

C6522221

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

2.04

2.16

2.16

2.11

2.05

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522221

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/7/90	KR.
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	KR
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	QA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/6/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/6/90	WB
	C) Inspect Ejector Hole for Chamfer		9/6/90	WB
	D) Oil Firing Pin Ass'y		9/6/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/6/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			9/6/90	WB
	H) Trigger Pull Test & Retainability						9/6/90	WB
	I) Firing Pin Indent	.020 .022	.020 .022	.0205 .022			9/6/90	WB
	J) Assemble Stock						9/7/90	KS
	K) Assemble Swivel Studs						9/7/90	JS
	L) Attach Front and Rear Sight Assemblies						9/7/90	KS
	M) Iron Sight Alignment						9/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/7/90	KS
	O) Attach Scope to Rifle						9/7/90	KS
	P) Detach & Attach Scope 20 Times						9/7/90	KS
640	Gallery Target & Test						9-10-90	AC
	A) Time						9-10-90	AC
	B) Malfunctions						9-10-90	AC
	C) Pierced Primers						9-10-90	AC
	D) Optical Clarity of Scope						9-10-90	AC
645	Inspect for Live Ammo						9-10-90	AC
655	Final Inspection							
	A) Headspace						9/11/90	JS
	B) Trigger Pull	2.39	2.35	2.29	2.33	2.32	9/10/90	WB
	C) Function						9/11/90	JS
660	Pack						9-18-90	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522221DATE 9/6/90TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.51	2.56	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.30	2.62	2.35	
PULL #3	2.55	2.52	2.67	2.29	
PULL #4	2.38	2.52	2.64	2.33	
PULL #5	2.54	2.53	2.60	2.32	
TOTAL	12.50	12.38	13.09	11.68	
AVG.	2.50	2.47	2.62	2.33	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.21		
PULL #2	3.07	3.22		
PULL #3	3.13	3.07		
PULL #4	3.11	3.15		
PULL #5	3.14	3.13		
TOTAL	15.55	15.78		
AVG.	3.11	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.27		4.21
PULL #2	4.22	4.23		4.19
PULL #3	4.26	4.11		4.18
PULL #4	4.18	4.23		4.14
PULL #5	4.16	4.12		4.05
TOTAL	21.08	20.96		20.77
AVG.	4.21	4.19		4.15

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522221
10 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.521061
1 TO	2	.484517
1 TO	3	.66897
1 TO	4	.611788
1 TO	5	.746294

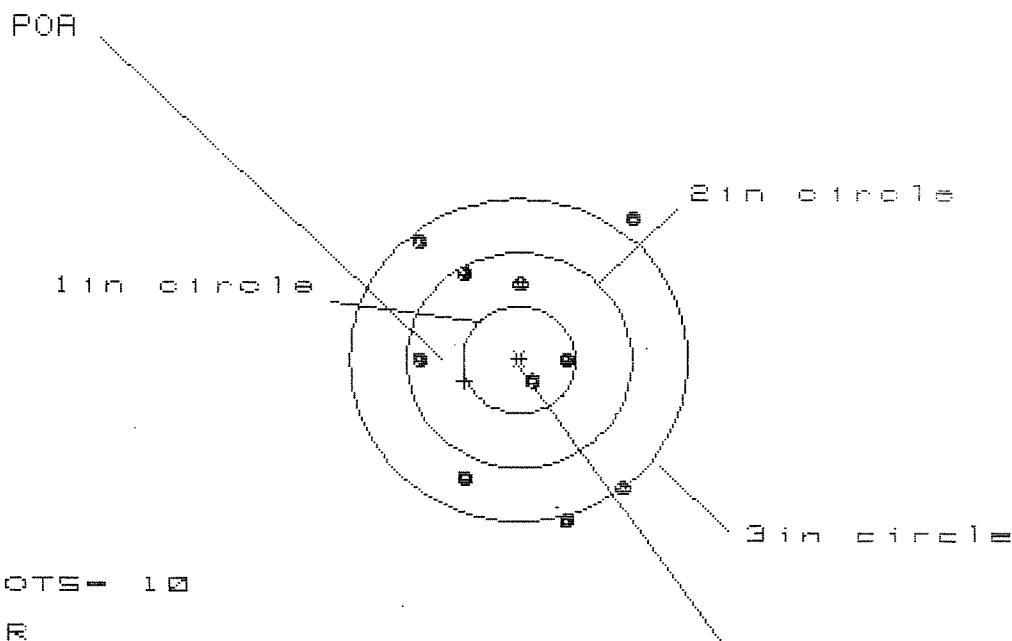
5
3 1
2 4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0156
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117441
THE AMR FOR THIS RIFLE IS: 1.065

18 Sep 1998

FILE: \PATTERNING\CENTERFIRE_PATT\08522221

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.923

VS= 2.736

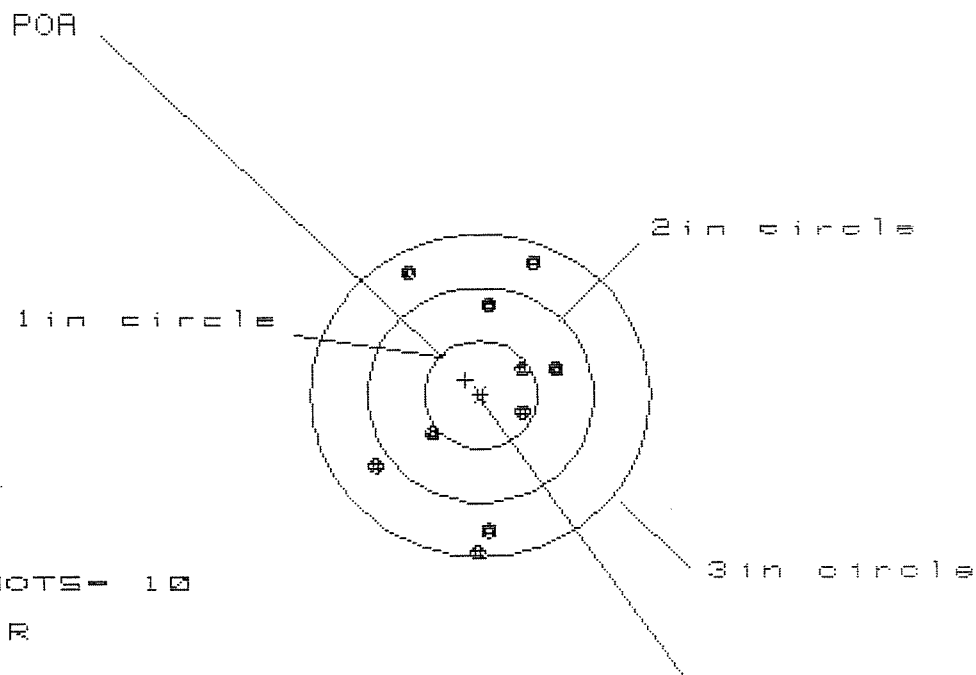
GS= 2.902

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.990	1.046	1.111
MINIMUM X	:	-.933	-.823	-.758
MAXIMUM Y	:	1.287	1.212	1.048
MINIMUM Y	:	-1.449	-1.306	-1.176
CENTROID X	:	.484	.374	.309
CENTROID Y	:	.193	.050	.214
POA TO CENTROID in.	:	.522	.378	.376
MIN RADIUS	:	.199	.185	.320
MEAN RADIUS	:	1.037	.970	.904
MAX RADIUS	:	1.623	1.463	1.617
HORIZONTAL SPREAD	:	1.923	1.869	1.869
VERTICAL SPREAD	:	2.736	2.518	2.224
EXTREME SPREAD	:	2.902	2.902	2.902
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522221

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 1.667

VS= 2.675

GS= 2.719

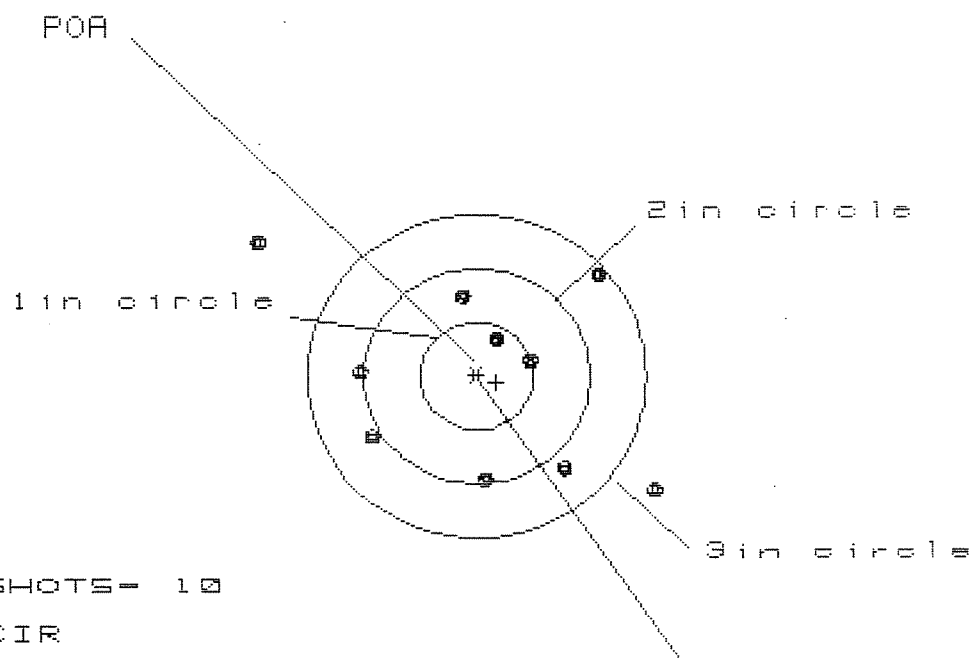
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.701	.695	.748
MINIMUM X	:	-.966	-.972	-.919
MAXIMUM Y	:	1.265	1.109	1.158
MINIMUM Y	:	-1.410	-1.376	-1.238
CENTROID X	:	.133	.139	.086
CENTROID Y	:	-.141	.015	-.123
POA TO CENTROID in.	:	.194	.140	.150
MIN RADIUS	:	.375	.337	.425
MEAN RADIUS	:	.937	.873	.833
MAX RADIUS	:	1.411	1.378	1.276
HORIZONTAL SPREAD	:	1.667	1.667	1.667
VERTICAL SPREAD	:	2.675	2.485	2.396
EXTREME SPREAD	:	2.719	2.510	2.485
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522221

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.541

VS= 2.372

GS= 4.262

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.394	.994
MINIMUM X	:	-1.932	-1.225	-1.051
MAXIMUM Y	:	1.280	1.073	.954
MINIMUM Y	:	-1.092	-.950	-.926
CENTROID X	:	-.171	.044	-.130
CENTROID Y	:	.057	-.085	.034
POA TO CENTROID in.	:	.180	.095	.135
MIN RADIUS	:	.366	.340	.370
MEAN RADIUS	:	1.146	1.003	.898
MAX RADIUS	:	2.318	1.687	1.378
HORIZONTAL SPREAD	:	3.541	2.619	2.045
VERTICAL SPREAD	:	2.372	2.023	1.880
EXTREME SPREAD	:	4.262	2.847	2.469
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8522221

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.649

VS= 3.150

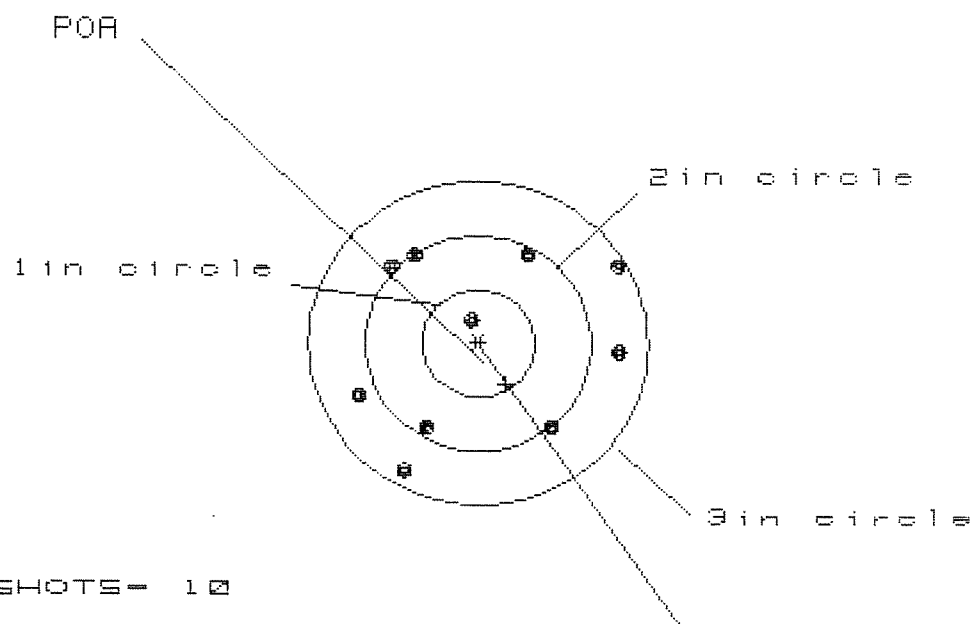
GS= 3.407

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.475	1.554	1.491
MINIMUM X	:	-1.174	-1.095	-1.158
MAXIMUM Y	:	1.554	1.367	1.189
MINIMUM Y	:	-1.596	-1.423	-1.055
CENTROID X	:	.375	.296	.359
CENTROID Y	:	-.409	-.582	-.404
POA TO CENTROID in.	:	.555	.653	.541
MIN RADIUS	:	.453	.298	.437
MEAN RADIUS	:	1.157	1.055	1.018
MAX RADIUS	:	1.708	1.624	1.493
HORIZONTAL SPREAD	:	2.649	2.649	2.649
VERTICAL SPREAD	:	3.150	2.790	2.244
EXTREME SPREAD	:	3.407	3.062	2.832
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/06522221

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.351

VS= 1.987

GS= 2.657

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.281	1.414	1.354
MINIMUM X	:	-1.070	-.937	-.997
MAXIMUM Y	:	.817	.902	.767
MINIMUM Y	:	-1.170	-1.085	-.869
CENTROID X	:	-.239	-.372	-.312
CENTROID Y	:	.378	.293	.428
POA TO CENTROID in.	:	.448	.474	.530
MIN RADIUS	:	.283	.354	.218
MEAN RADIUS	:	1.046	.996	.950
MAX RADIUS	:	1.425	1.415	1.364
HORIZONTAL SPREAD	:	2.351	2.351	2.351
VERTICAL SPREAD	:	1.987	1.987	1.636
EXTREME SPREAD	:	2.657	2.383	2.383
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522221
17 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.137644
1 TO	2	.518623
1 TO	3	.197517
1 TO	4	.217993
1 TO	5	.318198

24 <----POA

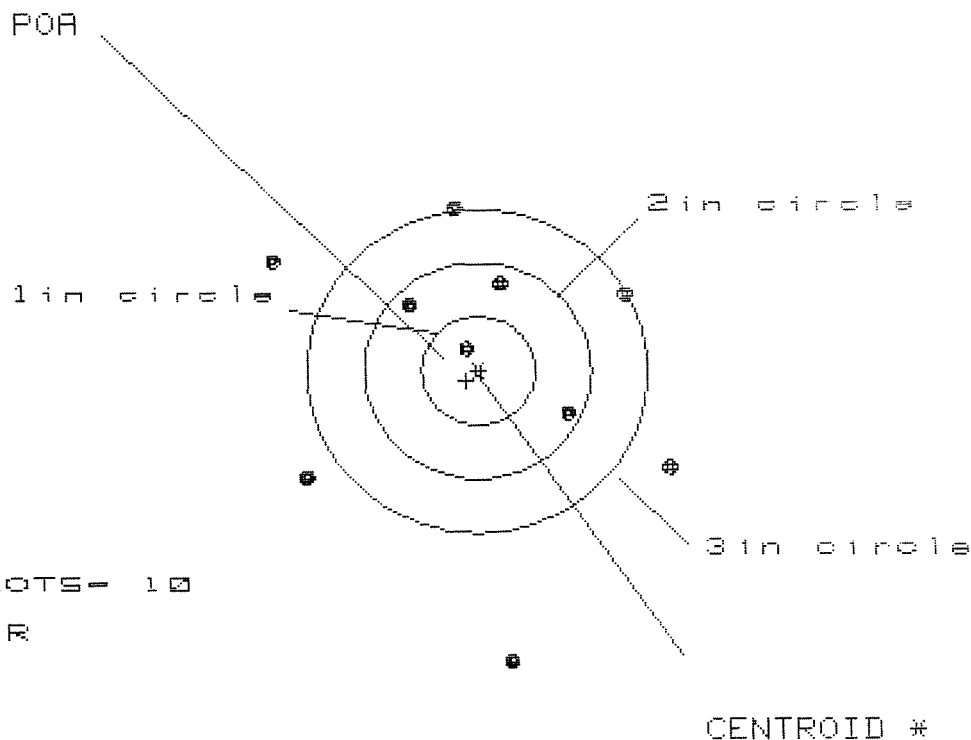
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0818
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0907943

THE AMR FOR THIS RIFLE IS: 1.131

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522221.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 3.437

VS= 4.212

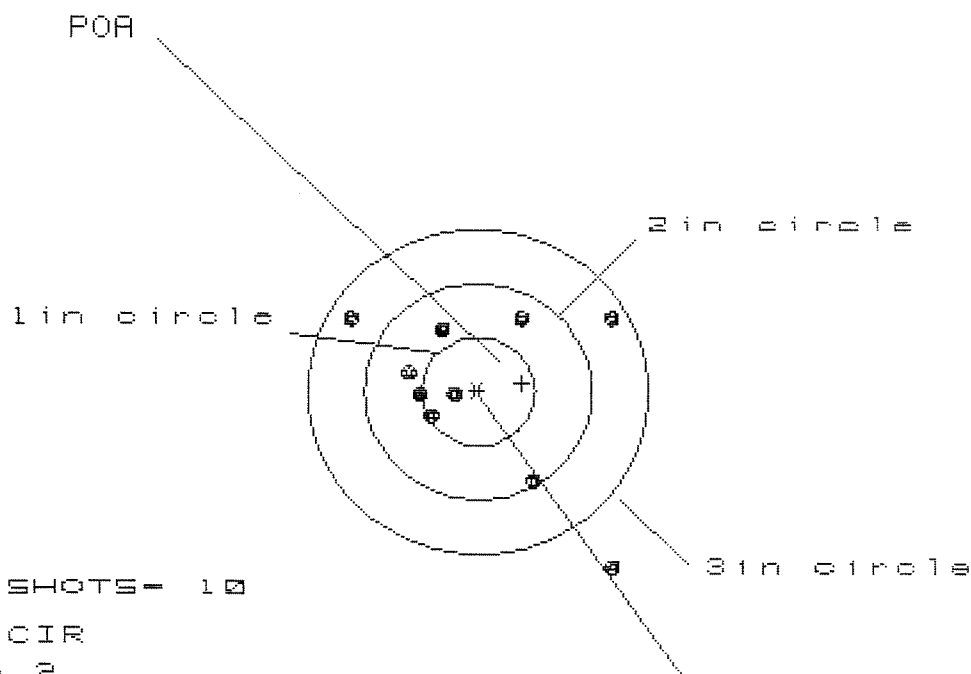
GS= 4.312

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.656	1.692	1.473
MINIMUM X	:	-1.781	-1.745	-1.663
MAXIMUM Y	:	1.508	1.207	1.302
MINIMUM Y	:	-2.704	-1.277	-1.182
CENTROID X	:	.105	.069	.288
CENTROID Y	:	.089	.390	.295
POA TO CENTROID in.	:	.138	.396	.412
MIN RADIUS	:	.262	.050	.246
MEAN RADIUS	:	1.418	1.193	1.119
MAX RADIUS	:	2.724	2.074	2.040
HORIZONTAL SPREAD	:	3.437	3.437	3.136
VERTICAL SPREAD	:	4.212	2.484	2.484
EXTREME SPREAD	:	4.312	3.956	3.239
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522221.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.340

VS= 2.243

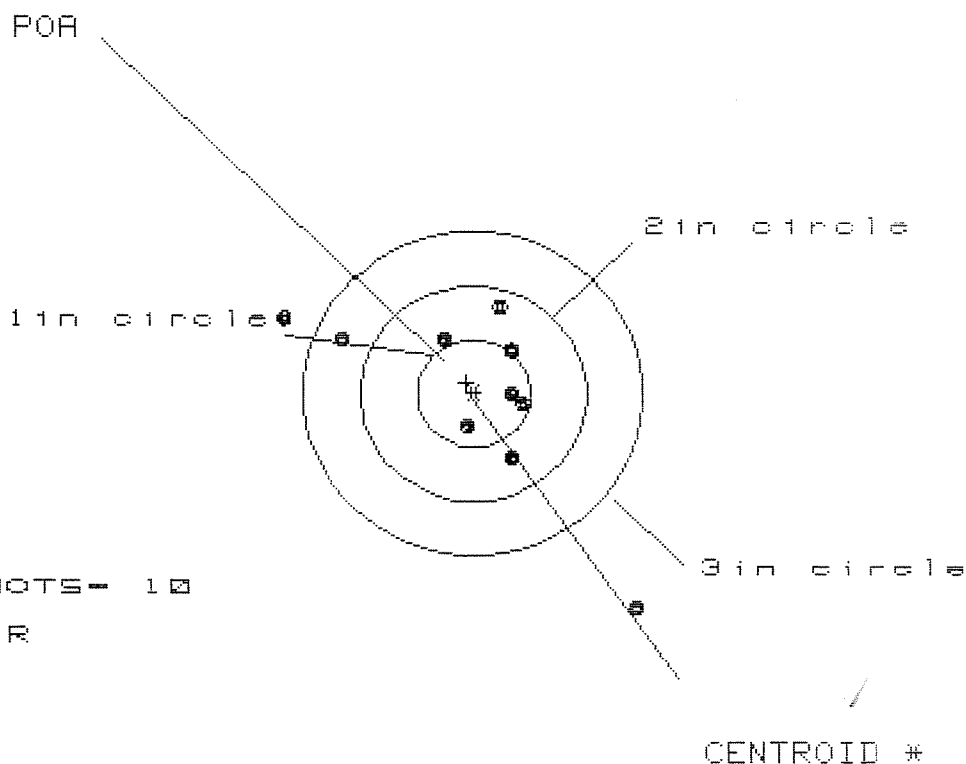
GS= 3.165

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.223	1.351	.758
MINIMUM X	:	-1.117	-.989	-.820
MAXIMUM Y	:	.670	.495	.555
MINIMUM Y	:	-1.573	-.963	-.903
CENTROID X	:	-.386	-.514	-.683
CENTROID Y	:	-.078	.097	.037
POA TO CENTROID in.	:	.394	.523	.684
MIN RADIUS	:	.220	.245	.189
MEAN RADIUS	:	.876	.712	.570
MAX RADIUS	:	1.950	1.434	1.179
HORIZONTAL SPREAD	:	2.340	2.340	1.578
VERTICAL SPREAD	:	2.243	1.458	1.458
EXTREME SPREAD	:	3.165	2.340	2.124
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522221.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.102

VS= 2.767

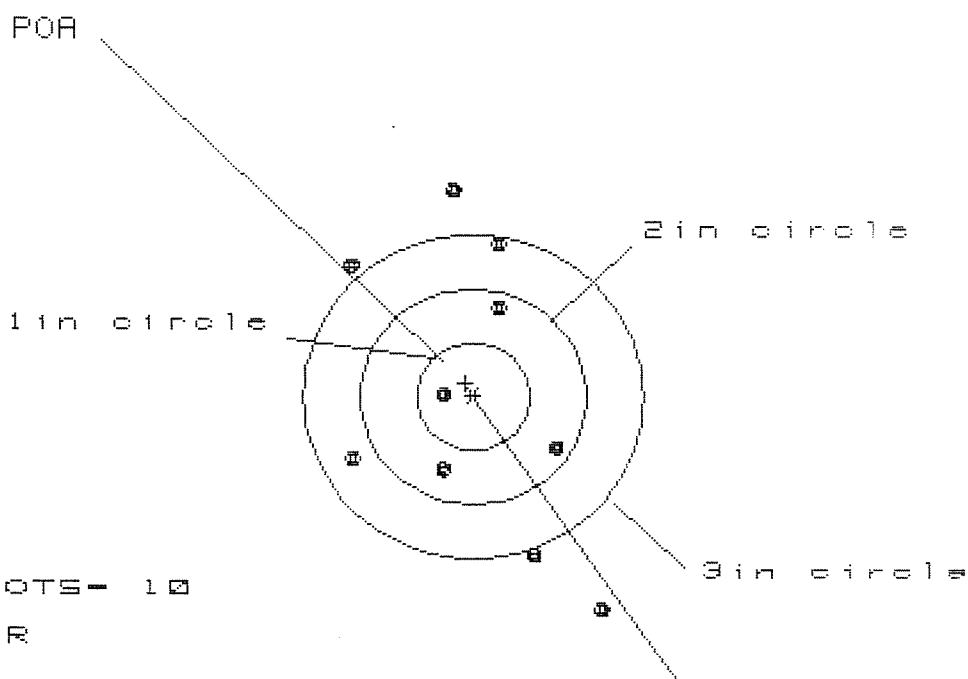
GS= 4.101

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.411	.614	.423
MINIMUM X	:	-1.691	-1.535	-1.165
MAXIMUM Y	:	.792	.573	.634
MINIMUM Y	:	-1.975	-.767	-.706
CENTROID X	:	.063	-.093	.098
CENTROID Y	:	-.104	.115	.054
POA TO CENTROID in.	:	.122	.148	.112
MIN RADIUS	:	.281	.312	.307
MEAN RADIUS	:	.907	.750	.585
MAX RADIUS	:	2.427	1.610	1.212
HORIZONTAL SPREAD	:	3.102	2.149	1.588
VERTICAL SPREAD	:	2.767	1.340	1.340
EXTREME SPREAD	:	4.101	2.369	1.783
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522221.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.220

VS= 3.906

GS= 4.133

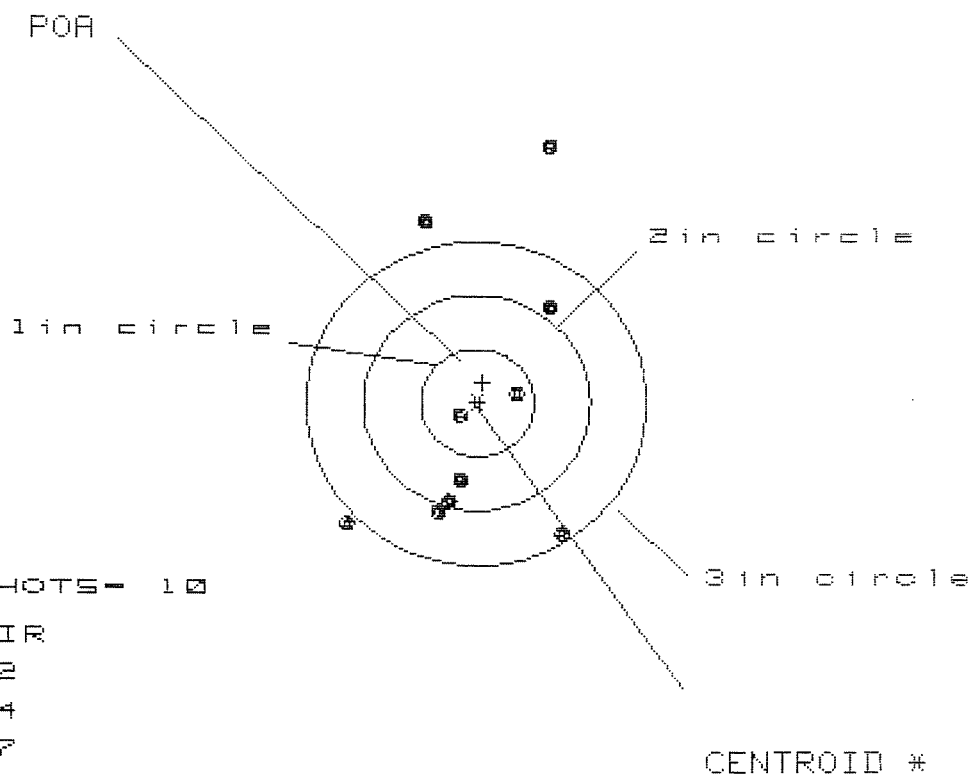
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	.907	.897
MINIMUM X	:	-1.071	-.943	-.953
MAXIMUM Y	:	1.885	1.661	1.362
MINIMUM Y	:	-2.021	-1.729	-1.522
CENTROID X	:	.069	-.059	-.050
CENTROID Y	:	-.126	.098	-.109
POA TO CENTROID in.	:	.144	.115	.120
MIN RADIUS	:	.290	.258	.171
MEAN RADIUS	:	1.292	1.158	1.072
MAX RADIUS	:	2.325	1.857	1.662
HORIZONTAL SPREAD	:	2.220	1.850	1.850
VERTICAL SPREAD	:	3.906	3.390	2.884
EXTREME SPREAD	:	4.133	3.472	3.144
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522221.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 1.871

VS= 3.593

GS= 3.926

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.762	.839	.792
MINIMUM X	:	-1.109	-1.032	-1.079
MAXIMUM Y	:	2.368	1.989	1.402
MINIMUM Y	:	-1.225	-.962	-.713
CENTROID X	:	-.048	-.125	-.078
CENTROID Y	:	-.190	-.453	-.702
POA TO CENTROID in.	:	.196	.470	.706
MIN RADIUS	:	.147	.182	.236
MEAN RADIUS	:	1.164	.965	.790
MAX RADIUS	:	2.468	2.025	1.550
HORIZONTAL SPREAD	:	1.871	1.871	1.871
VERTICAL SPREAD	:	3.593	2.951	2.115
EXTREME SPREAD	:	3.926	3.192	2.658
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6522221

ORDER NO.
5716

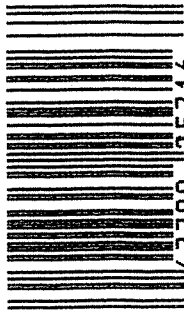
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5716 C6522221

UPC



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