

C6522218

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

can the

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6522218*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		<i>8-21-90</i>	<i>DB</i>
600	Proof		<i>8-21-90</i>	<i>DB</i>
607	Check Headspace		<i>8-21-90</i>	<i>DB</i>
610	Dis-assemble Gun		<i>8-21-90</i>	<i>DB</i>
612	Magnaflux Barrel Action		<i>8/22/90</i>	<i>KCR</i>
	Magnaflux Bolt		<i>8/22/90</i>	<i>KCR</i>
615	Rollmark Caliber		<i>8/22/90</i>	<i>GS.</i>
617	Drill and Tap Sight Holes		<i>8/23/90</i>	<i>FB</i>
618	Polish Barrel		<i>8/23/90</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>8-23-90</i>	<i>LA</i>
	Apply Coating (Bolt)		<i>8-23-90</i>	<i>LA</i>
625	Final Assembly A) Clean inside of Bolt Assembly		<i>8/31/90</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>8/31/90</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>8/31/90</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>8/31/90</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>9/5/90</i>	<i>WB</i>

op. #	OP. NAME	READINGS					DATE	INIT
605 nt.	F) Safety On Force	4 3/4	5	4 3/4			9/5/90	9/5/90
	G) Safety Off Force	2 1/4	2 1/4	2 1/2			9/5/90	WB
	H) Trigger Pull Test & Retainability						9/5/90	WB
	I) Firing Pin Indent	.0235	.0235	.0235			9/5/90	WB
	J) Assemble Stock						9/8/90	RW
	K) Assemble Swivel Studs						9/10/90	JS
	L) Attach Front and Rear Sight Assemblies						9/8/90	RW
	M) Iron Sight Alignment						9/8/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/8/90	RW
	O) Attach Scope to Rifle						9/8/90	RW
	P) Detach & Attach Scope 20 Times						9/8/90	RW
640	Gallery Target & Test						9-9-90	DH
	A) Time						9-9-90	DH
	B) Malfunctions						9-9-90	DH
	C) Pierced Primers						9-9-90	DH
	D) Optical Clarity of Scope						9-9-90	DH
645	Inspect for Live Ammo						9-9-90	DH
655	Final Inspection							
	A) Headspace						9/11/90	JS
	B) Trigger Pull	2.16	2.19	2.15	2.14	2.15	9/10/90	WB
	C) Function						9/11/90	JS
660	Pack						9/19/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522218
DATE 9/5/90
TESTER W.B

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.43	2.10	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.41	2.09	2.19	
PULL #3	2.28	2.30	2.11	2.15	
PULL #4	2.21	2.39	2.11	2.14	
PULL #5	2.36	2.37	2.13	2.15	
TOTAL	11.44	11.90	10.54	10.79	
AVG.	2.29	2.38	2.11	2.16	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.11		
PULL #2	3.31	3.08		
PULL #3	3.23	3.10		
PULL #4	3.24	3.12		
PULL #5	3.12	3.16		
TOTAL	16.19	15.57		
AVG.	3.22	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.12		4.12
PULL #2	4.12	4.14		4.10
PULL #3	4.15	4.19		4.12
PULL #4	4.09	4.16		4.07
PULL #5	4.14	4.05		4.10
TOTAL	20.59	20.66		20.51
AVG.	4.12	4.13		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522218
9 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.202786
1 TO	2	.434545
1 TO	3	.594832
1 TO	4	.901733
1 TO	5	.87341

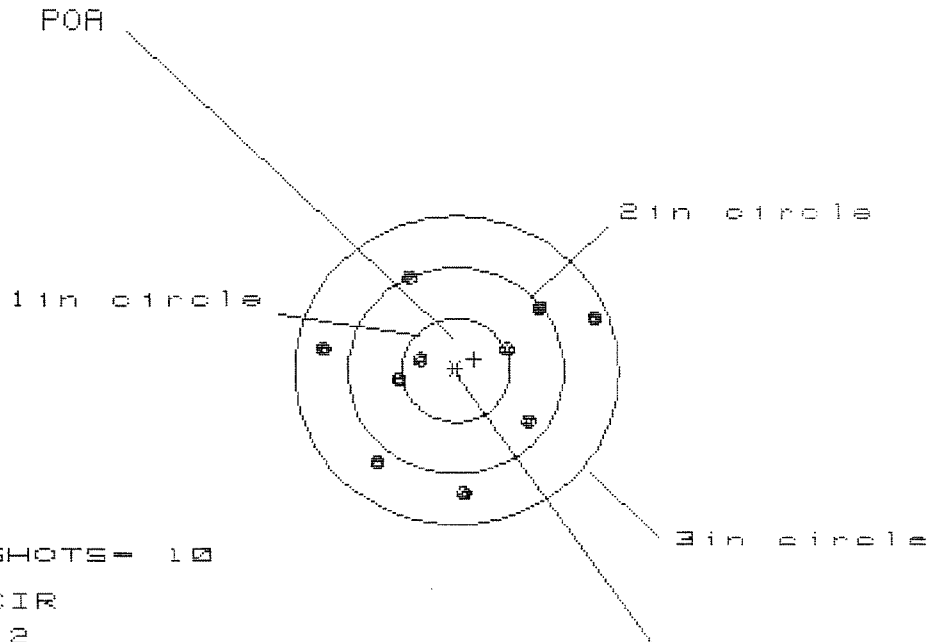
σ^2_{34} <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .415418
THE AMR FOR THIS RIFLE IS: .918

9 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522218

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS = 2.457

VS = 2.144

GS = 2.472

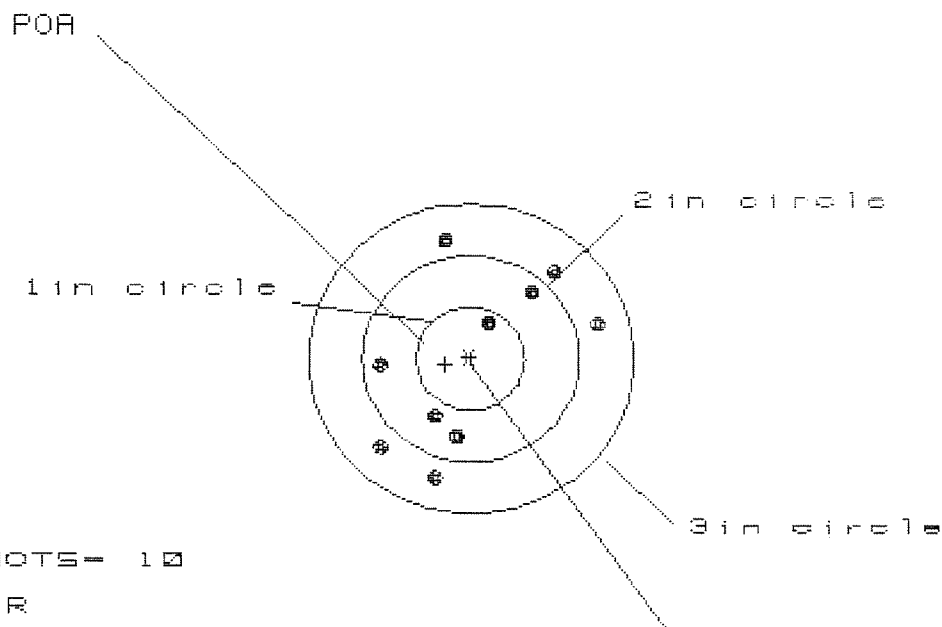
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	.924	.787
MINIMUM X	:	-1.232	-1.096	-.702
MAXIMUM Y	:	.918	.975	1.013
MINIMUM Y	:	-1.226	-1.169	-1.131
CENTROID X	:	-.171	-.307	-.170
CENTROID Y	:	-.109	-.166	-.204
POA TO CENTROID in.	:	.203	.349	.265
MIN RADIUS	:	.348	.271	.397
MEAN RADIUS	:	.917	.858	.826
MAX RADIUS	:	1.328	1.181	1.132
HORIZONTAL SPREAD	:	2.457	2.020	1.489
VERTICAL SPREAD	:	2.144	2.144	2.144
EXTREME SPREAD	:	2.472	2.187	2.187
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.029

VS= 2.311

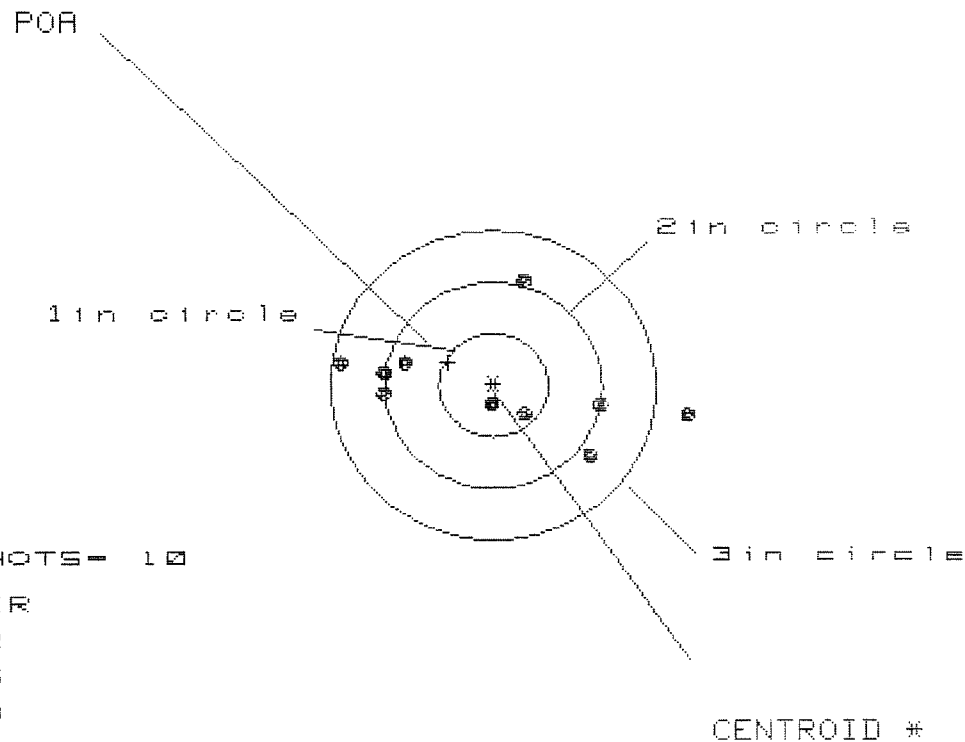
GS= 2.354

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.156	.895	.873
MINIMUM X	:	-.873	-.744	-.766
MAXIMUM Y	:	1.143	1.184	1.044
MINIMUM Y	:	-1.168	-1.127	-.946
CENTROID X	:	.231	.102	.124
CENTROID Y	:	.056	.015	.156
FOR TO CENTROID in.	:	.238	.103	.199
MIN RADIUS	:	.413	.503	.410
MEAN RADIUS	:	.945	.904	.871
MAX RADIUS	:	1.215	1.252	1.208
HORIZONTAL SPREAD	:	2.029	1.639	1.639
VERTICAL SPREAD	:	2.311	2.311	1.989
EXTREME SPREAD	:	2.354	2.337	2.337
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.189

VS= 1.737

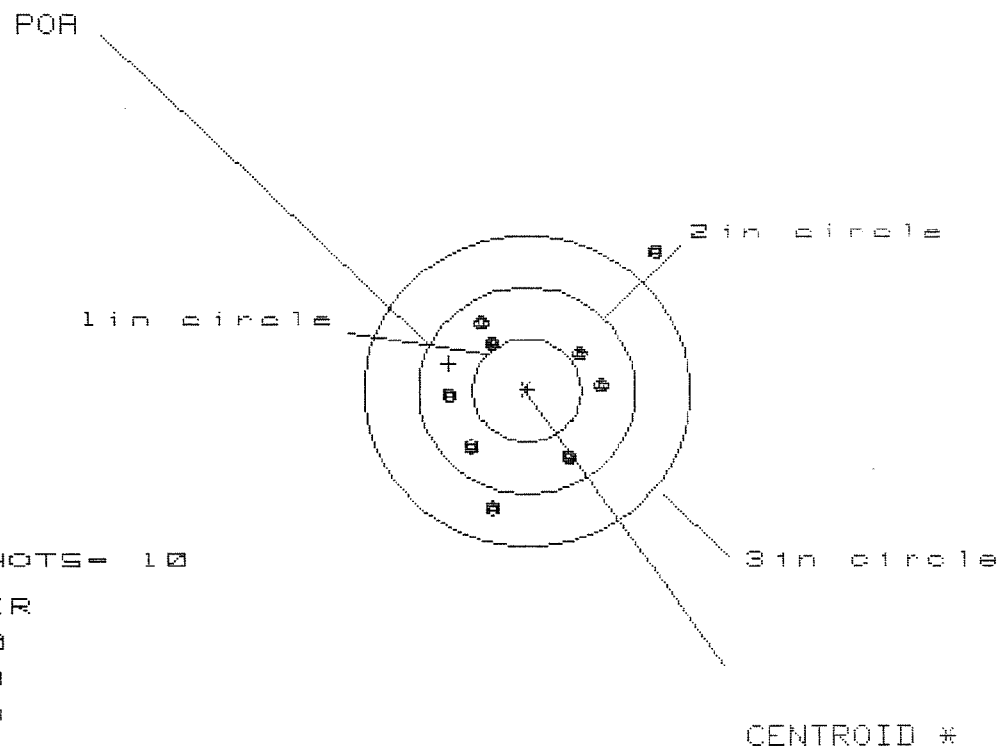
GS= 3.238

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.800	1.172	1.024
MINIMUM X	:	-1.389	-1.190	-.996
MAXIMUM Y	:	1.068	1.032	1.057
MINIMUM Y	:	-.669	-.705	-.680
CENTROID X	:	.413	.214	.362
CENTROID Y	:	-.222	-.186	-.211
POA TO CENTROID in.	:	.469	.283	.419
MIN RADIUS	:	.182	.259	.186
MEAN RADIUS	:	.996	.891	.840
MAX RADIUS	:	1.829	1.317	1.179
HORIZONTAL SPREAD	:	3.189	2.362	2.020
VERTICAL SPREAD	:	1.737	1.737	1.737
EXTREME SPREAD	:	3.238	2.474	2.043
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 = 0

2in = 8

3in = 9

HS= 1.905

VS= 2.467

GS= 2.910

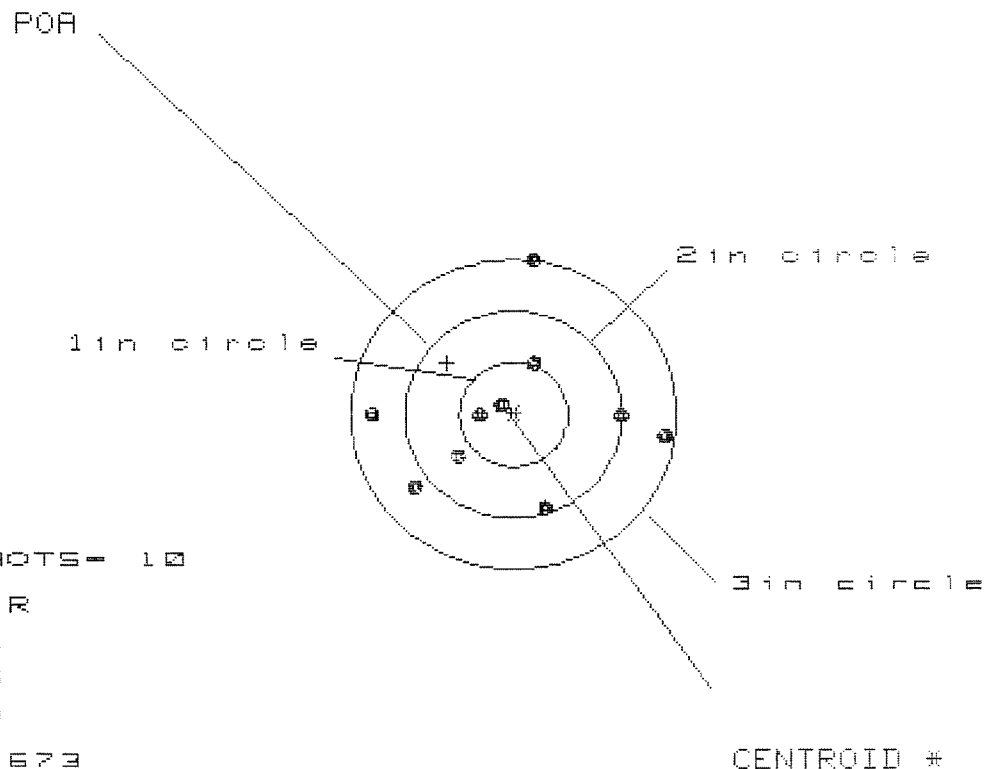
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	.784	.759
MINIMUM X	:	-.702	-.569	-.594
MAXIMUM Y	:	1.340	.844	.722
MINIMUM Y	:	-1.127	-.978	-.642
CENTROID X	:	.718	.585	.610
CENTROID Y	:	-.260	-.409	-.287
POR TO CENTROID in.	:	.764	.714	.674
MIN RADIUS	:	.510	.495	.482
MEAN RADIUS	:	.841	.712	.669
MAX RADIUS	:	1.801	.999	.808
HORIZONTAL SPREAD	:	1.905	1.353	1.353
VERTICAL SPREAD	:	2.467	1.822	1.364
EXTREME SPREAD	:	2.910	1.823	1.567
NUMBER IN ONE INCH CIRCLE	=		0	
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 = 2

2in = 6

3in = 9

HS= 2.673

VS= 2.409

GS= 2.678

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.403	1.427	1.187
MINIMUM X	:	-1.270	-1.246	-1.068
MAXIMUM Y	:	1.535	.700	.696
MINIMUM Y	:	-.874	-.703	-.707
CENTROID X	:	.611	.587	.409
CENTROID Y	:	-.498	-.669	-.665
POA TO CENTROID in.	:	.789	.890	.781
MIN RADIUS	:	.109	.249	.240
MEAN RADIUS	:	.891	.818	.710
MAX RADIUS	:	1.551	1.427	1.196
HORIZONTAL SPREAD	:	2.673	2.673	2.255
VERTICAL SPREAD	:	2.409	1.403	1.403
EXTREME SPREAD	:	2.678	2.678	2.255
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	




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

MODEL 700TM H24

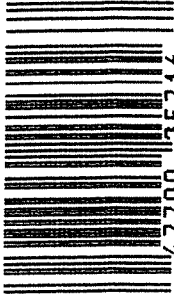
SERIAL NO.
C6522218

ORDER NO.
5716

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UPC



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