

06523338

MODEL 706™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

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.

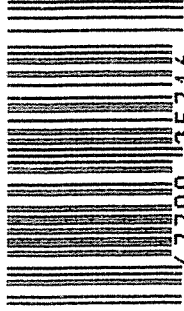
SERIAL NO.
C6523338

ORDER NO.
5716



5716 C6523338

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523338

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR.
615	Rollmark Caliber		9-26-90	LS.
617	Drill and Tap Sight Holes		9/28/90	WB
618	Polish Barrel <i>WB</i>		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/11/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/11/90	WB
	G) Safety Off Force	3	3	3			10/11/90	WB
	H) Trigger Pull Test & Retainability						10/11/90	WB
	I) Firing Pin Indent	.0205	.021	.021			10/11/90	WB
	J) Assemble Stock						10/18/90	RW
	K) Assemble Swivel Studs						2/18/90	RS
	L) Attach Front and Rear Sight Assemblies						10/18/90	RW
	M) Iron Sight Alignment						10/18/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/18/90	RW
	O) Attach Scope to Rifle						10/18/90	RW
	P) Detach & Attach Scope 20 Times						10/18/90	RW
640	Gallery Target & Test						10-24-90	DH
	A) Time						10-24-90	DH
	B) Malfunctions						10-24-90	DH
	C) Pierced Primers						10-24-90	DH
	D) Optical Clarity of Scope						10-24-90	DH
645	Inspect for Live Ammo						10-24-90	DH
655	Final Inspection						3/18/90	RS
	A) Headspace						2/18/90	RS
	B) Trigger Pull	238	239	242	232	223	2/18/90	RS
	C) Function						2/18/90	RS
660	Pack						12/11/90	NF

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # ~~C6523488~~ C6523338
24 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.137091
1 TO	2	.156544
1 TO	3	.61264
1 TO	4	.629925
1 TO	5	.561471

$\frac{3}{4}$ $\frac{24}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0358
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194523
THE AMR FOR THIS RIFLE IS: .9742

24 Oct 1998

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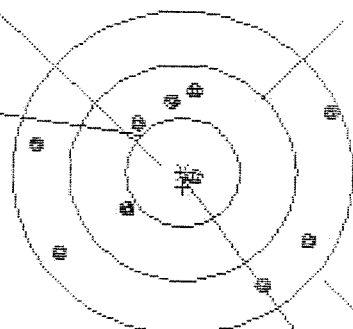
CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

CENTROID *

HS = 2.588

VS = 1.813

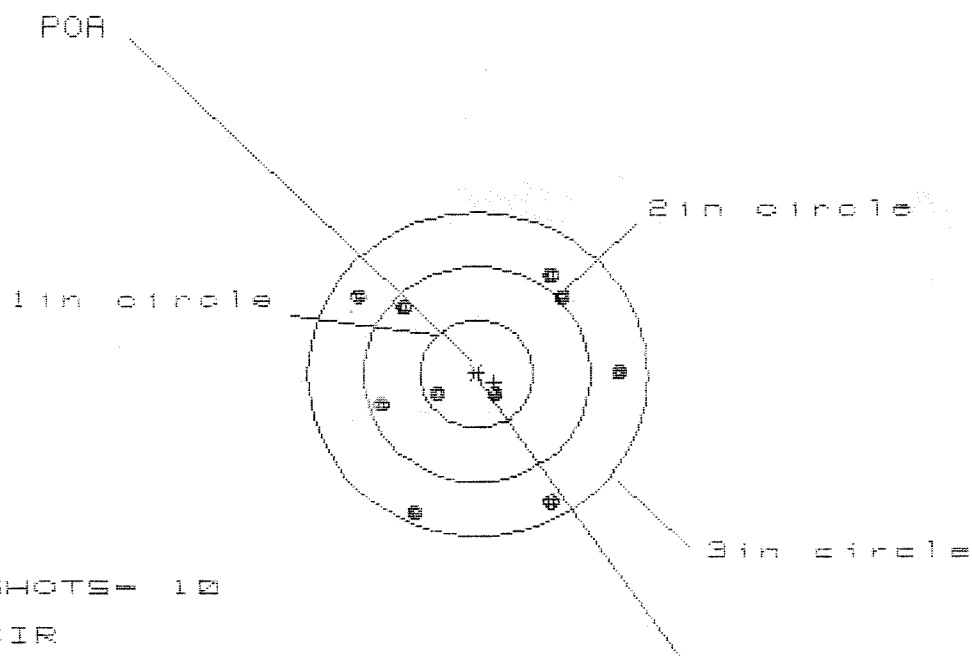
GS = 2.777

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.337	1.219	1.097
MINIMUM X	-1.251	-1.103	-1.225
MAXIMUM Y	.780	.839	.754
MINIMUM Y	-1.033	-.974	-1.059
CENTROID X	-.005	-.153	-.031
CENTROID Y	.137	.078	.163
POA TO CENTROID in.	.137	.172	.166
MIN RADIUS	.059	.215	.089
MEAN RADIUS	.924	.866	.804
MAX RADIUS	1.440	1.329	1.311
HORIZONTAL SPREAD	2.588	2.322	2.322
VERTICAL SPREAD	1.813	1.813	1.813
EXTREME SPREAD	2.777	2.484	2.484
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.303

VS= 2.213

GS= 2.498

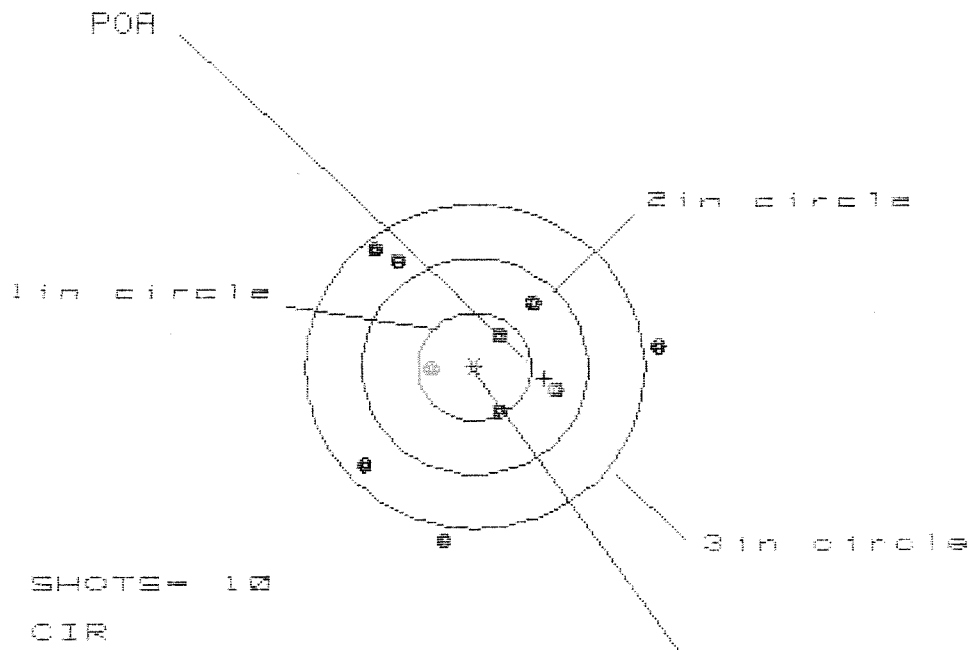
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.228	1.296
MINIMUM X	:	-1.013	-1.075	-1.007
MAXIMUM Y	:	.956	.816	.654
MINIMUM Y	:	-1.257	-1.303	-.549
CENTROID X	:	-.150	-.088	-.156
CENTROID Y	:	.078	.218	.380
POA TO CENTROID in.	:	.169	.235	.411
MIN RADIUS	:	.274	.378	.553
MEAN RADIUS	:	.984	.944	.880
MAX RADIUS	:	1.375	1.411	1.329
HORIZONTAL SPREAD	:	2.303	2.303	2.303
VERTICAL SPREAD	:	2.213	2.119	1.203
EXTREME SPREAD	:	2.498	2.481	2.410
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 2.637

VS = 2.704

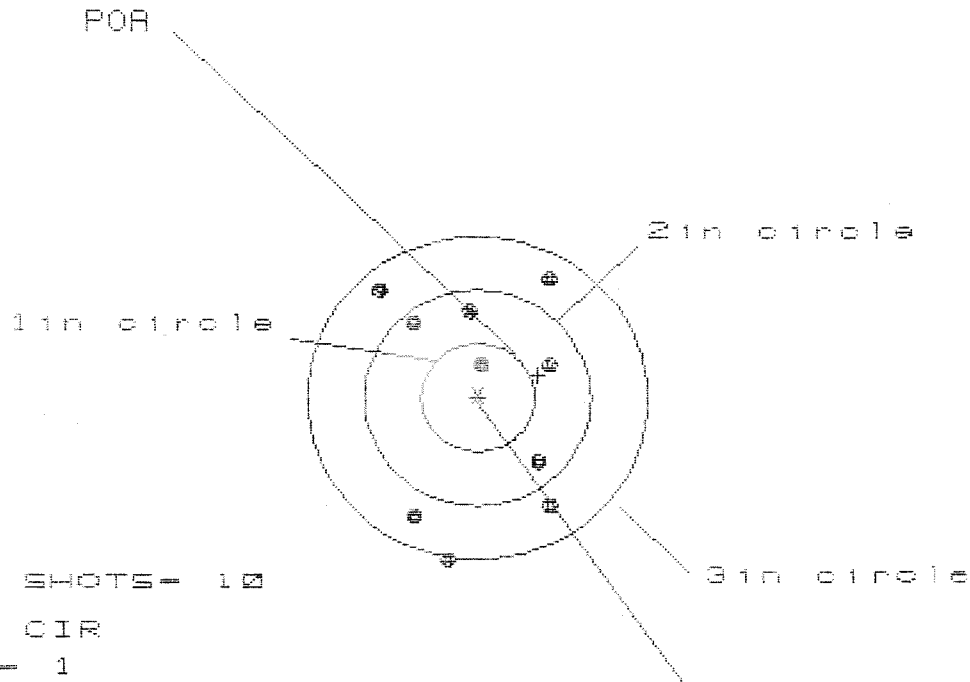
GS = 2.841

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.657	.855	.837
MINIMUM X	:	-.980	-.796	-.814
MAXIMUM Y	:	1.133	1.149	.955
MINIMUM Y	:	-1.571	-1.555	-1.088
CENTROID X	:	-.617	-.801	-.783
CENTROID Y	:	.109	.093	.287
POA TO CENTROID in.	:	.626	.806	.834
MIN RADIUS	:	.364	.204	.318
MEAN RADIUS	:	.988	.914	.819
MAX RADIUS	:	1.663	1.561	1.359
HORIZONTAL SPREAD	:	2.637	1.651	1.651
VERTICAL SPREAD	:	2.704	2.704	2.043
EXTREME SPREAD	:	2.841	2.752	2.101
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 1.548

VS = 2.571

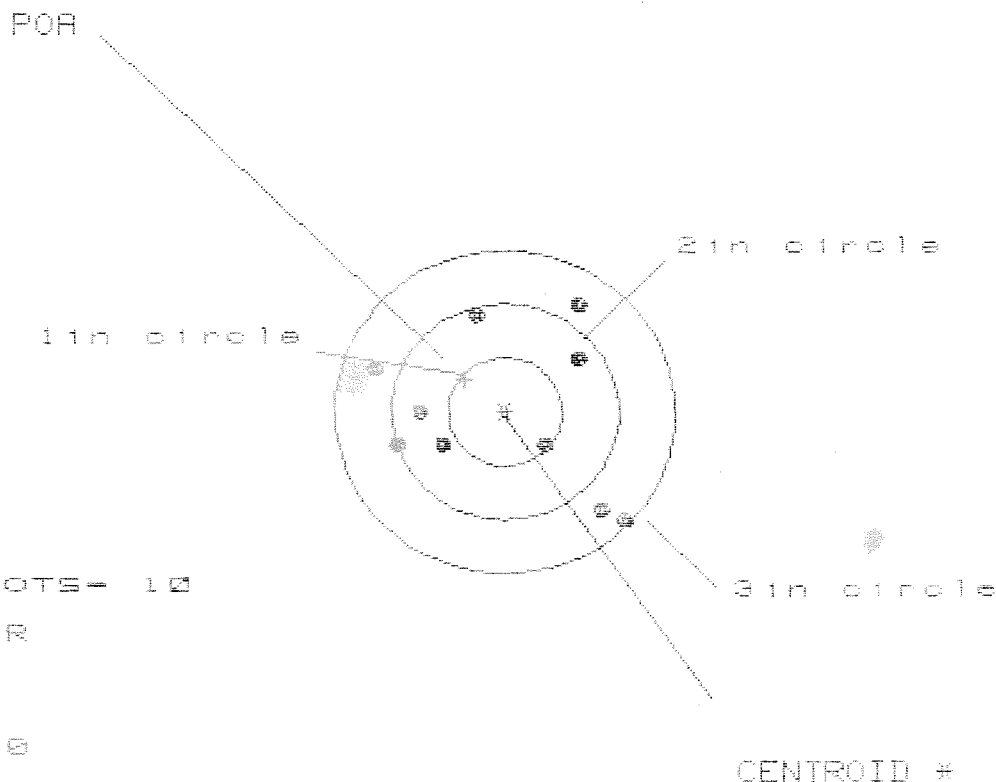
GS = 2.728

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.642	.608	.491
MINIMUM X	:	-.906	-.940	-.721
MAXIMUM Y	:	1.096	.932	1.036
MINIMUM Y	:	-1.475	-1.304	-1.200
CENTROID X	:	-.534	-.500	-.383
CENTROID Y	:	-.205	-.041	-.145
POA TO CENTROID in.	:	.572	.502	.410
MIN RADIUS	:	.263	.108	.260
MEAN RADIUS	:	1.002	.909	.871
MAX RADIUS	:	1.505	1.424	1.384
HORIZONTAL SPREAD	:	1.548	1.548	1.212
VERTICAL SPREAD	:	2.571	2.236	2.236
EXTREME SPREAD	:	2.728	2.514	2.514
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.187

VS= 1.998

GS= 2.635

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	.976	.922
MINIMUM X	:	-1.101	-.980	-.859
MAXIMUM Y	:	.971	.857	.725
MINIMUM Y	:	-1.027	-1.055	-.547
CENTROID X	:	.350	.229	.107
CENTROID Y	:	-.298	-.184	-.052
POR TO CENTROID in.	:	.460	.294	.119
MIN RADIUS	:	.465	.573	.568
MEAN RADIUS	:	.973	.898	.812
MAX RADIUS	:	1.495	1.437	1.173
HORIZONTAL SPREAD	:	2.187	1.956	1.781
VERTICAL SPREAD	:	1.998	1.912	1.272
EXTREME SPREAD	:	2.635	2.396	2.056
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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

SERIAL NO. C6523338
DATE 10/11/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.52	2.50	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.50	2.52	2.39	
PULL #3	2.52	2.56	2.51	2.42	
PULL #4	2.50	2.30	2.45	2.32	
PULL #5	2.49	2.55	2.46	2.23	
TOTAL	12.32	12.43	12.44		
AVG.	2.46	2.49	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.14		
PULL #2	3.05	3.12		
PULL #3	3.15	3.11		
PULL #4	3.13	3.05		
PULL #5	3.12	3.08		
TOTAL	15.58	15.50		
AVG.	3.11	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.19		4.08
PULL #2	4.10	4.25		4.15
PULL #3	4.13	4.19		4.14
PULL #4	4.03	4.25		4.15
PULL #5	4.09	4.22		4.16
TOTAL	20.43	21.10		20.68
AVG.	4.08	4.22		4.13