADIUS	:	.906	.751	.671
MAX RADIUS	:	1.819	1.481	1.415
HORIZONTAL SPREAD	:	2.556	2.054	1.809
VERTICAL SPREAD	:	2.246	2.246	1.400
EXTREME SPREAD	:	2.701	2.425	1.863
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

24 May 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6345157

CENTERFIRE PATTERNS # 2

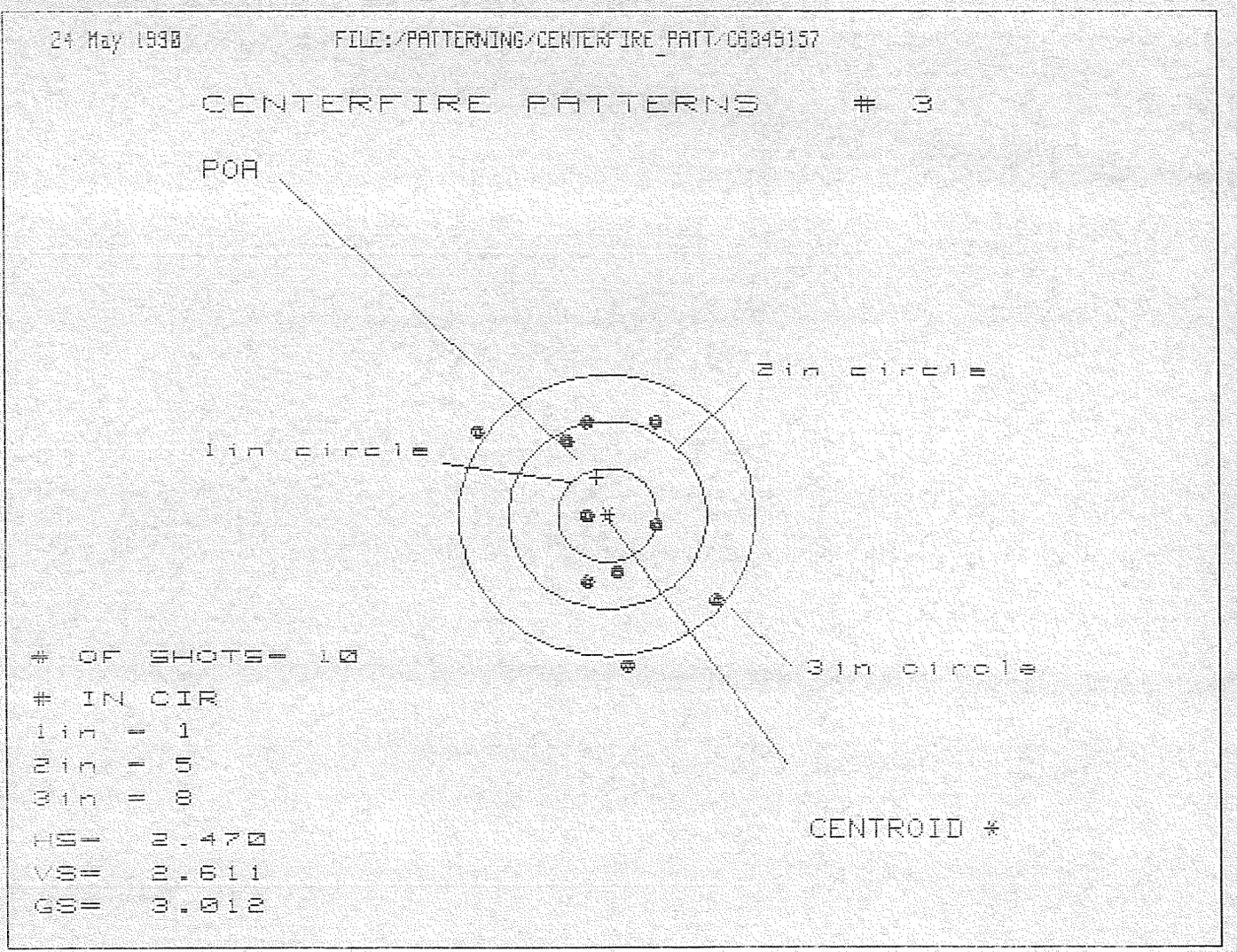


OF SHOTS= 10

# IN CIR	
1in =	4
2in =	7
3in =	8

HS=	3.071
VS=	1.717
GS=	3.375

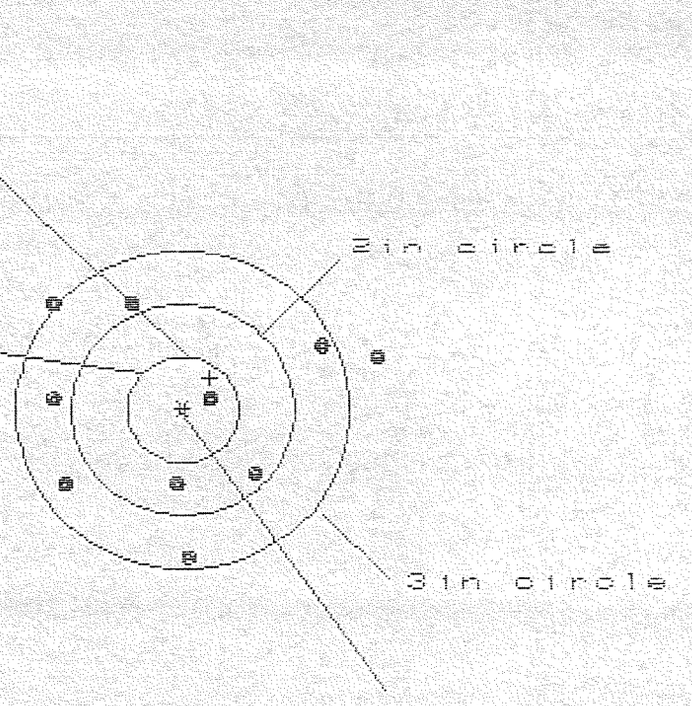
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.656	1.498	1.058
MINIMUM X	:	-1.415	-.718	-.530
MAXIMUM Y	:	.969	.782	.742
MINIMUM Y	:	-.748	-.641	-.681
CENTROID X	:	-.079	.079	-.109
CENTROID Y	:	.248	.141	.181
POA TO CENTROID in.	:	.261	.161	.211
MIN RADIUS	:	.149	.104	.166
MEAN RADIUS	:	.794	.703	.559
MAX RADIUS	:	1.715	1.533	1.144
HORIZONTAL SPREAD	:	3.071	2.216	1.588
VERTICAL SPREAD	:	1.717	1.423	1.423
EXTREME SPREAD	:	3.375	2.410	1.917
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.126	.977	.977
MINIMUM X	:	-1.344	-.579	-.580
MAXIMUM Y	:	1.023	1.119	.933
MINIMUM Y	:	-1.588	-1.492	-.949
CENTROID X	:	.109	.258	.259
CENTROID Y	:	-.396	-.492	-.306
POA TO CENTROID in.	:	.411	.556	.400
MIN RADIUS	:	.180	.351	.331
MEAN RADIUS	:	.964	.887	.808
MAX RADIUS	:	1.598	1.492	1.362
HORIZONTAL SPREAD	:	2.470	1.556	1.556
VERTICAL SPREAD	:	2.611	2.611	1.882
EXTREME SPREAD	:	3.012	2.633	2.286
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

24 May 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6345157

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

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

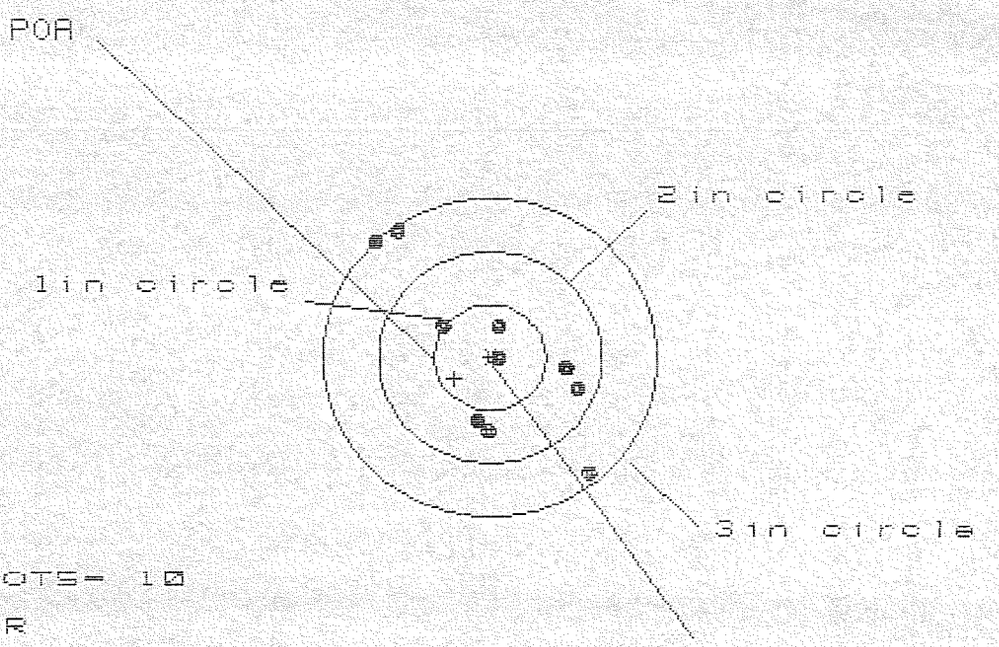
HS= 2.954
VS= 2.366
GS= 3.085

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.774	1.453	1.330
MINIMUM X	:	-1.180	-.983	-1.071
MAXIMUM Y	:	1.017	1.069	1.188
MINIMUM Y	:	-1.349	-1.297	-1.163
CENTROID X	:	-.244	-.441	-.318
CENTROID Y	:	-.308	-.360	-.494
POA TO CENTROID in.	:	.392	.569	.587
MIN RADIUS	:	.237	.439	.407
MEAN RADIUS	:	1.146	1.065	.991
MAX RADIUS	:	1.835	1.584	1.534
HORIZONTAL SPREAD	:	2.954	2.436	2.401
VERTICAL SPREAD	:	2.366	2.366	2.351
EXTREME SPREAD	:	3.085	2.667	2.659

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 3
NUMBER IN THREE INCH CIRCLE = 8

24 May 1930 FILE:/PATTERNING/CENTERFIRE_PATT/08349157

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 2
2in = 7
3in = 9

HS= 1.916
VS= 2.247
GS= 2.921

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.860	.743	.630
MINIMUM X	:	-1.056	-.900	-.663
MAXIMUM Y	:	1.162	1.286	.597
MINIMUM Y	:	-1.085	-.961	-.800
CENTROID X	:	.323	.440	.553
CENTROID Y	:	.196	.072	-.089
POA TO CENTROID in.	:	.378	.446	.560
MIN RADIUS	:	.048	.141	.337
MEAN RADIUS	:	.798	.705	.592
MAX RADIUS	:	1.539	1.570	1.018
HORIZONTAL SPREAD	:	1.916	1.643	1.293
VERTICAL SPREAD	:	2.247	2.247	1.397
EXTREME SPREAD	:	2.921	2.784	1.904

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 9