

C6522300

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

rear sight base
& stock needs
touch-up

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522300

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KA
600	Proof		7/10/90	KA
607	Check Headspace		7/10/90	KA
610	Dis-assemble Gun		7/10/90	KA
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	GS
617	Drill and Tap Sight Holes		7/22/90	EB
618	Polish Barrel AB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/90	KS
	C) Inspect Ejector Hole for Chamfer		8/22/90	KS
	D) Oil Firing Pin Ass'y		8/22/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/90	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			9/4/90	WB
	H) Trigger Pull Test & Retainability						9/1/90	JS
	I) Firing Pin Indent	.022	.0225	.0225			9/4/90	WB
	J) Assemble Stock						9/4/90	KS
	K) Assemble Swivel Studs						9/8/90	JS
	L) Attach Front and Rear Sight Assemblies						9/4/90	KS
	M) Iron Sight Alignment						9/4/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	KS
	O) Attach Scope to Rifle						9/4/90	KS
	P) Detach & Attach Scope 20 Times						9/4/90	KS
640	Gallery Target & Test						9/6/90	KJ
	A) Time						9/6/90	KJ
	B) Malfunctions						9/6/90	KJ
	C) Pierced Primers						9/6/90	KJ
	D) Optical Clarity of Scope						9/6/90	193
645	Inspect for Live Ammo						9/6/90	122
655	Final Inspection							
	A) Headspace						9/8/90	JS
	B) Trigger Pull	2.52	2.53	2.57	2.53	2.54	9-7-90	JS
	C) Function						9/8/90	JS
660	Pack						9-9-90	DA

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522300
DATE 9/1/90
TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.33	2.20	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.15	2.22	2.30	2.53	
PULL #3	2.19	2.24	2.26	2.57	
PULL #4	2.44	2.26	2.27	2.53	
PULL #5	2.27	2.25	2.22	2.54	
TOTAL	11.45	11.30	11.25	12.69	
AVG.	2.29	2.26	2.25	2.538	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.14		
PULL #2	3.26	3.20		
PULL #3	3.22	3.11		
PULL #4	3.24	3.20		
PULL #5	3.23	3.13		
TOTAL	16.22	15.78		
AVG.	3.244	3.156		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.23		4.50
PULL #2	4.21	4.50		4.46
PULL #3	4.41	4.29		4.27
PULL #4	4.31	4.47		4.49
PULL #5	4.50	4.30		4.43
TOTAL	21.61	21.78		22.15
AVG.	4.322	4.356		4.43

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522300
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.050448
1 TO	2	.150602
1 TO	3	.0468722
1 TO	4	.1364
1 TO	5	.185421

⊙ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.024
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0458
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0517073
THE AMR FOR THIS RIFLE IS: .764

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/=CB522300

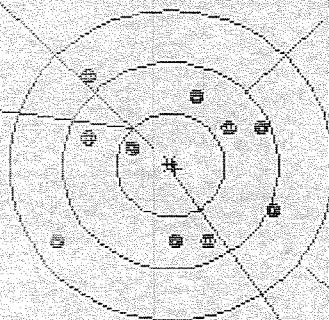
CENTERFIRE PATTERNS # 1

PQR

1 in circle

2 in circle

3 in circle



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.953

VS= 1.687

GS= 2.135

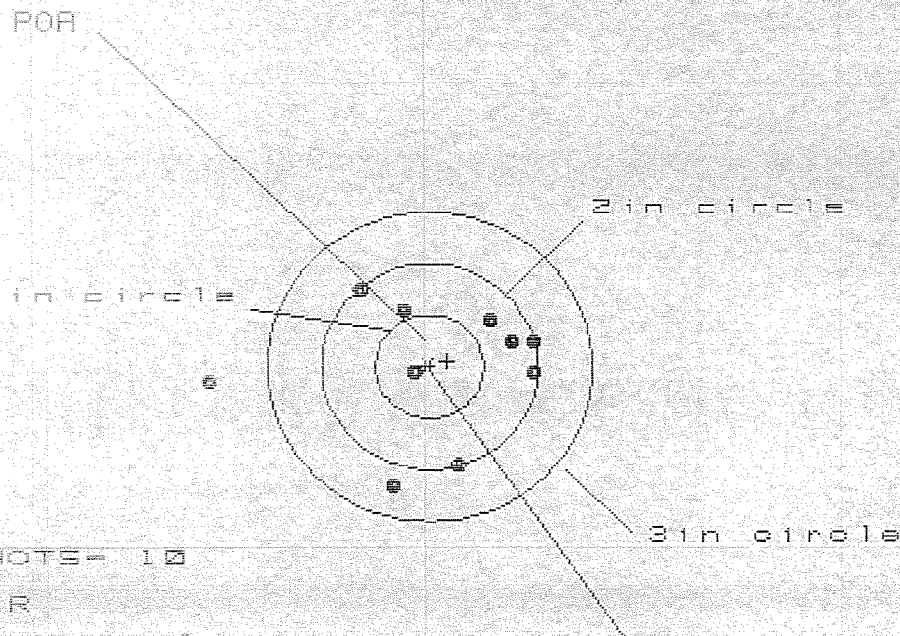
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.921	.806	.698
MINIMUM X	:	-1.032	-.868	-.955
MAXIMUM Y	:	.905	.828	.698
MINIMUM Y	:	-.781	-.859	-.756
CENTROID X	:	-.039	.076	.184
CENTROID Y	:	.032	.110	.007
PQR TO CENTROID in.	:	.051	.134	.184
MIN RADIUS	:	.388	.485	.483
MEAN RADIUS	:	.845	.787	.727
MAX RADIUS	:	1.248	1.199	1.003
HORIZONTAL SPREAD	:	1.953	1.674	1.653
VERTICAL SPREAD	:	1.687	1.687	1.454
EXTREME SPREAD	:	2.135	2.127	1.790
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/=C6522300

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.990

VS= 1.849

GS= 3.021

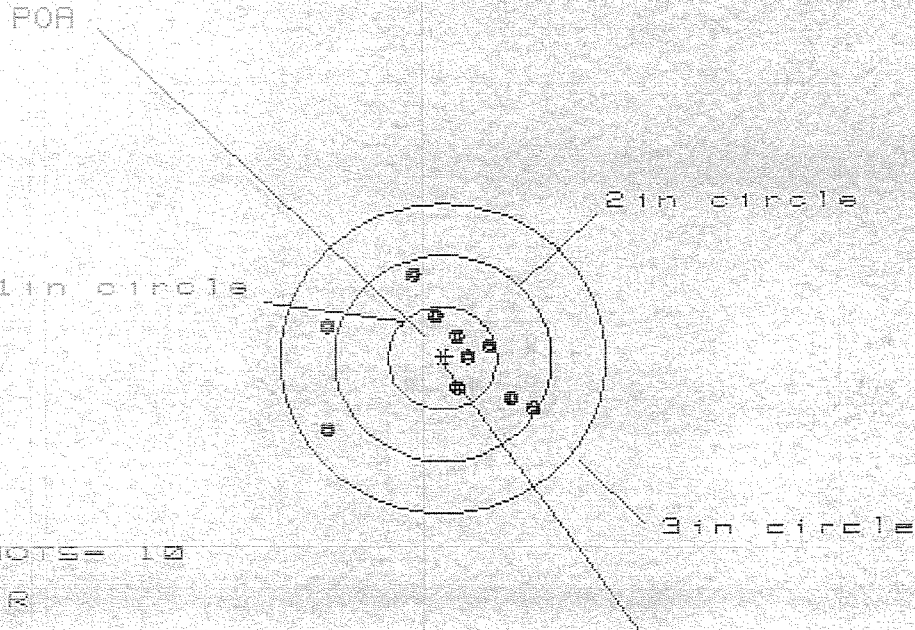
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.950	.724	.649
MINIMUM X	:	-2.040	-.885	-.960
MAXIMUM Y	:	.742	.721	.580
MINIMUM Y	:	-1.107	-1.128	-1.155
CENTROID X	:	-.164	.062	.138
CENTROID Y	:	-.052	-.031	.110
POA TO CENTROID in.	:	.172	.070	.176
MIN RADIUS	:	.155	.382	.428
MEAN RADIUS	:	.946	.795	.704
MAX RADIUS	:	2.048	1.278	1.155
HORIZONTAL SPREAD	:	2.990	1.609	1.609
VERTICAL SPREAD	:	1.849	1.849	1.735
EXTREME SPREAD	:	3.021	1.971	1.971
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/=CB522300

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.930

VS= 1.528

GS= 2.067

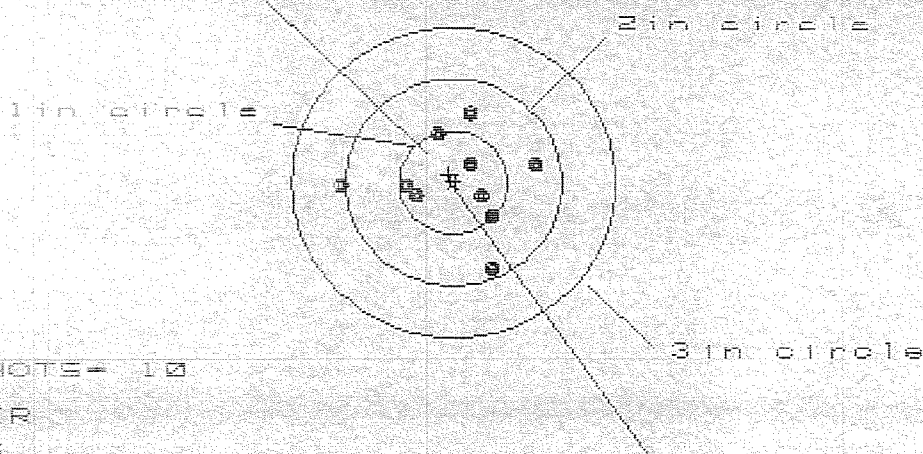
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.855	.735	.592
MINIMUM X	:	-1.075	-1.144	-.491
MAXIMUM Y	:	.811	.731	.767
MINIMUM Y	:	-.717	-.582	-.546
CENTROID X	:	-.030	.090	.233
CENTROID Y	:	-.014	.066	.030
POA TO CENTROID in.	:	.033	.111	.235
MIN RADIUS	:	.206	.111	.030
MEAN RADIUS	:	.664	.554	.452
MAX RADIUS	:	1.292	1.178	.910
HORIZONTAL SPREAD	:	1.930	1.079	1.083
VERTICAL SPREAD	:	1.528	1.313	1.313
EXTREME SPREAD	:	2.067	2.067	1.702
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 1.8009

VS= 1.495

GS= 1.825

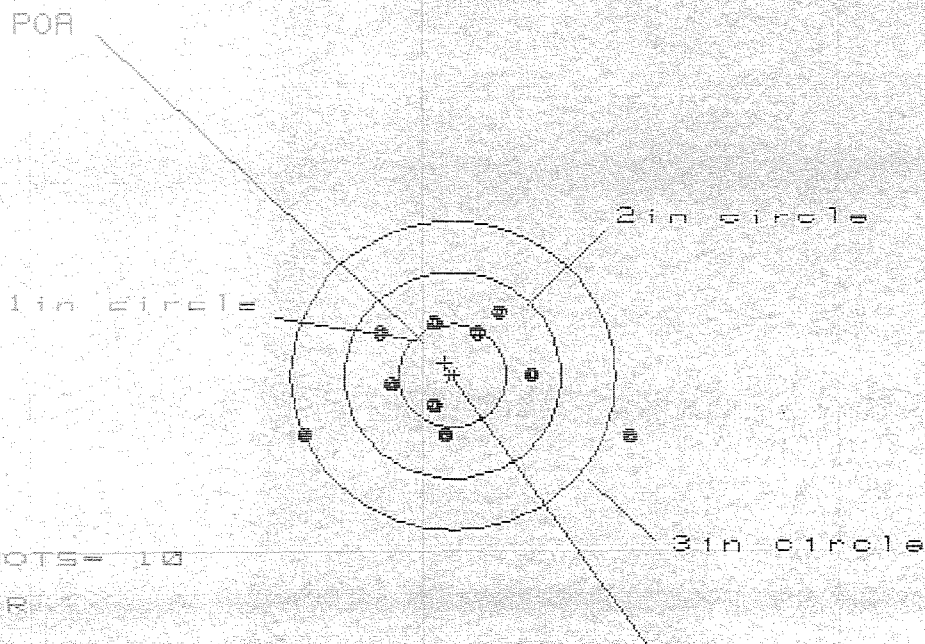
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.731	.611	.642
MINIMUM X	:	-1.078	-.607	-.576
MAXIMUM Y	:	.675	.668	.564
MINIMUM Y	:	-.820	-.827	-.471
CENTROID X	:	.043	.163	.132
CENTROID Y	:	-.077	-.069	.035
POB TO CENTROID in.	:	.088	.177	.136
MIN RADIUS	:	.202	.134	.064
MEAN RADIUS	:	.571	.499	.445
MAX RADIUS	:	1.080	.864	.645
HORIZONTAL SPREAD	:	1.809	1.218	1.218
VERTICAL SPREAD	:	1.495	1.495	1.035
EXTREME SPREAD	:	1.825	1.508	1.227
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/=C6522300

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.920

VS= 1.287

GS= 2.920

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	.940	.796
MINIMUM X	:	-1.325	-1.147	-.595
MAXIMUM Y	:	.661	.592	.508
MINIMUM Y	:	-.626	-.666	-.687
CENTROID X	:	.070	-.108	.036
CENTROID Y	:	-.118	-.049	.035
POA TO CENTROID in.	:	.137	.118	.050
MIN RADIUS	:	.283	.305	.375
MEAN RADIUS	:	.794	.670	.579
MAX RADIUS	:	1.714	1.327	.813
HORIZONTAL SPREAD	:	2.920	2.087	1.391
VERTICAL SPREAD	:	1.287	1.258	1.195
EXTREME SPREAD	:	2.920	2.167	1.453
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

Remington®

MODEL 700™ H24

UPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6522300

ORDER NO.
5716

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