

C6522274

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CAR TCC

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522274

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	RB
600	Proof		8-21-90	RB
607	Check Headspace		8-21-90	RB
610	Dis-assemble Gun		8-21-90	RB
612	Magnaflux Barrel Action	NEW BARREL 8/22/90	8/23/90	KCR
	Magnaflux Bolt		8/24/90	KCR
615	Rollmark Caliber		8/23/90	ES.
617	Drill and Tap Sight Holes		8/23/90	RB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
605 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			9/13/90	W.B
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9/13/90	W.B
	H) Trigger Pull Test & Retainability						9/13/90	W.B
	I) Firing Pin Indent	.0215	.022	.022			9/13/90	W.B
	J) Assemble Stock						9/14/90	RW
	K) Assemble Swivel Studs						9/16/90	928
	L) Attach Front and Rear Sight Assemblies						9/14/90	RW
	M) Iron Sight Alignment						9/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/14/90	RW
	O) Attach Scope to Rifle						9/14/90	RW
	P) Detach & Attach Scope 20 Times						9/14/90	RW
640	Gallery Target & Test						9-15-90	DH
	A) Time						9-15-90	DH
	B) Malfunctions						9-15-90	DH
	C) Pierced Primers						9-15-90	DH
	D) Optical Clarity of Scope						9-15-90	DH
645	Inspect for Live Ammo						9-15-90	DH
655	Final Inspection							
	A) Headspace						9/16/90	928
	B) Trigger Pull	2.54	2.49	2.50	2.51	2.57	9-16-90	928
	C) Function						9/16/90	928
660	Pack						9/19/90	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522274
DATE 9/12/90
TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.38	2.20	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.53	2.43	2.49	
PULL #3	2.27	2.52	2.38	2.50	
PULL #4	2.27	2.51	2.48	2.51	
PULL #5	2.25	2.41	2.30	2.57	
TOTAL	11.38	12.35	11.79	12.61	
AVG.	2.28	2.47	2.36	2.522	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.33		HAD TROUBLE SETTING DOWN TRIGGER SETTING RE-ARMED HOLE & FILED SPRING
PULL #2	3.23	3.24		
PULL #3	3.30	3.20		
PULL #4	3.24	3.28		
PULL #5	3.40	3.12		
TOTAL	16.34	16.17		
AVG.	3.27	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.06		4.16
PULL #2	4.00	4.08		4.07
PULL #3	4.02	4.00		4.05
PULL #4	4.03	4.03		4.09
PULL #5	4.09	4.01		4.07
TOTAL	20.16	20.18		20.44
AVG.	4.03	4.04		4.09

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522274
15 Sep 1990

CENTROIDAL DISTANCES

0	TO	1	.664606
1	TO	2	1.49932
1	TO	3	.891409
1	TO	4	.511544
1	TO	5	.235669

4+ (----POA
15 3
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0504
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4376
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .440493

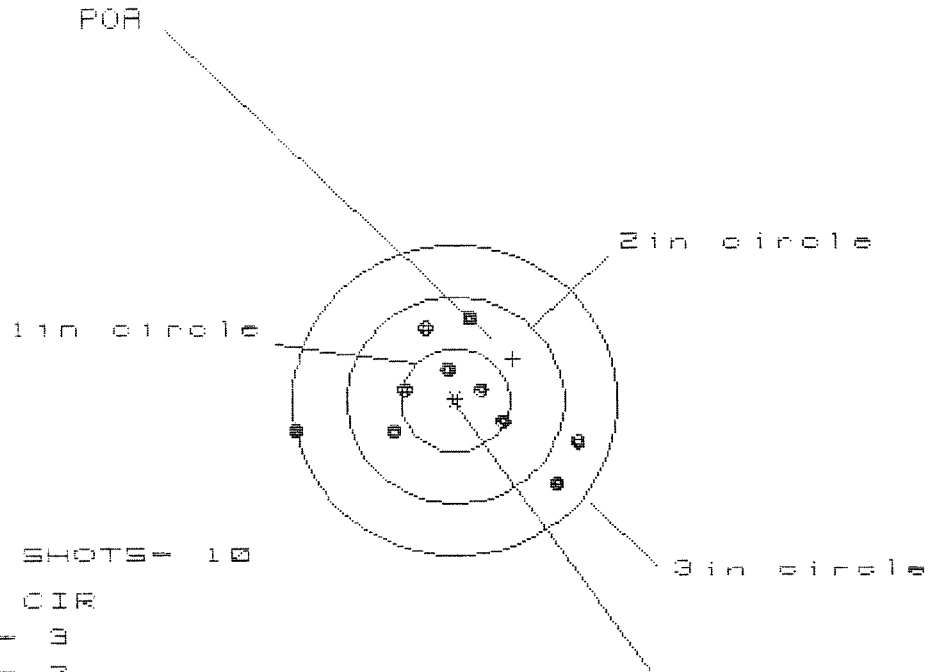
THE AMR FOR THIS RIFLE IS: .7836

15 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522274

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.599

VS= 1.598

GS= 2.603

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.107	.941	1.038
MINIMUM X	-1.492	-.708	-.611
MAXIMUM Y	.780	.748	.641
MINIMUM Y	-.818	-.850	-.587
CENTROID X	-.530	-.364	-.461
CENTROID Y	-.401	-.369	-.262
POA TO CENTROID in.	.665	.518	.530
MIN RADIUS	.262	.096	.187
MEAN RADIUS	.764	.663	.583
MAX RADIUS	1.521	1.148	1.192
HORIZONTAL SPREAD	2.599	1.649	1.649
VERTICAL SPREAD	1.598	1.598	1.228
EXTREME SPREAD	2.603	1.965	1.821
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

15 Sep 1998

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.597

VS= 2.633

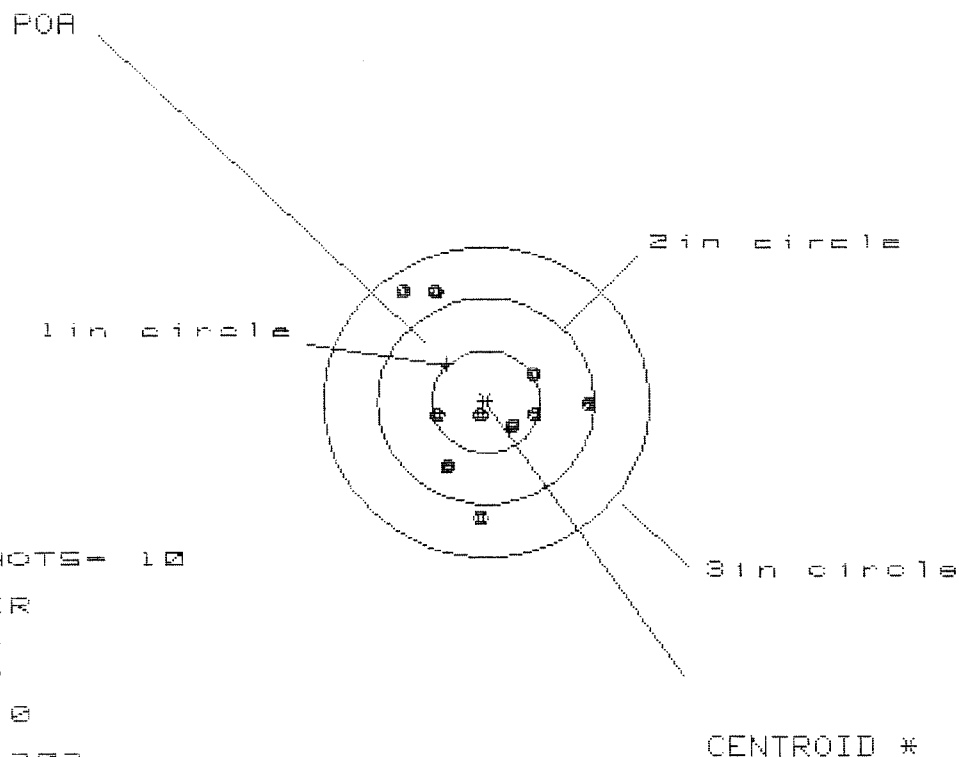
GS= 2.823

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.813	.801	.835
MINIMUM X	:	-.884	-.682	-.648
MAXIMUM Y	:	1.230	1.321	1.157
MINIMUM Y	:	-1.403	-1.312	-.792
CENTROID X	:	.903	.701	.667
CENTROID Y	:	-.842	-.933	-.769
POA TO CENTROID in.	:	1.235	1.168	1.019
MIN RADIUS	:	.255	.138	.039
MEAN RADIUS	:	.943	.760	.662
MAX RADIUS	:	1.989	1.545	1.427
HORIZONTAL SPREAD	:	2.697	1.483	1.483
VERTICAL SPREAD	:	2.633	2.633	1.949
EXTREME SPREAD	:	2.823	2.686	2.027
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.707

VS= 2.159

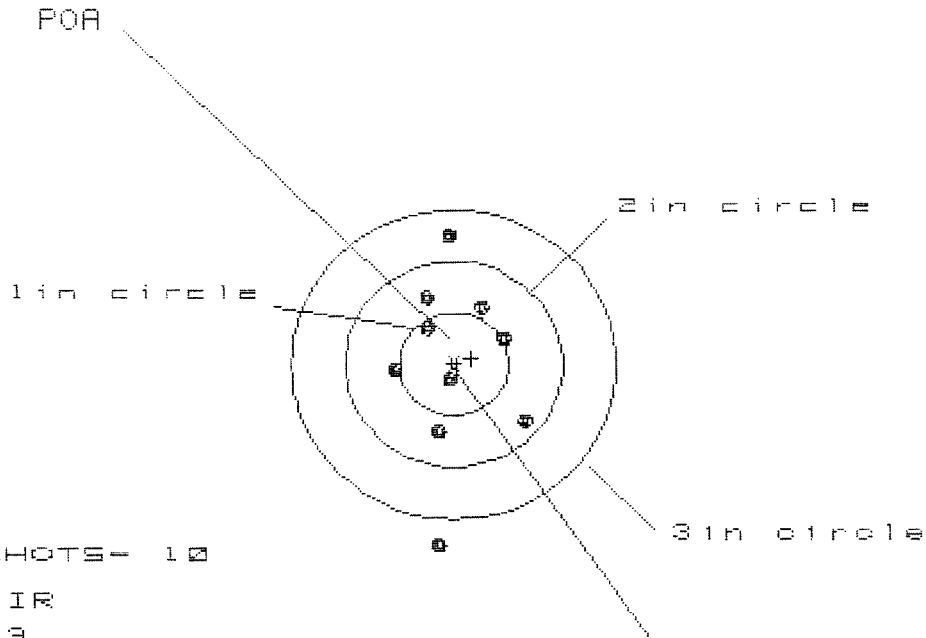
GS= 2.259

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.980	.899	.882
MINIMUM X	:	-.727	-.505	-.522
MAXIMUM Y	:	1.039	1.155	1.029
MINIMUM Y	:	-1.120	-1.004	-.651
CENTROID X	:	.361	.442	.459
CENTROID Y	:	-.374	-.490	-.364
POA TO CENTROID in.	:	.520	.659	.585
MIN RADIUS	:	.169	.166	.239
MEAN RADIUS	:	.710	.621	.579
MAX RADIUS	:	1.267	1.255	1.148
HORIZONTAL SPREAD	:	1.707	1.404	1.404
VERTICAL SPREAD	:	2.159	2.159	1.680
EXTREME SPREAD	:	2.259	2.188	1.739
NUMBER IN ONE INCH CIRCLE	=		4	
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 = 3

2 in = 8

3 in = 9

HS= 1.204

VS= 2.951

GS= 2.955

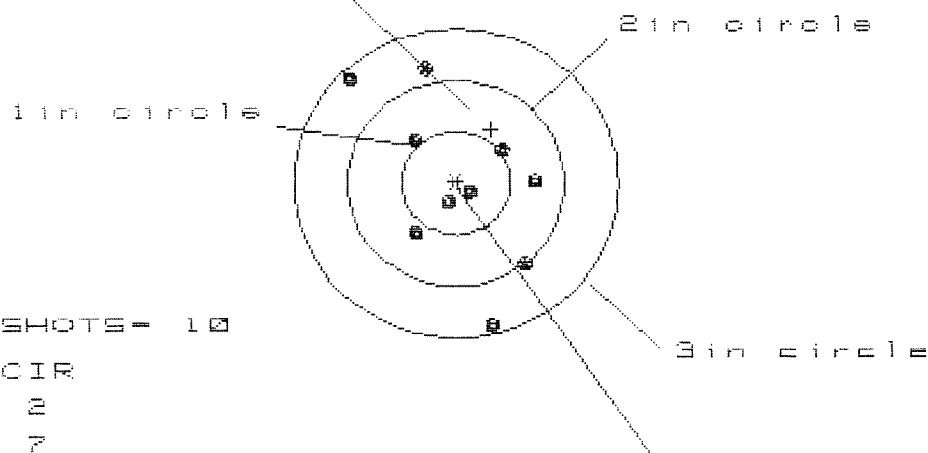
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.676
MINIMUM X	-.528
MAXIMUM Y	1.242
MINIMUM Y	-1.709
CENTROID X	-.156
CENTROID Y	-.052
POA TO CENTROID in.	.164
MIN RADIUS	.149
MEAN RADIUS	.740
MAX RADIUS	1.716
HORIZONTAL SPREAD	1.204
VERTICAL SPREAD	2.951
EXTREME SPREAD	2.955
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.685

VS= 2.466

GS= 2.723

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.706
MINIMUM X	-.979
MAXIMUM Y	1.079
MINIMUM Y	-1.387
CENTROID X	-.326
CENTROID Y	-.519
POA TO CENTROID in.	.613
MIN RADIUS	.117
MEAN RADIUS	.761
MAX RADIUS	1.422
HORIZONTAL SPREAD	1.685
VERTICAL SPREAD	2.466
EXTREME SPREAD	2.723
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

Remington®



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

MODEL 700™ H24

SERIAL NO.

C6522274

ORDER NO.

5716

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

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5716 C6522274

UPC



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