

C6498822

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498822

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/22/90	GS
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6/4/90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	94

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/26/90	811
	G) Safety Off Force	3	3	3			7/26/90	811
	H) Trigger Pull Test & Retainability						8/23/90	94
	I) Firing Pin Indent	.0205	.0205	.0205			7/26/90	811
	J) Assemble Stock						7/30/90	RW
	K) Assemble Swivel Studs						8/24/90	94
	L) Attach Front and Rear Sight Assemblies						7/30/90	RW
	M) Iron Sight Alignment						7/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/90	RW
	O) Attach Scope to Rifle						7/30/90	RW
	P) Detach & Attach Scope 20 Times						7/30/90	RW
640	Gallery Target & Test						8-8-90	#
	A) Time						"	#
	B) Malfunctions						"	#
	C) Pierced Primers						"	#
	D) Optical Clarity of Scope						"	#
645	Inspect for Live Ammo						8-8-90	#
655	Final Inspection							
	A) Headspace						8/29/90	98
	B) Trigger Pull	2.23	2.08	2.20	2.10	2.11	8/23/90	811
	C) Function						8/24/90	98
660	Pack						9/20/00	15

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6498822

DATE 8/23/90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.23	2.18	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.21	2.20	2.08	
PULL #3	2.26	2.21	2.22	2.20	
PULL #4	2.27	2.19	2.10	2.10	
PULL #5	2.19	2.20	2.31	2.11	
TOTAL	11.40	11.04	11.01	10.72	
AVG.	2.28	2.208	2.202	2.144	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.11		
PULL #2	3.35	3.21		
PULL #3	3.20	3.22		
PULL #4	3.03	3.10		
PULL #5	3.21	3.12		
TOTAL	15.98	15.76		
AVG.	3.196	3.152		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.26		4.21
PULL #2	4.27	4.23		4.14
PULL #3	4.23	4.25		4.11
PULL #4	4.25	4.27		4.18
PULL #5	4.23	4.19		4.19
TOTAL	21.24	21.20		20.83
AVG.	4.248	4.24		4.166

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498822
8 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.329662
1 TO	2	.496557
1 TO	3	.898902
1 TO	4	.219586
1 TO	5	.677528

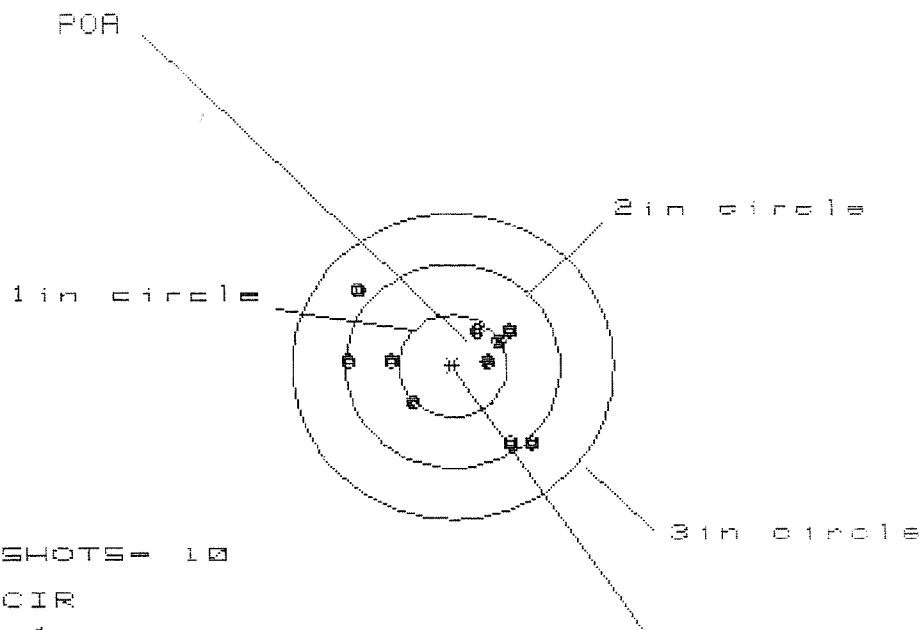
14th <----POA
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1814
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0552
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189613
THE AMR FOR THIS RIFLE IS: .9098

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498822

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.677

VS = 1.449

GS = 2.136

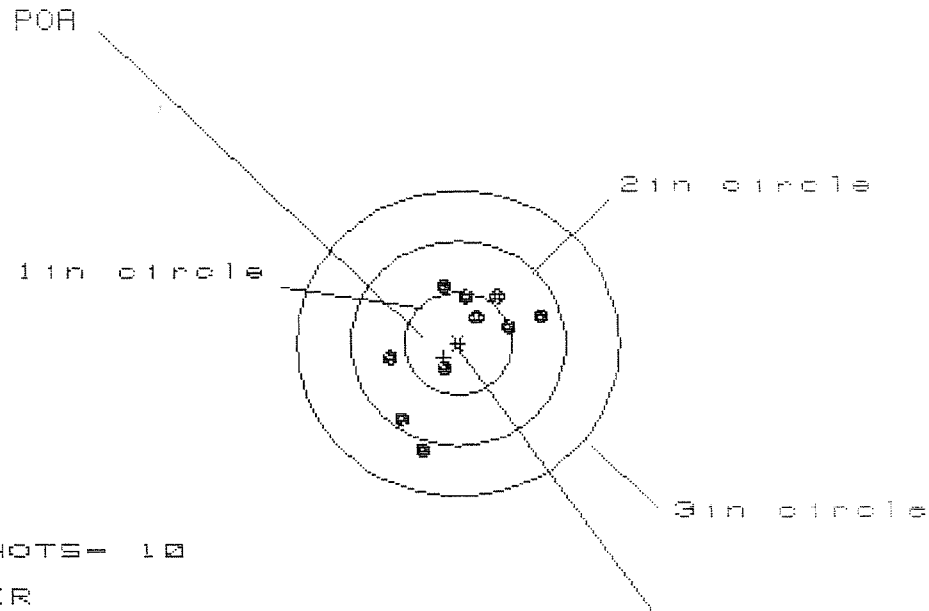
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.721	.626	.543
MINIMUM X	-.957	-1.051	-.973
MAXIMUM Y	.706	.391	.308
MINIMUM Y	-.743	-.664	-.747
CENTROID X	-.326	-.231	-.309
CENTROID Y	-.049	-.128	-.045
POA TO CENTROID in.	.329	.264	.313
MIN RADIUS	.308	.252	.292
MEAN RADIUS	.683	.626	.584
MAX RADIUS	1.105	1.065	.977
HORIZONTAL SPREAD	1.677	1.677	1.516
VERTICAL SPREAD	1.449	1.055	1.055
EXTREME SPREAD	2.136	1.873	1.685
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

8 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10
 # IN CIR
 1in = 4
 2in = 8
 3in = 10
 HS= 1.317
 VS= 1.506
 GS= 1.665

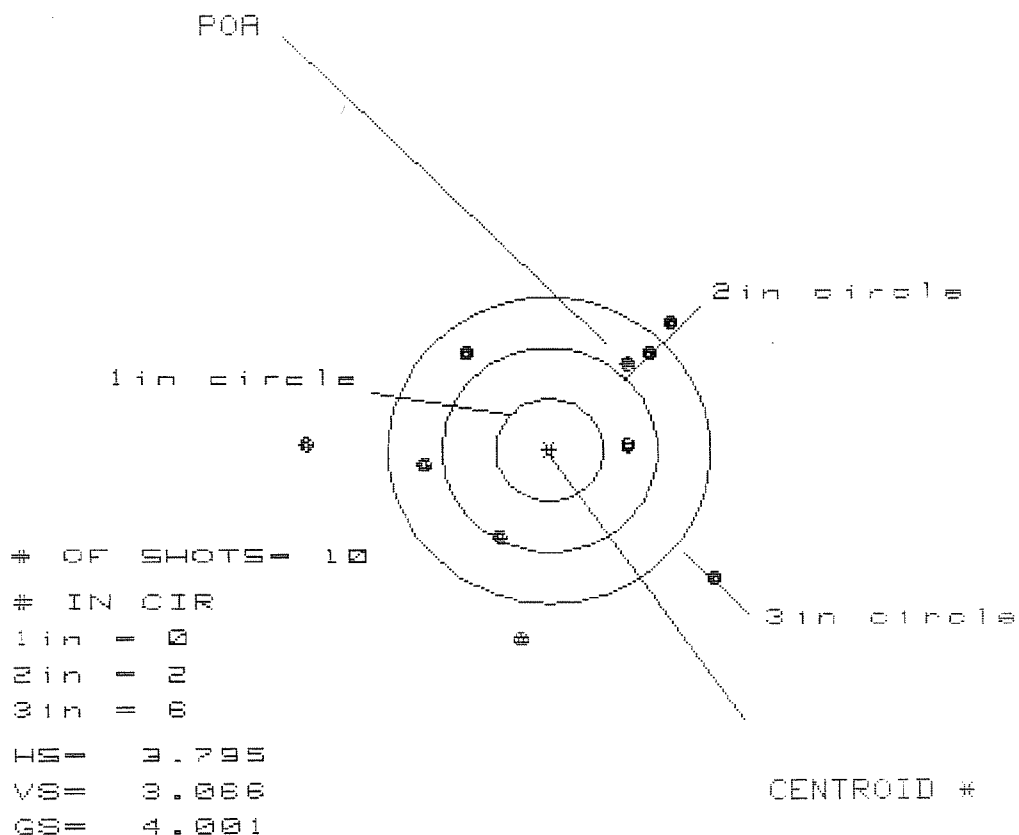
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.721	.686	.619
MINIMUM X	:	-.596	-.631	-.698
MAXIMUM Y	:	.517	.407	.300
MINIMUM Y	:	-.989	-.851	-.426
CENTROID X	:	.134	.169	.236
CENTROID Y	:	.138	.248	.355
POA TO CENTROID in.	:	.192	.301	.426
MIN RADIUS	:	.251	.155	.033
MEAN RADIUS	:	.581	.501	.398
MAX RADIUS	:	1.041	1.005	.763
HORIZONTAL SPREAD	:	1.317	1.317	1.317
VERTICAL SPREAD	:	1.506	1.258	.726
EXTREME SPREAD	:	1.665	1.608	1.376
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

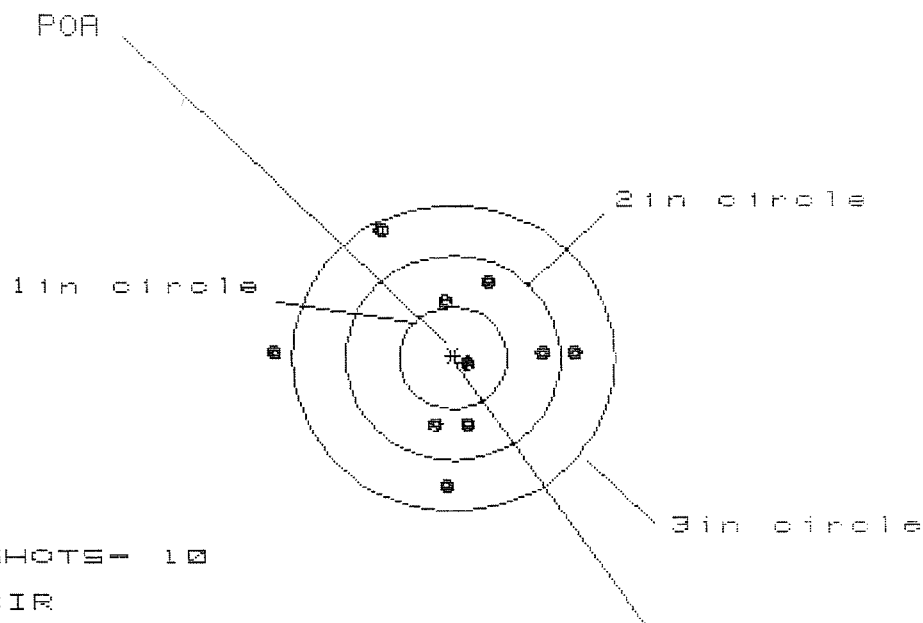


PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.528
MINIMUM X	-2.267
MAXIMUM Y	1.238
MINIMUM Y	-1.828
CENTROID X	-.730
CENTROID Y	-.852
POA TO CENTROID in.	1.121
MIN RADIUS	.715
MEAN RADIUS	1.418
MAX RADIUS	2.268
HORIZONTAL SPREAD	3.795
VERTICAL SPREAD	3.066
EXTREME SPREAD	4.001
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	6

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.813

VS= 2.404

GS= 2.813

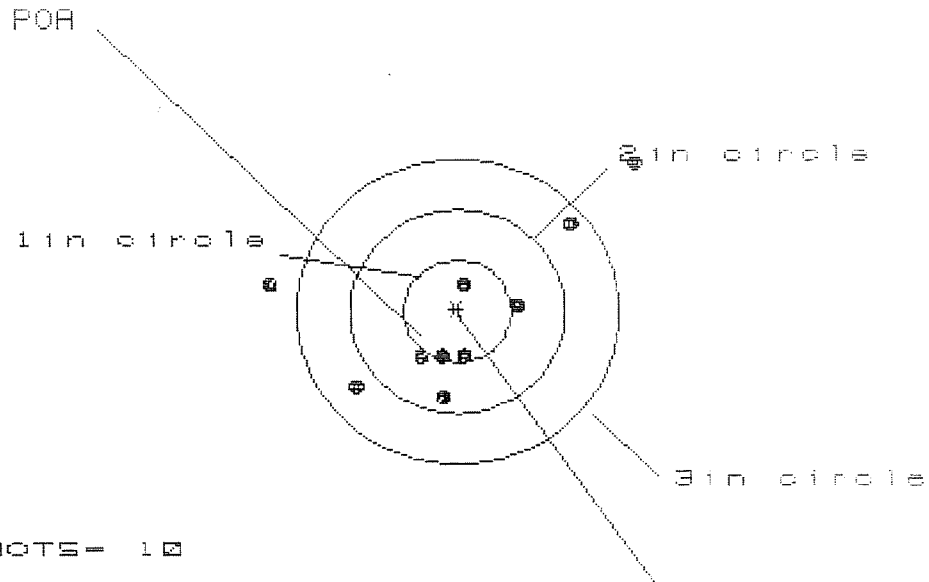
CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.148
MINIMUM X	-1.665
MAXIMUM Y	1.202
MINIMUM Y	-1.202
CENTROID X	-.129
CENTROID Y	.048
POA TO CENTROID in.	.138
MIN RADIUS	.138
MEAN RADIUS	.900
MAX RADIUS	1.665
HORIZONTAL SPREAD	2.813
VERTICAL SPREAD	2.404
EXTREME SPREAD	2.813
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.344

VS= 2.291

GS= 3.569

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.621	1.258	1.065
MINIMUM X	:	-1.723	-1.542	-.981
MAXIMUM Y	:	1.495	1.025	1.077
MINIMUM Y	:	-.796	-.629	-.577
CENTROID X	:	.144	-.037	.156
CENTROID Y	:	.439	.272	.220
POA TO CENTROID in.	:	.461	.275	.270
MIN RADIUS	:	.257	.298	.194
MEAN RADIUS	:	.967	.784	.656
MAX RADIUS	:	2.206	1.622	1.514
HORIZONTAL SPREAD	:	3.344	2.800	2.046
VERTICAL SPREAD	:	2.291	1.654	1.654
EXTREME SPREAD	:	3.569	2.865	2.608
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

SERIAL NO.

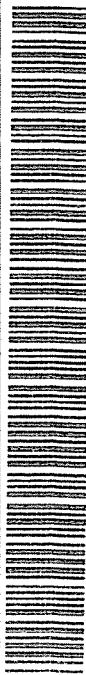
C6498822

ORDER NO.

5715

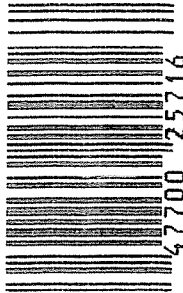
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5715 C6498822

UPC



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