

C6523321

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523321
3 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	1.40077
1 TO	2	1.32199
1 TO	3	1.50897
1 TO	4	1.12405
1 TO	5	1.27607

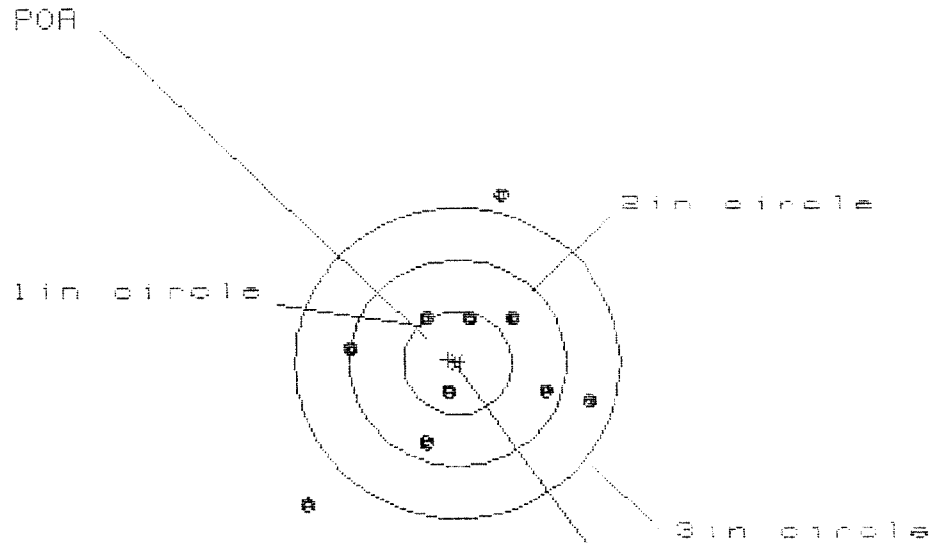
1 ~~43~~ <----PDR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3576
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.123
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .378162
THE AMR FOR THIS RIFLE IS: 1.015

3 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523321

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.622

VS= 3.015

GS= 3.488

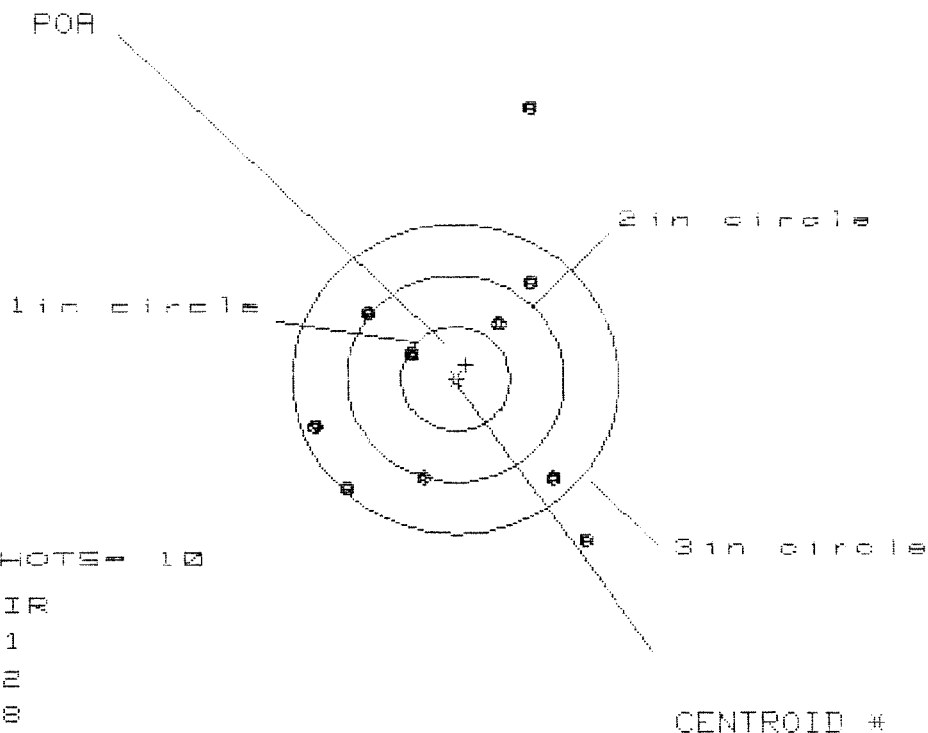
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.258	1.106	1.136
MINIMUM X	-1.364	-1.176	-1.146
MAXIMUM Y	1.617	1.462	.499
MINIMUM Y	-1.398	-.904	-.722
CENTROID X	.088	.240	.210
CENTROID Y	-.032	.123	-.059
POB TO CENTROID in.	.094	.270	.218
MIN RADIUS	.326	.317	.364
MEAN RADIUS	.966	.835	.753
MAX RADIUS	1.953	1.481	1.181
HORIZONTAL SPREAD	2.622	2.282	2.282
VERTICAL SPREAD	3.015	2.366	1.221
EXTREME SPREAD	3.488	2.469	2.336
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

3 Nov 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS = 2.561

VS = 4.168

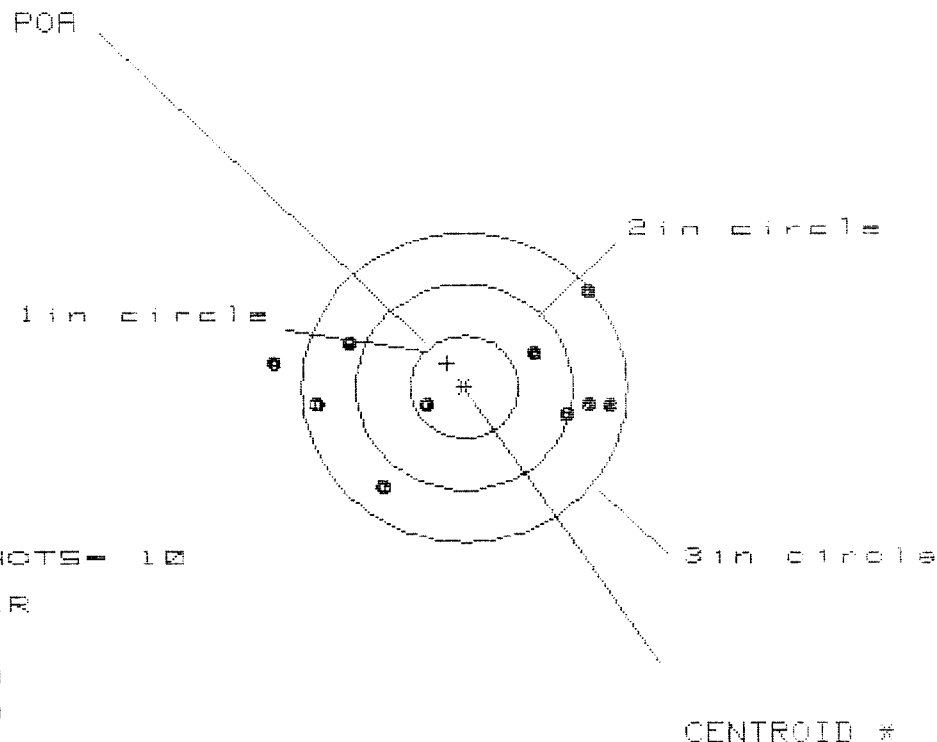
GS = 4.200

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.224	1.303	1.106
MINIMUM X	:	-1.337	-1.258	-1.095
MAXIMUM Y	:	2.631	1.272	1.116
MINIMUM Y	:	-1.536	-1.244	-.948
CENTROID X	:	-.096	-.175	-.338
CENTROID Y	:	-.141	-.433	-.277
POA TO CENTROID in.	:	.170	.467	.437
MIN RADIUS	:	.492	.621	.401
MEAN RADIUS	:	1.337	1.167	1.050
MAX RADIUS	:	2.725	1.802	1.449
HORIZONTAL SPREAD	:	2.561	2.561	2.201
VERTICAL SPREAD	:	4.168	2.516	2.064
EXTREME SPREAD	:	4.200	2.955	2.680
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 0

3 in = 0

HS= 3.134

VS= 1.956

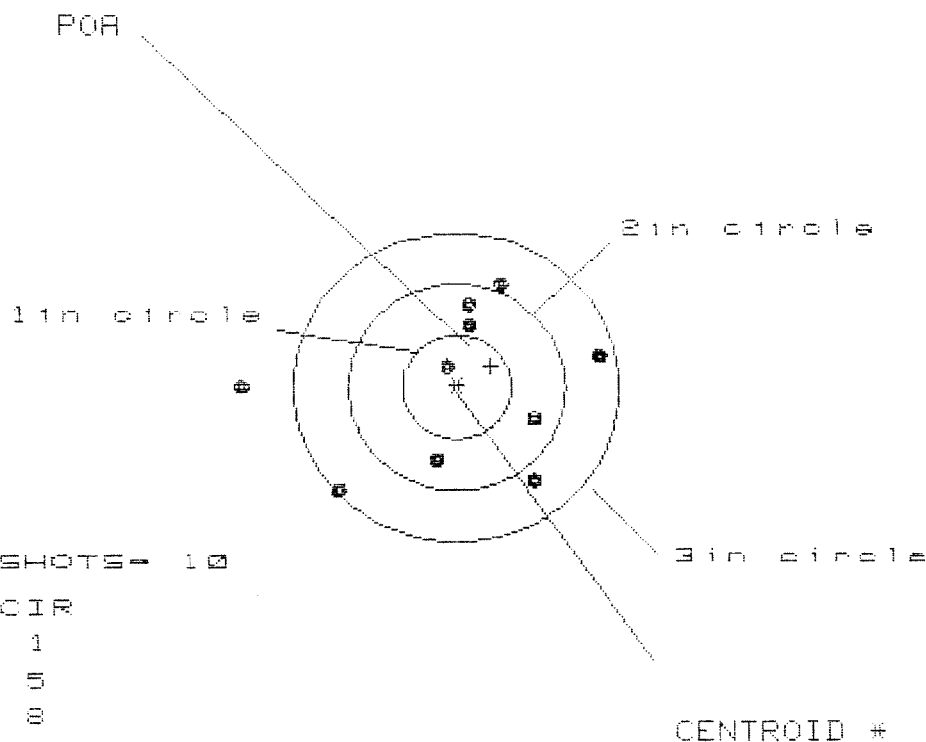
GS= 3.166

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.329	1.128	1.246
MINIMUM X	:	-1.805	-1.524	-1.406
MAXIMUM Y	:	.955	.985	.605
MINIMUM Y	:	-1.001	-.971	-.848
CENTROID X	:	.158	.358	.240
CENTROID Y	:	-.234	-.264	-.387
POA TO CENTROID in.	:	.282	.445	.455
MIN RADIUS	:	.361	.537	.400
MEAN RADIUS	:	1.166	1.069	1.030
MAX RADIUS	:	1.826	1.534	1.407
HORIZONTAL SPREAD	:	3.134	2.652	2.652
VERTICAL SPREAD	:	1.956	1.956	1.453
EXTREME SPREAD	:	3.166	2.726	2.652
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.295

VS= 2.004

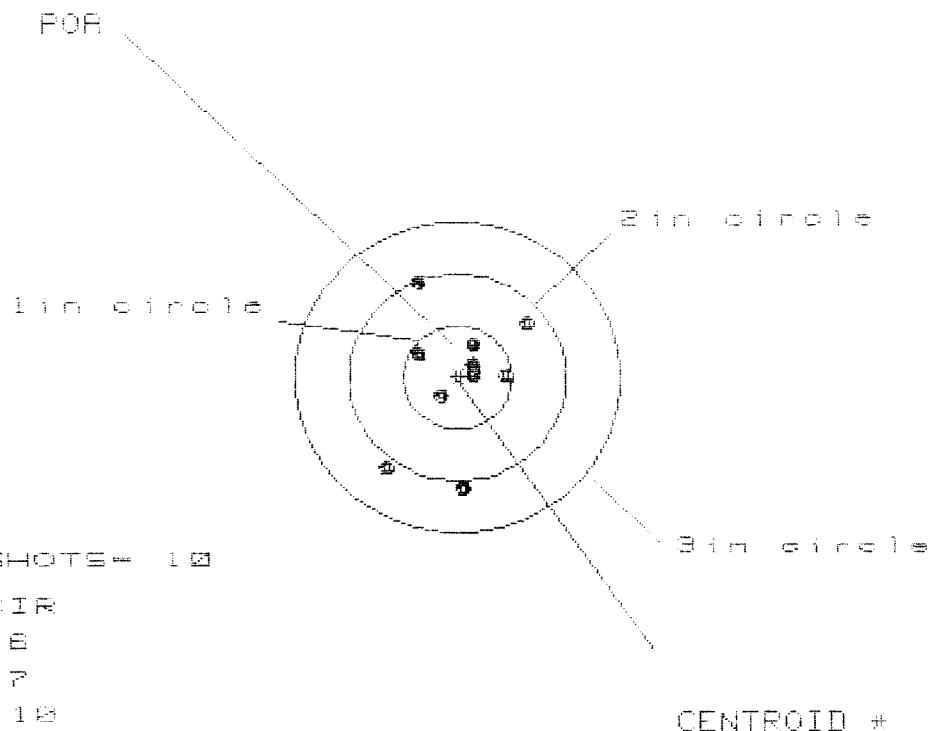
GS= 3.307

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	1.051	.881
MINIMUM X	:	-2.020	-1.358	-.570
MAXIMUM Y	:	.993	.996	.870
MINIMUM Y	:	-1.011	-1.008	-1.061
CENTROID X	:	-.312	-.088	.082
CENTROID Y	:	-.202	-.205	-.079
POA TO CENTROID in.	:	.372	.223	.114
MIN RADIUS	:	.197	.374	.494
MEAN RADIUS	:	1.017	.884	.763
MAX RADIUS	:	2.020	1.692	1.113
HORIZONTAL SPREAD	:	3.295	2.409	1.451
VERTICAL SPREAD	:	2.004	2.004	1.931
EXTREME SPREAD	:	3.307	2.742	1.951
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 6

2in = 7

3in = 10

HE= 1.247

VS= 2.078

GS= 2.114

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.603	.532	.524
MINIMUM X	-.644	-.455	-.464
MAXIMUM Y	.965	.862	.710
MINIMUM Y	-1.113	-1.216	-.384
CENTROID X	-.140	-.069	-.061
CENTROID Y	-.126	-.023	.129
POR TO CENTROID in.	.188	.073	.142
MIN RADIUS	.171	.051	.125
MEAN RADIUS	.590	.501	.413
MAX RADIUS	1.123	1.218	.848
HORIZONTAL SPREAD	1.247	.987	.987
VERTICAL SPREAD	2.078	2.078	1.094
EXTREME SPREAD	2.114	2.114	1.277
NUMBER IN ONE INCH CIRCLE	=	6	
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. C6523321

DATE 10/31/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.14	2.20	256	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.13	2.13	262	
PULL #3	2.26	2.21	2.26	260	
PULL #4	2.23	2.19	2.22	281	
PULL #5	2.23	2.13	2.15	285	
TOTAL	11.15	10.8	10.98		
AVG.	2.23	2.16	2.196		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.50		
PULL #2	3.25	3.42		
PULL #3	3.29	3.45		
PULL #4	3.12	3.50		
PULL #5	3.23	3.40		
TOTAL	16.33	17.27		
AVG.	3.266	3.454		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.24		4.33
PULL #2	4.24	4.41		4.36
PULL #3	4.21	4.40		4.42
PULL #4	4.26	4.30		4.43
PULL #5	4.20	4.20		4.31
TOTAL	21.09	21.55		21.85
AVG.	4.218	4.31		4.37

L 116
M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523321

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KH
600	Proof		10/2/90	KH
607	Check Headspace		10/2/90	KH
610	Dis-assemble Gun		10/2/90	KH
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	LL
617	Drill and Tap Sight Holes		10/8/90	KLB
618	Polish Barrel <i>KLB</i>		10/9/90	KLB
620	Apply Coatings (Barrel Action)		10-20-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	KH
	C) Inspect Ejector Hole for Chamfer		10/21/90	KH
	D) Oil Firing Pin Ass'y		10/21/90	KH
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/90	KH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/31/90	W.B
	G) Safety Off Force	7 3/4	7 3/4	7 3/4			10/31/90	W.B
	H) Trigger Pull Test & Retainability						10/31/90	W.B
	I) Firing Pin Indent	.021	.021	.021			10/31/90	W.B
	J) Assemble Stock						11/2/90	W.B
	K) Assemble Swivel Studs						11-20-90	W.B
	L) Attach Front and Rear Sight Assemblies						11/2/90	W.B
	M) Iron Sight Alignment						11/2/90	W.B
	N) Detach Front & Rear Sights & place in numbered container						11/2/90	W.B
	O) Attach Scope to Rifle						11/2/90	W.B
	P) Detach & Attach Scope 20 Times						11/2/90	W.B
640	Gallery Target & Test						11-3-90	W.B
	A) Time						11-3-90	W.B
	B) Malfunctions						11-3-90	W.B
	C) Pierced Primers						11-3-90	W.B
	D) Optical Clarity of Scope						11-3-90	W.B
645	Inspect for Live Ammo						11-3-90	W.B
655	Final Inspection							
	A) Headspace						11-20-90	W.B
	B) Trigger Pull	256	262	260	281	285	11-20-90	W.B
	C) Function						11-20-90	W.B
660	Pack						12-17-90	W.B

Remington



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

MODEL 700™ H24

SERIAL NO.

C6523321

ORDER NO.

5716

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



5716 C6523321

UPC



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