

C6522315

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

REPD

7-31-90

ASSEM.

TEST INIT. ACTION TO CORRECT

#

PROOF

FILED

TEST

BOLT SLOT

23

TGT

CHANGED
EXTRACTOR

PROOF

shot 100% OK

TEST

8/6/90

DA

TGT

PROOF

ENGINEER

TEST

TGT

PROOF

ENGINEER

TEST

TGT

MOD.		GA. CAL.	GUN #	ASSEM. #
#	DATE	MALFUNCTION/DEFECT		
1st	7/30/90	Bolt handle hits the stock and Don't extract		
2nd				
3rd				
4th				
FUNCTION		RD 6654		Rev 1

Remington®



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

MODEL 700™ M24

SERIAL NO.

C6522315

ORDER NO.

5716

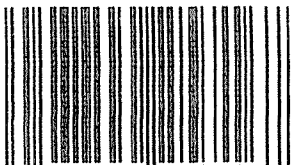
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

01



5716 C6522315

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522315
30 JUL 1990

CENTROIDAL DISTANCES

0 TO	1	.220638
1 TO	2	.215845
1 TO	3	.545539
1 TO	4	.581055
1 TO	5	.653478

$\bar{x}^4_5$ <----FOR

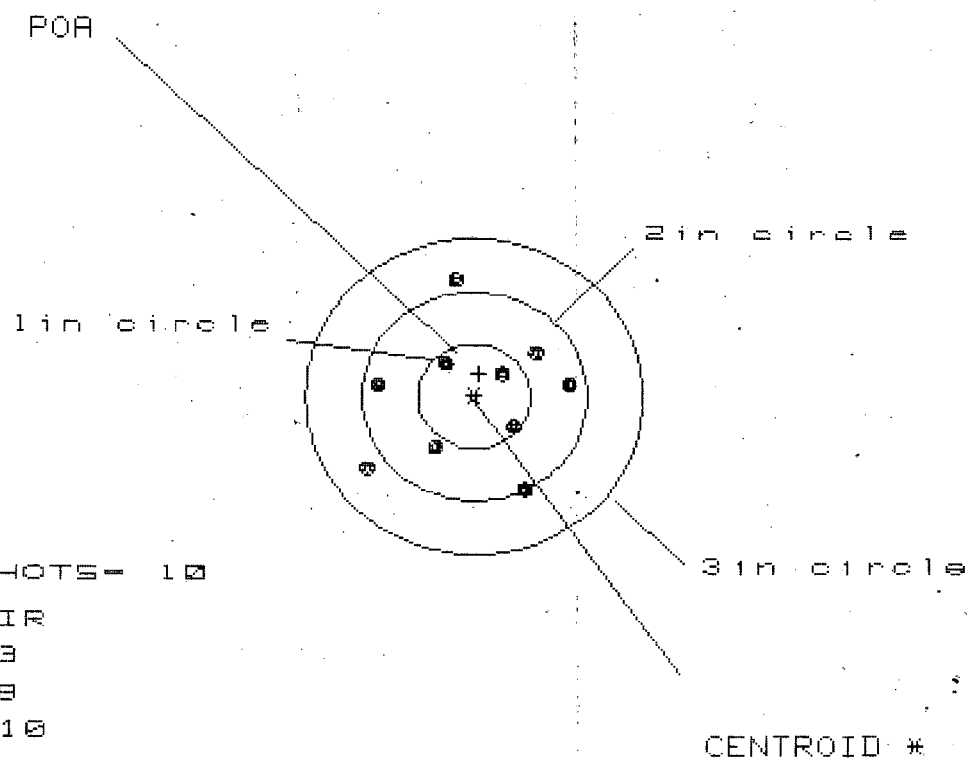
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0806
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0134
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0817063

THE AMR FOR THIS RIFLE IS: .7024

30 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522315

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in - 10

HS- 1.796

VS- 1.944

GS- 2.040

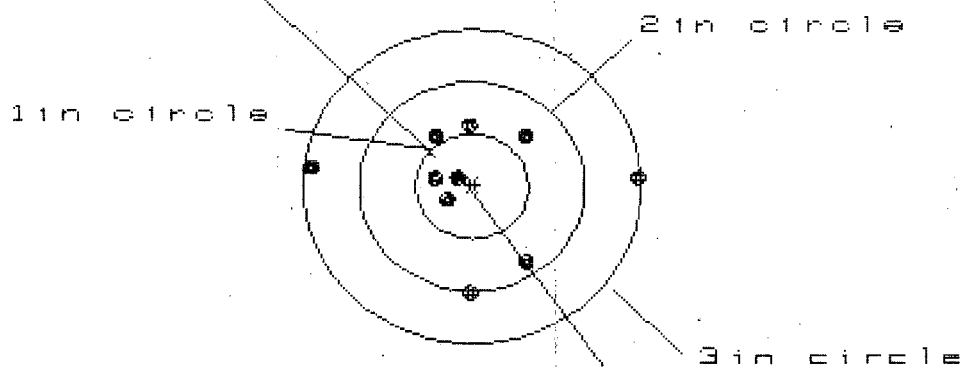
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.866	.762	.734
MINIMUM X	-.930	-.952	-.980
MAXIMUM Y	1.098	1.025	.505
MINIMUM Y	-.846	-.919	-.791
CENTROID X	-.045	.059	.087
CENTROID Y	-.216	-.143	-.271
POA TO CENTROID in.	.220	.155	.285
MIN RADIUS	.312	.189	.290
MEAN RADIUS	.740	.677	.630
MAX RADIUS	1.137	1.050	.999
HORIZONTAL SPREAD	1.796	1.714	1.714
VERTICAL SPREAD	1.944	1.944	1.296
EXTREME SPREAD	2.040	2.040	1.715
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.973

VS= 1.631

GS= 2.976

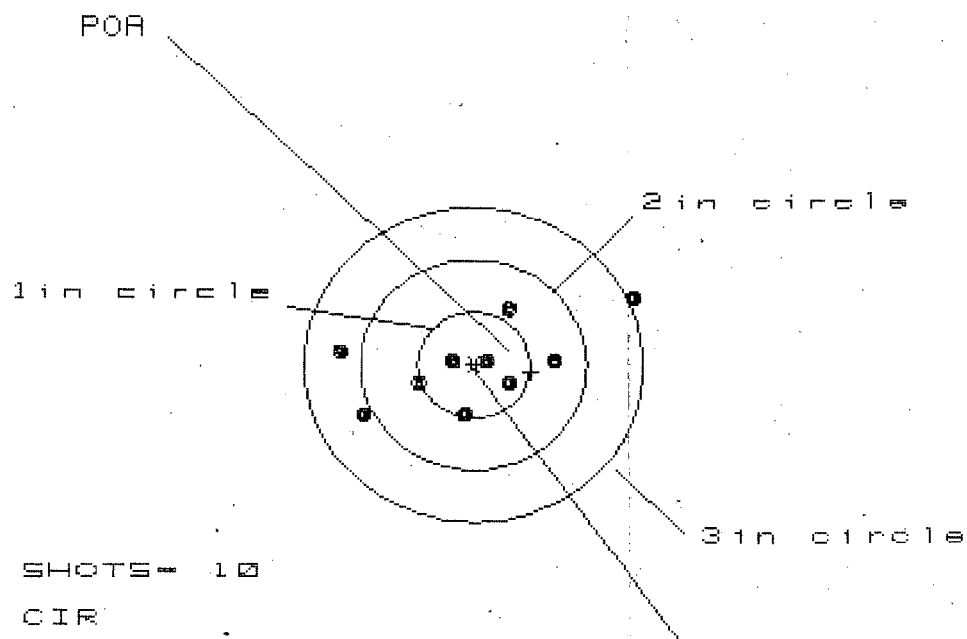
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	.686	.525
MINIMUM X	:	-1.459	-1.291	-.309
MAXIMUM Y	:	.586	.592	.614
MINIMUM Y	:	-1.045	-1.039	-1.017
CENTROID X	:	.125	-.043	.118
CENTROID Y	:	-.083	-.089	-.111
POA TO CENTROID in.	:	.150	.099	.162
MIN RADIUS	:	.145	.132	.163
MEAN RADIUS	:	.736	.620	.550
MAX RADIUS	:	1.515	1.303	1.019
HORIZONTAL SPREAD	:	2.973	1.977	.834
VERTICAL SPREAD	:	1.631	1.631	1.631
EXTREME SPREAD	:	2.976	2.165	1.633
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.569

VS = 1.158

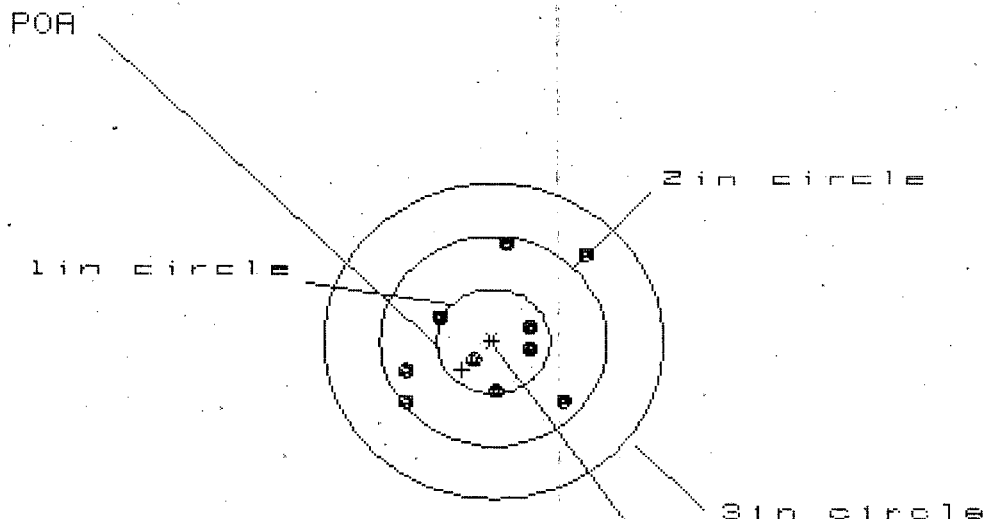
GS = 2.627

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.404	.881	.755
MINIMUM X	-1.165	-1.009	-.921
MAXIMUM Y	.652	.632	.654
MINIMUM Y	-.506	-.434	-.412
CENTROID X	-.512	-.668	-.542
CENTROID Y	.066	-.006	-.028
POA TO CENTROID in.	.517	.668	.543
MIN RADIUS	.157	.092	.181
MEAN RADIUS	.683	.580	.511
MAX RADIUS	1.548	1.024	1.008
HORIZONTAL SPREAD	2.569	1.890	1.676
VERTICAL SPREAD	1.158	1.066	1.066
EXTREME SPREAD	2.627	1.893	1.748
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 1.582

VS= 1.472

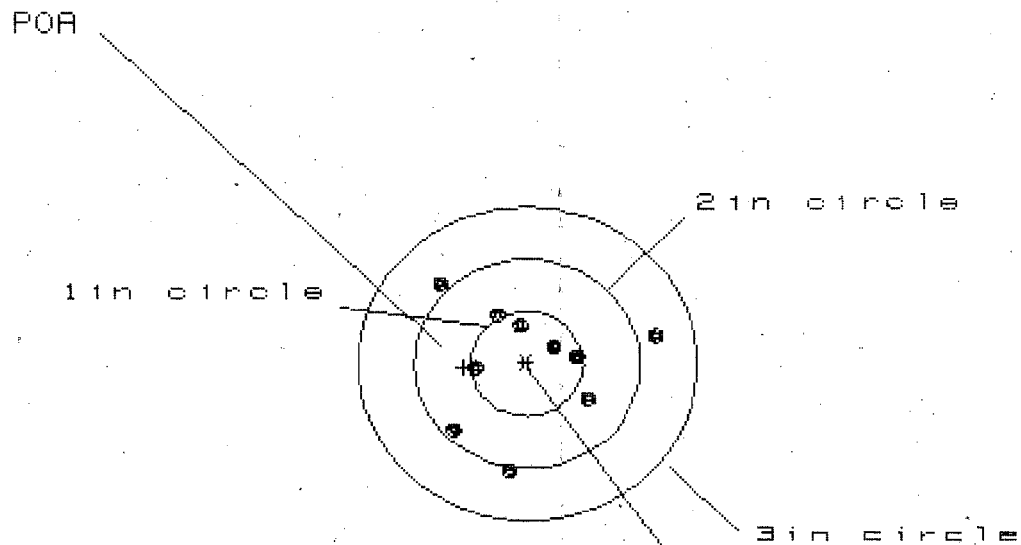
GS= 2.114

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.788	.677	.589
MINIMUM X	-.794	-.707	-.795
MAXIMUM Y	.881	.972	.910
MINIMUM Y	-.591	-.500	-.561
CENTROID X	.275	.188	.276
CENTROID Y	.269	.178	.239
POA TO CENTROID in.	.385	.259	.365
MIN RADIUS	.258	.142	.245
MEAN RADIUS	.659	.591	.556
MAX RADIUS	1.138	.999	.921
HORIZONTAL SPREAD	1.582	1.384	1.384
VERTICAL SPREAD	1.472	1.472	1.472
EXTREME SPREAD	2.114	1.736	1.539
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.848

VS= 1.790

GS= 2.046

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.137	.694	.621
MINIMUM X	-.711	-.585	-.655
MAXIMUM Y	.758	.790	.580
MINIMUM Y	-1.032	-1.000	-.902
CENTROID X	.560	.434	.507
CENTROID Y	.031	-.001	-.099
POA TO CENTROID in.	.561	.434	.517
MIN RADIUS	.246	.372	.371
MEAN RADIUS	.694	.643	.605
MAX RADIUS	1.172	1.000	.904
HORIZONTAL SPREAD	1.848	1.279	1.276
VERTICAL SPREAD	1.790	1.790	1.482
EXTREME SPREAD	2.046	1.886	1.491
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

SWS TRIGGER PULL TEST

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

SERIAL NO CL522315

DATE 9-5-90

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.34	2.31	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.34	2.35	2.50	
PULL #3	2.33	2.36	2.24	2.37	
PULL #4	2.29	2.33	2.39	2.51	
PULL #5	2.29	2.37	2.35	2.48	
TOTAL	11.67	11.74	11.64	12.35	
AVG.	2.334	2.348	2.328	2.47	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.18		
PULL #2	3.20	3.12		
PULL #3	3.24	3.16		
PULL #4	3.27	3.21		
PULL #5	3.26	3.31		
TOTAL	16.14	15.98		
AVG.	3.228	3.196		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.25		4.33
PULL #2	4.27	4.23		4.33
PULL #3	4.28	4.27		4.43
PULL #4	4.18	4.36		4.36
PULL #5	4.35	4.38		4.37
TOTAL	21.31	21.49		21.82
AVG.	4.262	4.298		4.364

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522315

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/90	KA
600	Proof		6/27/90	KA
607	Check Headspace		6/27/90	KA
610	Dis-assemble Gun		6/27/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	G.S.
617	Drill and Tap Sight Holes		7/11/90	EB
618	Polish Barrel AB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/26/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/26/90	KA
	C) Inspect Ejector Hole for Chamfer		7/26/90	KA
	D) Oil Firing Pin Ass'y		7/26/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/15/90	92/

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/25/90	JK
	G) Safety Off Force	4	4	4			7/25/90	JK
	H) Trigger Pull Test & Retainability						9-5-90	JK
	I) Firing Pin Indent	.023	.0225	.0225			7/25/90	JK
	J) Assemble Stock						7/26/90	JK
	K) Assemble Swivel Studs						9/6/90	JSR
	L) Attach Front and Rear Sight Assemblies						7/26/90	JK
	M) Iron Sight Alignment						7/26/90	JK
	N) Detach Front & Rear Sights & place in numbered container						7/26/90	JK
	O) Attach Scope to Rifle						7/26/90	JK
	P) Detach & Attach Scope 20 Times						7/26/90	JK
640	Gallery Target & Test						7-30-90	DH
	A) Time						7-30-90	DH
	B) Malfunctions						7-30-90	DH
	C) Pierced Primers						7-30-90	DH
	D) Optical Clarity of Scope						7-30-90	DH
645	Inspect for Live Ammo						7-30-90	DH
655	Final Inspection							
	A) Headspace						9/6/90	JSR
	B) Trigger Pull	2.49	2.50	2.37	2.51	2.48	9/6/90	JK
	C) Function						9/6/90	JSR
660	Pack						7/26/90	NF