

C6522253

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

CC522253

BDS
BBLNEW
BBL

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KA
600	Proof		6/24/90	KA
607	Check Headspace		6/24/90	KA
610	Dis-assemble Gun		6/24/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	ES
617	Drill and Tap Sight Holes		8/10/90	ES
618	Polish Barrel		8/10/90	ES
620	Apply Coatings (Barrel Action)		8/22/90	KA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/23/90	ES
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/90	ES
	C) Inspect Ejector Hole for Chamfer		8/23/90	ES
	D) Oil Firing Pin Ass'y		8/23/90	ES
	E) Adjust Trigger Pull to Min Setting and Stake		8/24/90	GU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 1/4	5			8/24/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/24/90	WB
	H) Trigger Pull Test & Retainability						8/24/90	AL
	I) Firing Pin Indent	.023	.023	.023			8/24/90	WB
	J) Assemble Stock						8/24/90	KS
	K) Assemble Swivel Studs						8/30/90	GS
	L) Attach Front and Rear Sight Assemblies						8/24/90	KS
	M) Iron Sight Alignment						8/24/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	KS
	O) Attach Scope to Rifle						8/24/90	KS
	P) Detach & Attach Scope 20 Times						8/24/90	KS
640	Gallery Target & Test						8-25-90	DH
	A) Time						8-25-90	DH
	B) Malfunctions						8-25-90	DH
	C) Pierced Primers						8-25-90	DH
	D) Optical Clarity of Scope						8-25-90	DH
645	Inspect for Live Ammo						8-25-90	DH
655	Final Inspection							
	A) Headspace						8/30/90	GS
	B) Trigger Pull	2.12	2.13	2.15	2.15	2.18	8/30/90	AL
	C) Function						8/30/90	GS
660	Pack						9/20/90	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6522253

DATE 8/24/90

TESTER JLI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.20	2.33	2.12	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.25	2.15	2.13	
PULL #3	2.25	2.08	2.20	2.15	
PULL #4	2.25	2.26	2.10	2.15	
PULL #5	2.22	2.14	2.25	2.18	
TOTAL	11.35	10.93	11.03	10.73	
AVG.	2.27	2.186	2.206	2.146	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.19		
PULL #2	3.19	3.16		
PULL #3	3.15	3.15		
PULL #4	3.16	3.19		
PULL #5	3.20	3.15		
TOTAL	15.88	15.84		
AVG.	3.176	3.168		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.10		4.12
PULL #2	4.18	4.17		4.18
PULL #3	4.14	4.18		4.16
PULL #4	4.16	4.08		4.20
PULL #5	4.14	4.16		4.14
TOTAL	20.80	20.69		20.80
AVG.	4.16	4.138		4.16

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6522253
 25 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.534176
1 TO	2	.692755
1 TO	3	.220989
1 TO	4	.21836
1 TO	5	.435894

$\frac{5}{34} +$ <----POA
 2

THIS RIFLE IS: -.3388
 THIS RIFLE IS: -.0888
 TIME FOR THIS RIFLE IS: .350244

11118

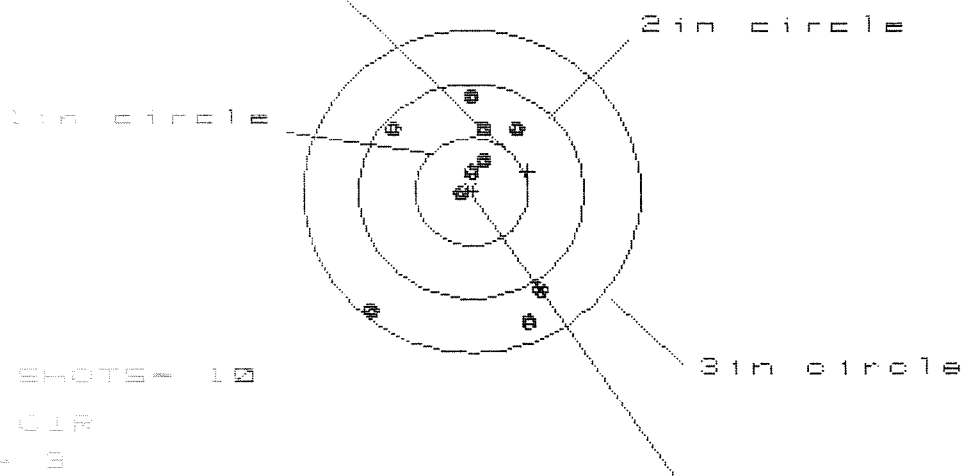
25 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522253

CENTERFIRE PATTERNS

1

FOR



NO OF SHOTS- 10

1 IN CIR

2 IN CIR

3 IN CIR

4 IN CIR

5 IN CIR

6 IN CIR

7 IN CIR

8 IN CIR

9 IN CIR

10 IN CIR

CENTROID #

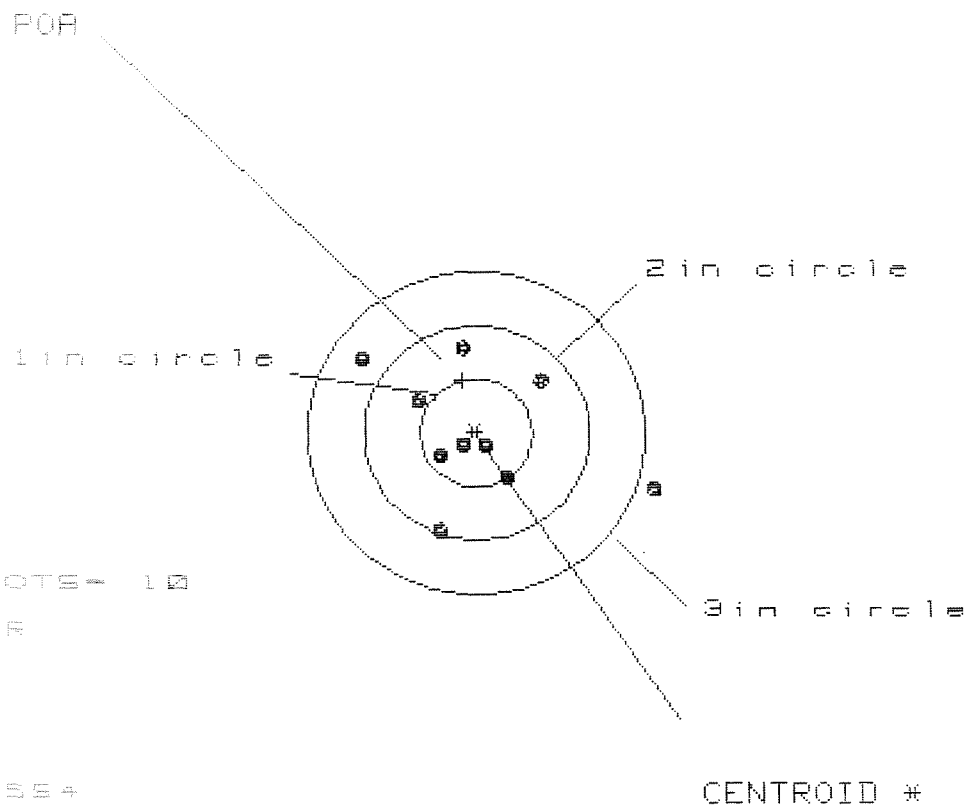
PATTERN #	1	2	3
SHOTS (LESS 10)	10	9	8
MAXIMUM	.640	.543	.589
MINIMUM	-.875	-.769	-.723
MAXIMUM	.925	.806	.641
MINIMUM	-1.197	-1.316	-1.198
CENTROID	-.500	-.403	-.449
CENTROID	-.188	-.069	.096
10 IN CIRCLE	.535	.409	.459
9 IN CIRCLE	.893	.139	.037
8 IN CIRCLE	.748	.646	.500
7 IN CIRCLE	1.386	1.365	1.334
HORIZONTAL SPREAD	1.515	1.312	1.312
VERTICAL SPREAD	2.122	2.122	1.839

EXTREME SPREAD	2.168	2.169	2.002
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

25 Aug 1980

FILE:/PATTERNING/CENTERFIRE_PATT/08522253

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

ME = 2.554

MS = 1.666

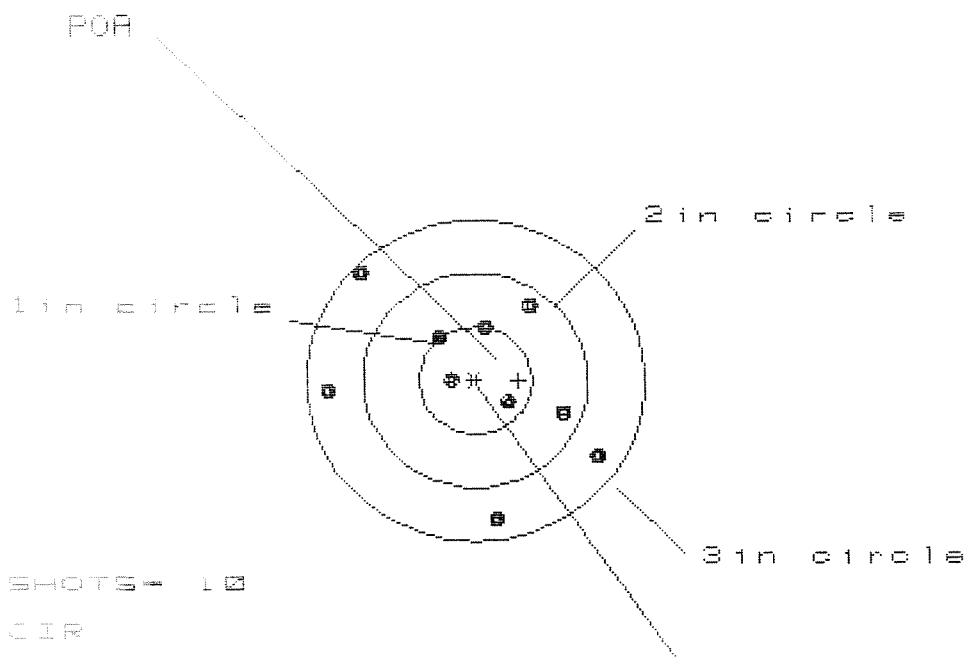
GS = 2.885

PATTERN #	:	2		
SPOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.585	.763	.659
MINIMUM X	:	-1.009	-.833	-.461
MAXIMUM Y	:	.827	.766	.847
MINIMUM Y	:	-.869	-.930	-.849
CENTROID X	:	.122	-.054	.050
CENTROID Y	:	-.493	-.432	-.513
ACP TO CENTROID (in)	:	.508	.435	.516
MIN RADIUS	:	.099	.172	.126
MEAN RADIUS	:	.724	.611	.531
MSD RADIUS	:	1.678	1.057	.896
HORIZONTAL SPREAD	:	2.594	1.596	1.120
VERTICAL SPREAD	:	1.696	1.696	1.696
EXTREME SPREAD	:	2.885	1.716	1.712
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

25 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522253

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

CENTROID #

10 = 2.348

20 = 2.225

30 = 2.663

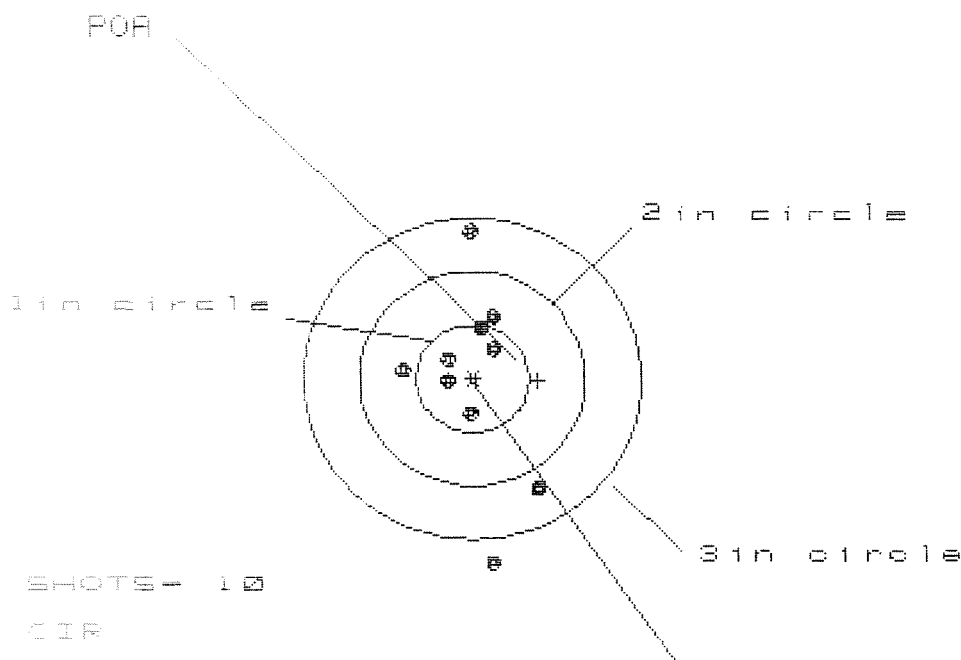
PATTERN # 4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.047	.928	.751
MINIMUM X	-1.301	-1.420	-.609
MAXIMUM Y	.962	.841	.848
MINIMUM Y	-1.263	-1.156	-1.149
CENTROID X	-.384	-.265	-.088
CENTROID Y	-.003	-.110	-.117
POA TO CENTROID INCH	.384	.287	.146
MIN RADIUS	.219	.235	.104
MEAN RADIUS	.856	.788	.690
MAX RADIUS	1.434	1.421	1.154
HORIZONTAL SPREAD	2.348	2.348	1.360
VERTICAL SPREAD	2.225	1.997	1.997
EXTREME SPREAD	2.663	2.426	2.025
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

25 Aug 1980

FILE:/PATTERNING/CENTERFIRE_PATT/C6522253

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 7

3 in = 8

HS = 1.2002

VS = 2.045

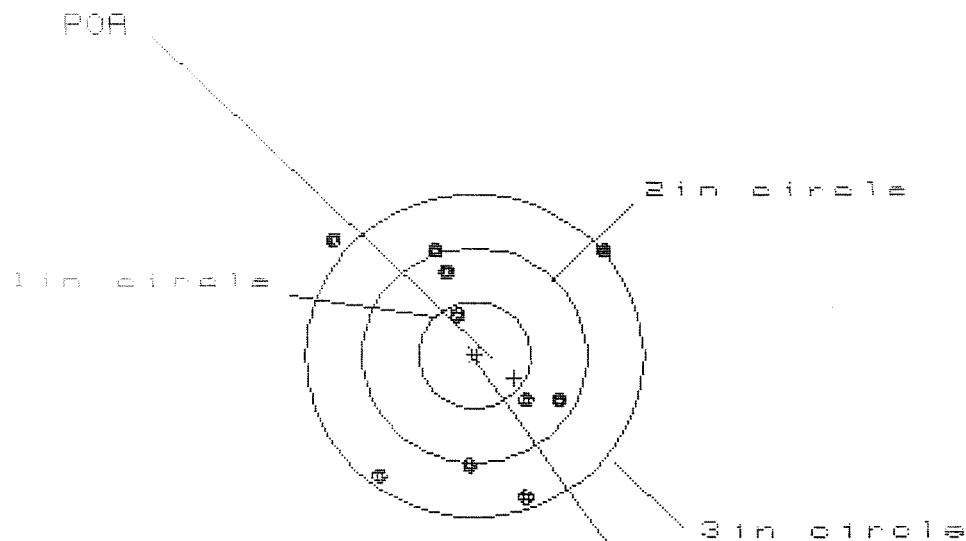
GS = 3.052

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.621	.640	.638
MINIMUM X	:	-.661	-.642	-.644
MAXIMUM Y	:	1.367	1.181	.542
MINIMUM Y	:	-1.678	-1.232	-1.085
CENTROID X	:	-.580	-.599	-.597
CENTROID Y	:	.018	.204	.057
POA TO CENTROID in.	:	.580	.633	.600
MIN RADIUS	:	.232	.173	.217
MEAN RADIUS	:	.712	.560	.497
MAX RADIUS	:	1.686	1.389	1.258
HORIZONTAL SPREAD	:	1.282	1.282	1.282
VERTICAL SPREAD	:	3.045	2.413	1.627
EXTREME SPREAD	:	3.052	2.501	1.726
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

25 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522253

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

SE= 2.403

VE= 2.423

GE= 2.973

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.135	.994	.781
MINIMUM X	-1.268	-.994	-.870
MAXIMUM Y	1.115	1.134	1.257
MINIMUM Y	-1.308	-1.185	-1.043
CENTROID X	-.352	-.211	-.335
CENTROID Y	.222	.098	-.044
POA TO CENTROID (in)	.416	.233	.338
MIN RADIUS	.346	.405	.449
MEAN RADIUS	1.069	.984	.914
MAX RADIUS	1.688	1.508	1.301
HORIZONTAL SPREAD	2.403	1.988	1.651
VERTICAL SPREAD	2.423	2.319	2.300
EXTREME SPREAD	2.973	2.909	2.426
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	




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

MODEL 700™ H24

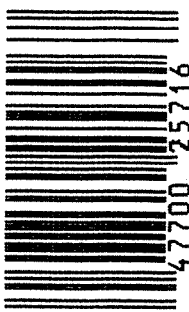
SERIAL NO.
C6522253

ORDER NO.
5716

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

Ø1

UPC



0 47700 25716 7



5716 C6522253