

C6594508

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ **M24**

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

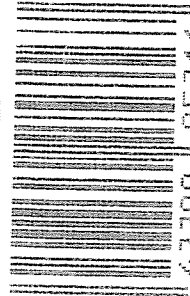
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO. C6594508	ORDER NO. 5715
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5715 C6594508

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594508

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	KJ
600	Proof		10/31/90	KJ
607	Check Headspace		10/31/90	KJ
610	Dis-assemble Gun		10/31/90	KJ
612	Magnaflux Barrel Action		11/2/90	KCD
	Magnaflux Bolt		11/2/90	KCD
615	Rollmark Caliber		11/2/90	GS
617	Drill and Tap Sight Holes		11/5/90	LB
618	Polish Barrel <i>LB</i>		11/6/90	LB
620	Apply Coatings (Barrel Action)		11/26/90	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-791	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	4.50	4.25			1/2/91	KT
	G) Safety Off Force	2.75	3.25	3.25			1/10/91	KT
	H) Trigger Pull Test & Retainability						1-7-91	DH
	I) Firing Pin Indent	.020	.021	.020			1/2/91	KT
	J) Assemble Stock						1/14/91	KA
	K) Assemble Swivel Studs						1-15-91	KA
	L) Attach Front and Rear Sight Assemblies						1/14/91	KA
	M) Iron Sight Alignment						1/14/91	KA
	N) Detach Front & Rear Sights & place in numbered container						1/14/91	KA
	O) Attach Scope to Rifle						1/14/91	KA
	P) Detach & Attach Scope 20 Times						1/14/91	KA
640	Gallery Target & Test						1-14-91	DH
	A) Time						1-14-91	DH
	B) Malfunctions						1-14-91	DH
	C) Pierced Primers						1-14-91	DH
	D) Optical Clarity of Scope						1-14-91	DH
645	Inspect for Live Ammo						1-14-91	DH
655	Final Inspection							
	A) Headspace						1-15-91	KA
	B) Trigger Pull	2.31	2.26	2.28	2.34	2.46	1-15-91	KA
	C) Function						1-15-91	KA
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594508

DATE 1-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.70	2.66	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.71	2.71	2.16	
PULL #3	2.48	2.69	2.63	2.28	
PULL #4	2.47	2.22	2.62	2.34	
PULL #5	2.49	2.59	2.71	2.46	
TOTAL	12.58	12.91	13.33		
AVG.	2.51	2.58	2.66		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.45		
PULL #2	3.36	3.48		
PULL #3	3.54	3.05		
PULL #4	3.45	3.19		
PULL #5	3.54	3.18		
TOTAL	17.27	16.35		
AVG.	3.45	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.02		4.00
PULL #2	4.38	4.08		4.07
PULL #3	4.23	4.07		4.05
PULL #4	4.45	4.08		4.14
PULL #5	4.52	4.10		4.02
TOTAL	21.86	20.35		20.28
AVG.	4.37	4.07		4.05

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594508
15 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.264093
1 TO	2	.12912
1 TO	3	.499802
1 TO	4	.442848
1 TO	5	.0710282

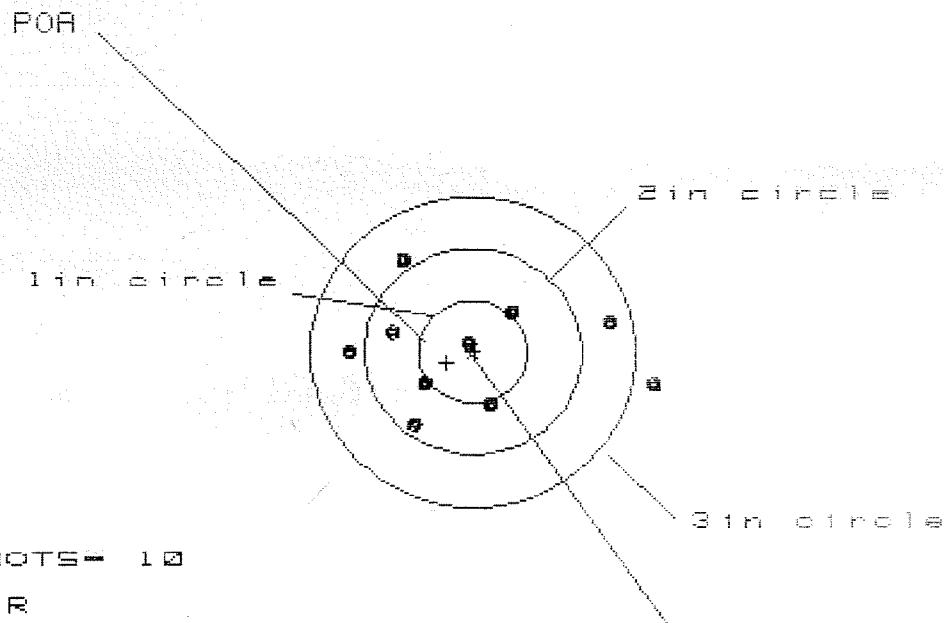
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0554
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0146
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0572915
THE AMR FOR THIS RIFLE IS: .8788

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534508

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.845

VS= 1.565

GS= 2.868

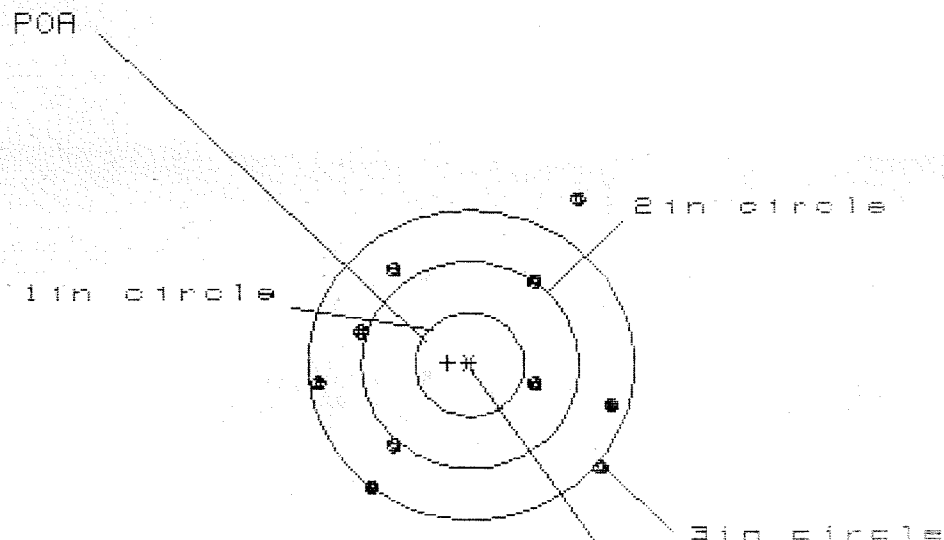
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.694	1.434	.754
MINIMUM X	:	-1.151	-.962	-.783
MAXIMUM Y	:	.859	.821	.849
MINIMUM Y	:	-.706	-.744	-.716
CENTROID X	:	.241	.052	-.127
CENTROID Y	:	.108	.146	.118
POA TO CENTROID in.	:	.264	.155	.173
MIN RADIUS	:	.124	.193	.308
MEAN RADIUS	:	.865	.746	.643
MAX RADIUS	:	1.729	1.450	.983
HORIZONTAL SPREAD	:	2.845	2.396	1.537
VERTICAL SPREAD	:	1.565	1.565	1.565
EXTREME SPREAD	:	2.868	2.407	1.646
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 1

3in = 8

HS = 2.690

VS = 2.716

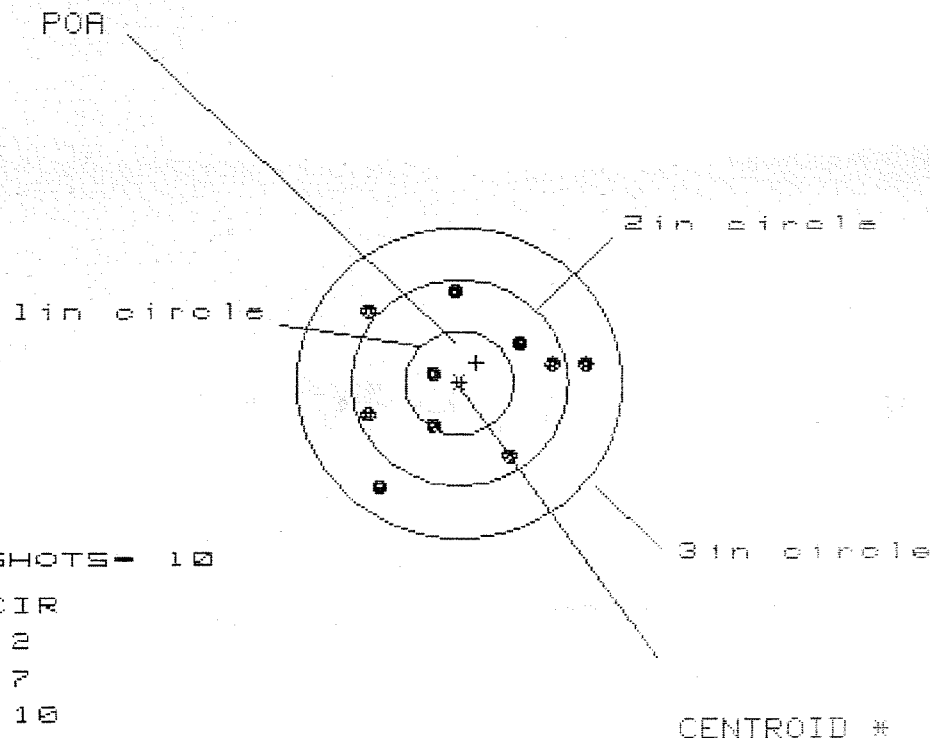
GS = 3.280

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.286	1.392	1.551
MINIMUM X	:	-1.405	-1.298	-1.139
MAXIMUM Y	:	1.581	1.127	1.026
MINIMUM Y	:	-1.135	-.959	-1.060
CENTROID X	:	.205	.099	-.060
CENTROID Y	:	-.016	-.192	-.091
POA TO CENTROID in.	:	.206	.216	.109
MIN RADIUS	:	.659	.741	.807
MEAN RADIUS	:	1.250	1.169	1.108
MAX RADIUS	:	1.849	1.504	1.583
HORIZONTAL SPREAD	:	2.690	2.690	2.690
VERTICAL SPREAD	:	2.716	2.086	2.086
EXTREME SPREAD	:	3.280	2.720	2.690
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.021

VS= 1.845

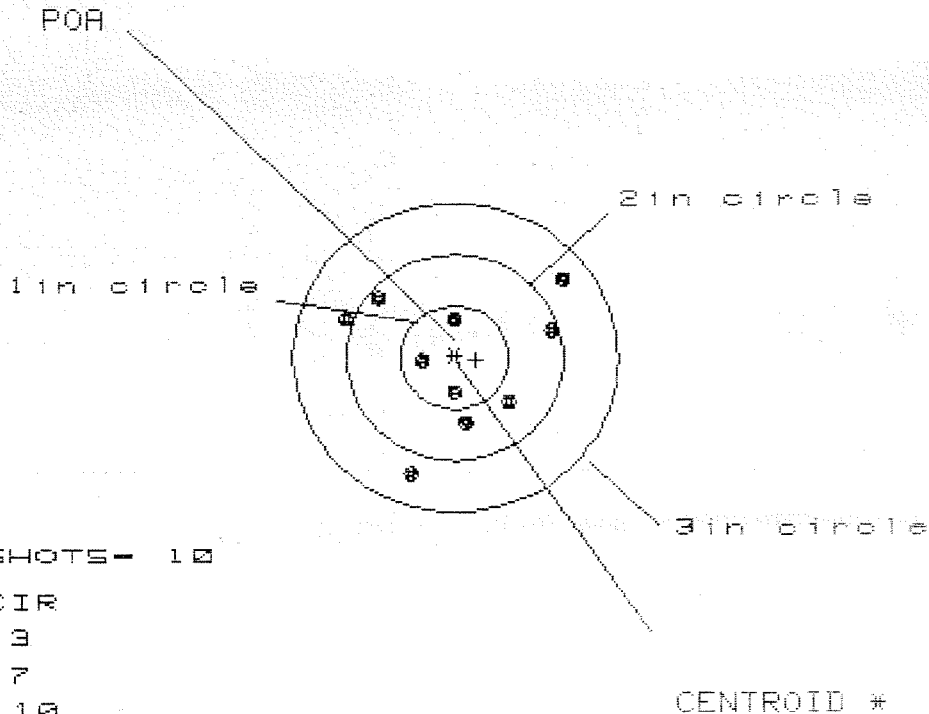
GS= 2.173

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.136	1.057	.862
MINIMUM X	:	-.885	-.964	-.832
MAXIMUM Y	:	.886	.780	.789
MINIMUM Y	:	-.959	-.802	-.792
CENTROID X	:	-.158	-.079	-.211
CENTROID Y	:	-.193	-.086	-.096
POA TO CENTROID in.:	:	.249	.117	.232
MIN RADIUS	:	.252	.296	.166
MEAN RADIUS	:	.828	.782	.732
MAX RADIUS	:	1.194	1.109	1.001
HORIZONTAL SPREAD	:	2.021	2.021	1.694
VERTICAL SPREAD	:	1.845	1.582	1.582
EXTREME SPREAD	:	2.173	2.075	1.923
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Jan 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.018

VS= 1.891

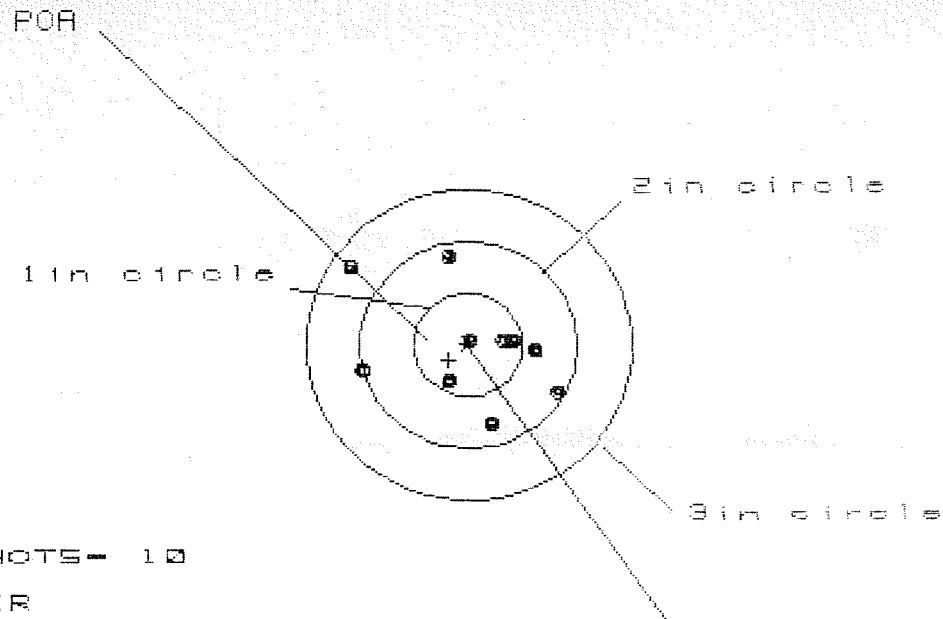
GS= 2.349

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.996	.983	.947
MINIMUM X	:	-1.022	-.911	-.947
MAXIMUM Y	:	.811	.710	.586
MINIMUM Y	:	-1.080	-.990	-.630
CENTROID X	:	-.194	-.305	-.269
CENTROID Y	:	.025	-.065	.059
POA TO CENTROID in.	:	.196	.312	.276
MIN RADIUS	:	.264	.166	.196
MEAN RADIUS	:	.762	.684	.642
MAX RADIUS	:	1.285	1.061	.997
HORIZONTAL SPREAD	:	2.018	1.894	1.894
VERTICAL SPREAD	:	1.891	1.700	1.216
EXTREME SPREAD	:	2.349	1.894	1.894
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.934

VS= 1.550

GS= 2.285

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.803	.678	.533
MINIMUM X	:	-1.131	-1.156	-.481
MAXIMUM Y	:	.825	.905	.888
MINIMUM Y	:	-.725	-.645	-.662
CENTROID X	:	.183	.308	.453
CENTROID Y	:	.149	.069	.086
POA TO CENTROID in.	:	.236	.316	.461
MIN RADIUS	:	.102	.178	.167
MEAN RADIUS	:	.689	.590	.489
MAX RADIUS	:	1.339	1.164	1.010
HORIZONTAL SPREAD	:	1.934	1.834	1.014
VERTICAL SPREAD	:	1.550	1.550	1.550
EXTREME SPREAD	:	2.285	1.856	1.667
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	

NUMBER IN THREE INCH CIRCLE =

10