

06523300

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523300

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 1/2	5 1/2			9/8/90	WB
	G) Safety Off Force	3	3	3			9/8/90	WB
	H) Trigger Pull Test & Retainability						9/8/90	WB
	I) Firing Pin Indent	.023	.0225	.0225			9/8/90	WB
	J) Assemble Stock						9/9/90	KS
	K) Assemble Swivel Studs						9/15/90	JS
	L) Attach Front and Rear Sight Assemblies						9/9/90	KS
	M) Iron Sight Alignment						9/9/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/9/90	KS
	O) Attach Scope to Rifle						9/9/90	KS
	P) Detach & Attach Scope 20 Times						9/9/90	KS
640	Gallery Target & Test						9/12/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9/12/90	NF
655	Final Inspection							
	A) Headspace						9/15/90	JS
	B) Trigger Pull	2.50	2.54	2.29	2.37	2.43	9-14-90	JS
	C) Function						9/15/90	JS
660	Pack						9/19/90	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00# ,

SERIAL NO. C6523300

DATE 9/8/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.42	2.29	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.42	2.34	2.54	
PULL #3	2.38	2.44	2.09	2.29	
PULL #4	2.33	2.39	2.24	2.37	
PULL #5	2.20	2.36	2.30	2.43	
TOTAL	11.79	12.03	11.26	12.13	
AVG.	2.36	2.41	2.35	2.426	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.07		
PULL #2	3.03	3.03		
PULL #3	3.04	3.06		
PULL #4	3.00	3.03		
PULL #5	3.04	3.00		
TOTAL	15.14	15.19		
AVG.	3.03	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.01		4.30
PULL #2	4.03	4.03		4.28
PULL #3	4.04	4.17		4.27
PULL #4	4.06	4.20		4.31
PULL #5	4.04	4.26		4.06
TOTAL	20.23	20.67		21.22
AVG.	4.05	4.13		4.24

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523300
13 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.174453
1 TO	2	.181135
1 TO	3	.269164
1 TO	4	.20501
1 TO	5	.191024

5/8 <----FOR

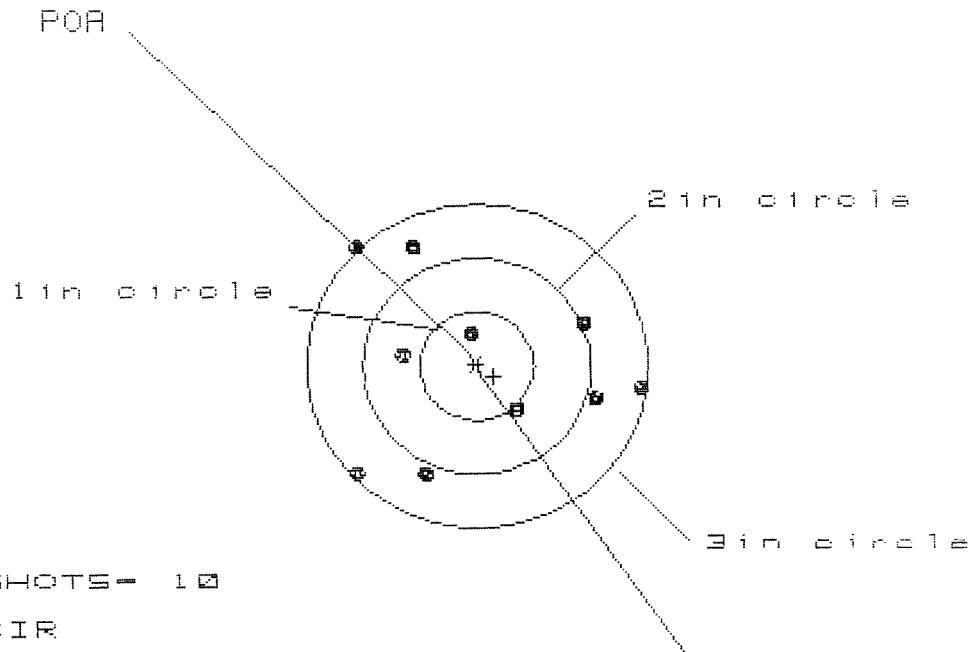
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1692
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169778

THE AMR FOR THIS RIFLE IS: .9736

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523300

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.555

VS= 2.123

GS= 2.835

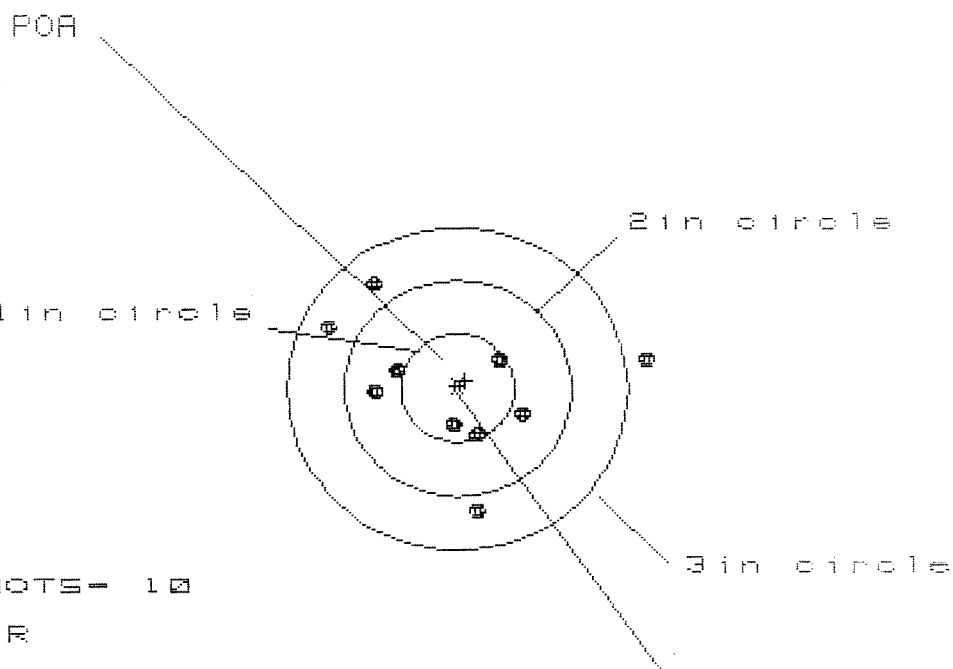
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.460	1.338	1.188
MINIMUM X	:	-1.095	-1.200	-.902
MAXIMUM Y	:	1.082	1.199	1.084
MINIMUM Y	:	-1.041	-.924	-.965
CENTROID X	:	-.145	-.023	.127
CENTROID Y	:	.097	-.020	.095
POA TO CENTROID in.	:	.174	.031	.159
MIN RADIUS	:	.294	.409	.423
MEAN RADIUS	:	1.039	.977	.896
MAX RADIUS	:	1.520	1.514	1.355
HORIZONTAL SPREAD	:	2.555	2.538	2.090
VERTICAL SPREAD	:	2.123	2.123	2.049
EXTREME SPREAD	:	2.835	2.682	2.363
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523300

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.733

VS= 2.059

GS= 2.752

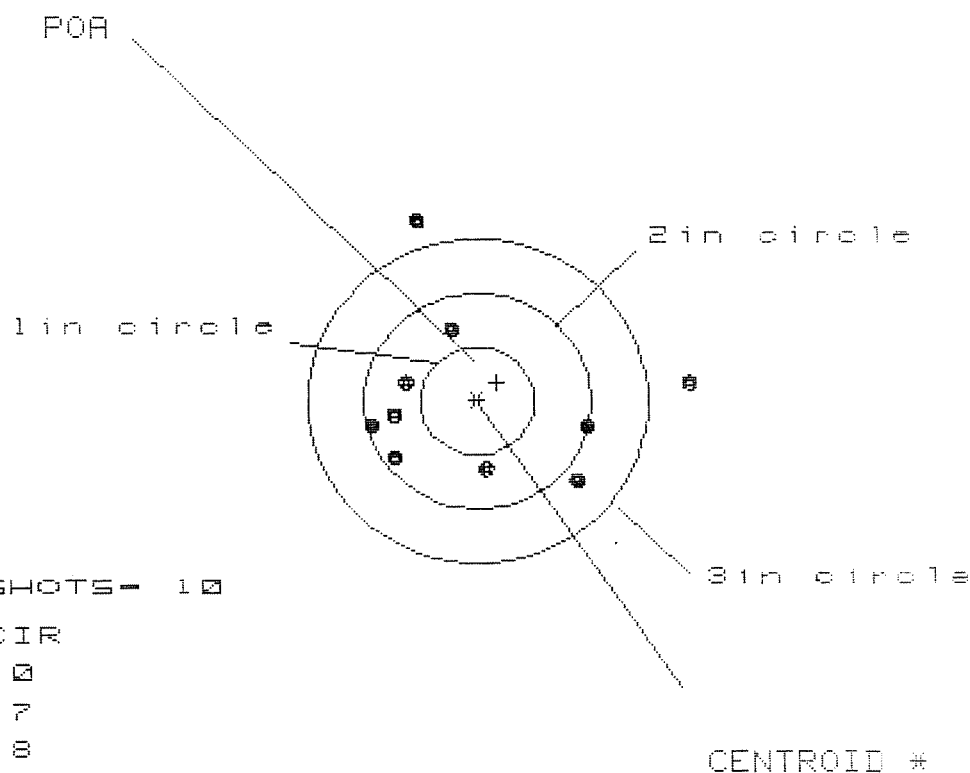
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.647	.757	.644
MINIMUM X	:	-1.086	-.903	-.649
MAXIMUM Y	:	.918	.946	1.021
MINIMUM Y	:	-1.141	-1.113	-1.038
CENTROID X	:	-.066	-.249	-.136
CENTROID Y	:	-.066	-.094	-.169
POA TO CENTROID in.	:	.093	.266	.217
MIN RADIUS	:	.307	.321	.208
MEAN RADIUS	:	.838	.733	.670
MAX RADIUS	:	1.666	1.181	1.210
HORIZONTAL SPREAD	:	2.733	1.660	1.293
VERTICAL SPREAD	:	2.059	2.059	2.059
EXTREME SPREAD	:	2.752	2.260	2.260
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523300

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 8

HS= 2.795

VS= 2.400

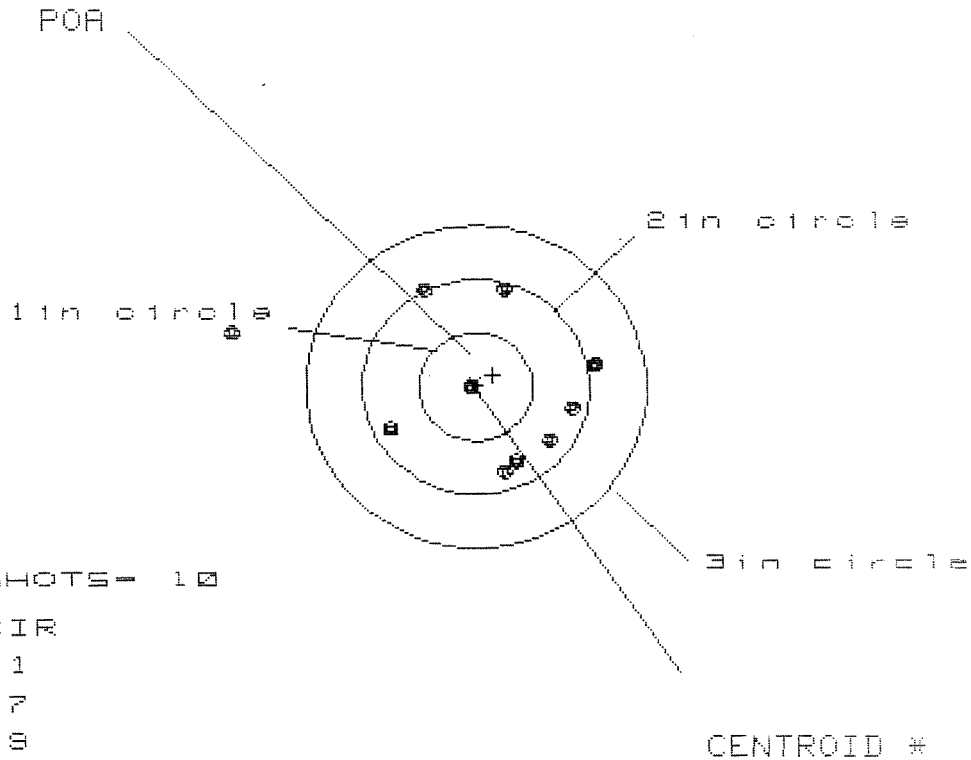
GS= 2.830

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.876	1.171	1.129
MINIMUM X	:	-.919	-.711	-.753
MAXIMUM Y	:	1.635	1.654	.867
MINIMUM Y	:	-.765	-.746	-.539
CENTROID X	:	-.170	-.378	-.336
CENTROID Y	:	-.171	-.190	-.397
POA TO CENTROID in.	:	.241	.423	.520
MIN RADIUS	:	.611	.420	.479
MEAN RADIUS	:	1.037	.893	.779
MAX RADIUS	:	1.883	1.687	1.204
HORIZONTAL SPREAD	:	2.795	1.882	1.882
VERTICAL SPREAD	:	2.400	2.400	1.406
EXTREME SPREAD	:	2.830	2.805	1.893
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523380

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.233

VS= 1.752

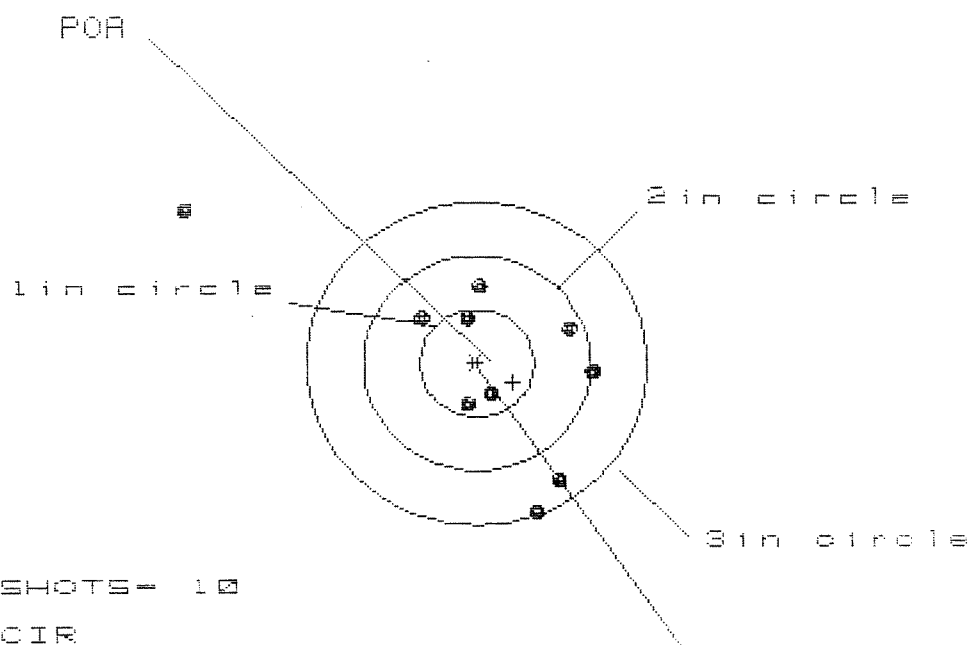
GS= 3.245

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.038	.794	.728
MINIMUM X	-2.195	-.973	-.873
MAXIMUM Y	.945	1.000	1.034
MINIMUM Y	-.807	-.752	-.718
CENTROID X	-.147	.097	-.003
CENTROID Y	-.108	-.163	-.197
POA TO CENTROID in.	.183	.190	.197
MIN RADIUS	.074	.324	.243
MEAN RADIUS	.946	.769	.753
MAX RADIUS	2.251	1.195	1.174
HORIZONTAL SPREAD	3.233	1.767	1.601
VERTICAL SPREAD	1.752	1.752	1.752
EXTREME SPREAD	3.245	1.877	1.855
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

12 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523300

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 3.639

VS= 2.781

GS= 4.204

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.043	.755	.788
MINIMUM X	-2.596	-.759	-.726
MAXIMUM Y	1.388	.847	.691
MINIMUM Y	-1.401	-1.248	-1.057
CENTROID X	-.318	-.030	-.064
CENTROID Y	.178	.025	.181
POA TO CENTROID in.	.365	.039	.192
MIN RADIUS	.327	.261	.361
MEAN RADIUS	1.008	.770	.692
MAX RADIUS	2.940	1.276	1.141
HORIZONTAL SPREAD	3.639	1.514	1.514
VERTICAL SPREAD	2.781	2.095	1.748
EXTREME SPREAD	4.204	2.169	1.907
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

Remington®



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

MODEL 700™ M24

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

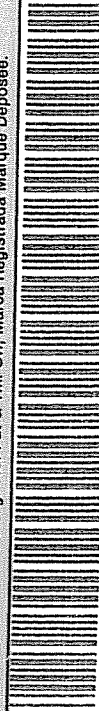
01

SERIAL NO.

06520300

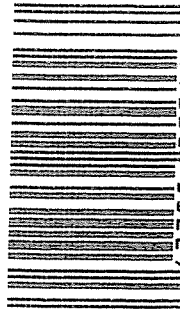
ORDER NO.

5716



5716 06520300

UPC



0 47700 25716 7