

C6587553

MODEL 700TM M24

Model **SWS** TM

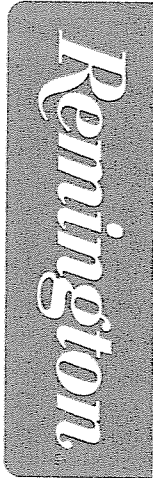
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DU PONT**
REG. U.S. PAT. & TM. OFF.

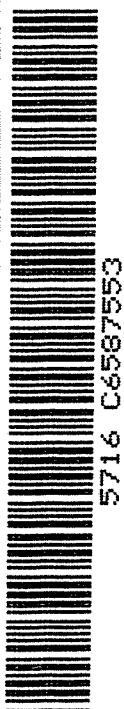
MODEL 700™ M24

MADE IN ILION, 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. C6587553	ORDER NO. 5716
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Ø1



UPC



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587553

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/19/90	KA
600	Proof		10/19/90	KA
607	Check Headspace		10/19/90	KA
610	Dis-assemble Gun		10/19/90	KA
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	GL
617	Drill and Tap Sight Holes		10/23/90	KB
618	Polish Barrel RB		10/24/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/7/90 11-8-90	KS JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 3/4	5 3/4			11/7/90	KS
	G) Safety Off Force	2 3/4	2 1/2	3.0			11/7/90	KS
	H) Trigger Pull Test & Retainability						11-8-90	SH
	I) Firing Pin Indent	.020	.021	.020			11/7/90	KS
	J) Assemble Stock						11/9/90	KS
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	KS
	M) Iron Sight Alignment						11/9/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	KS
	O) Attach Scope to Rifle						11/9/90	KS
	P) Detach & Attach Scope 20 Times						11/9/90	KS
640	Gallery Target & Test						11-12-90	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						11-12-90	KS
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	263	261	246	261	260	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/19/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587553

DATE 11-8-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.37	2.42	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.31	2.28	2.61	
PULL #3	2.36	2.38	2.33	2.46	
PULL #4	2.47	2.31	2.41	2.61	
PULL #5	2.48	2.22	2.31	2.60	
TOTAL	11.66	11.59	11.75		
AVG.	2.332	2.318	2.35		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.33		
PULL #2	3.05	3.48		
PULL #3	3.12	3.22		
PULL #4	3.22	3.18		
PULL #5	3.15	3.22		
TOTAL	15.76	16.43		
AVG.	3.152	3.286		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.29		4.24
PULL #2	4.17	4.33		4.26
PULL #3	4.49	4.23		4.18
PULL #4	4.22	4.40		4.39
PULL #5	4.43	4.43		4.34
TOTAL	21.52	21.68		21.41
AVG.	4.304	4.336		4.282

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587553
12 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.480926
1 TO 2	.57808
1 TO 3	.621136
1 TO 4	.646233
1 TO 5	.573917

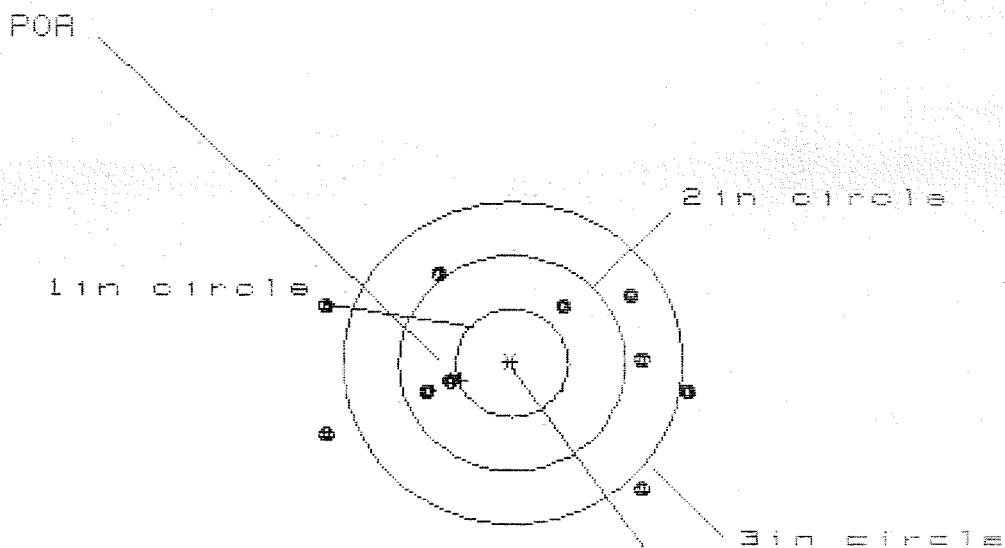
1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0148
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0078
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0167296
THE AMR FOR THIS RIFLE IS: .9954

12 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587553

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 0

2in - 3

3in - 6

HS- 3.222

VS- 1.991

GS- 3.311

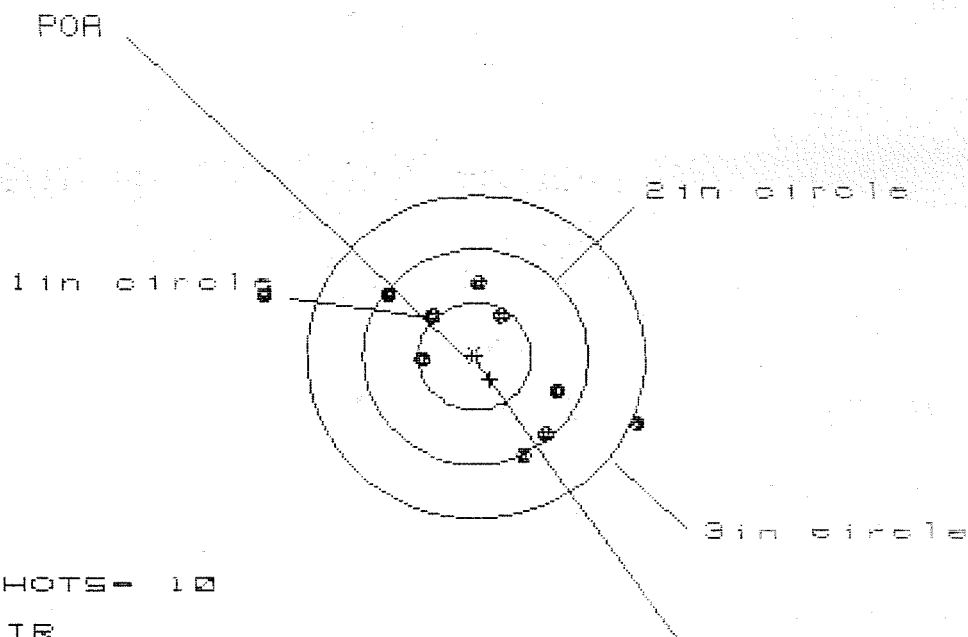
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.544	1.358	1.126
MINIMUM X	:	-1.678	-1.853	-1.174
MAXIMUM Y	:	.853	.773	.826
MINIMUM Y	:	-1.138	-1.218	-1.165
CENTROID X	:	.451	.637	.869
CENTROID Y	:	.167	.247	.194
POA TO CENTROID in.	:	.481	.684	.891
MIN RADIUS	:	.551	.547	.542
MEAN RADIUS	:	1.228	1.146	1.031
MAX RADIUS	:	1.823	1.900	1.374
HORIZONTAL SPREAD	:	3.222	3.211	2.300
VERTICAL SPREAD	:	1.991	1.991	1.991
EXTREME SPREAD	:	3.311	3.311	2.670
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 3.299

VS= 1.589

GS= 3.500

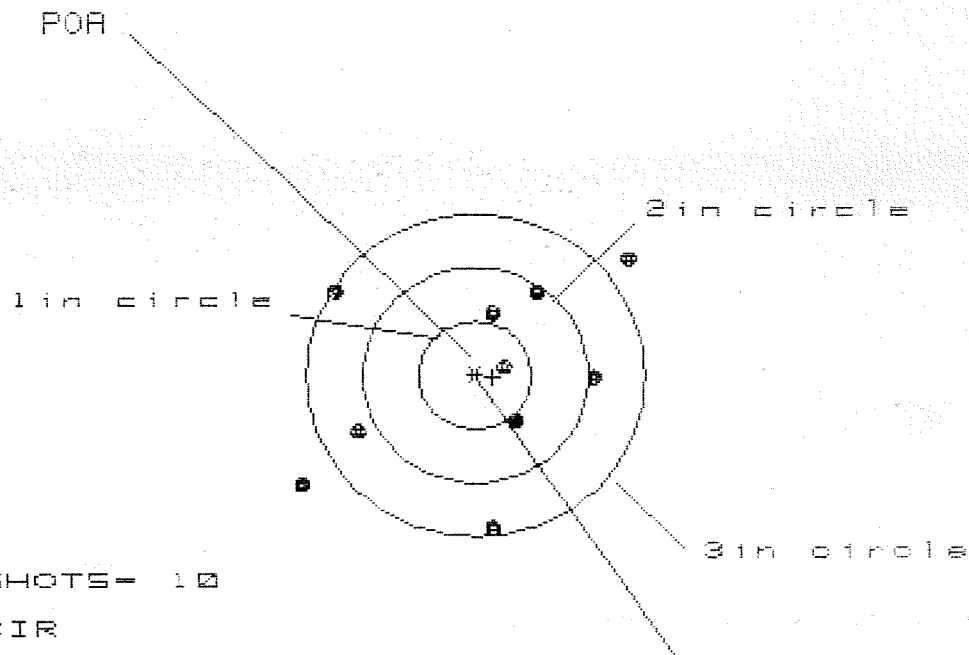
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.461	1.257	.666
MINIMUM X	:	-1.838	-.948	-.791
MAXIMUM Y	:	.693	.753	.683
MINIMUM Y	:	-.897	-.836	-.906
CENTROID X	:	-.125	.079	-.078
CENTROID Y	:	.216	.156	.226
POA TO CENTROID in.	:	.250	.175	.239
MIN RADIUS	:	.428	.406	.394
MEAN RADIUS	:	.928	.812	.721
MAX RADIUS	:	1.918	1.376	.990
HORIZONTAL SPREAD	:	3.299	2.205	1.457
VERTICAL SPREAD	:	1.589	1.589	1.589
EXTREME SPREAD	:	3.500	2.522	1.892
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 3

3 in - 8

HS- 2.884

VS- 2.452

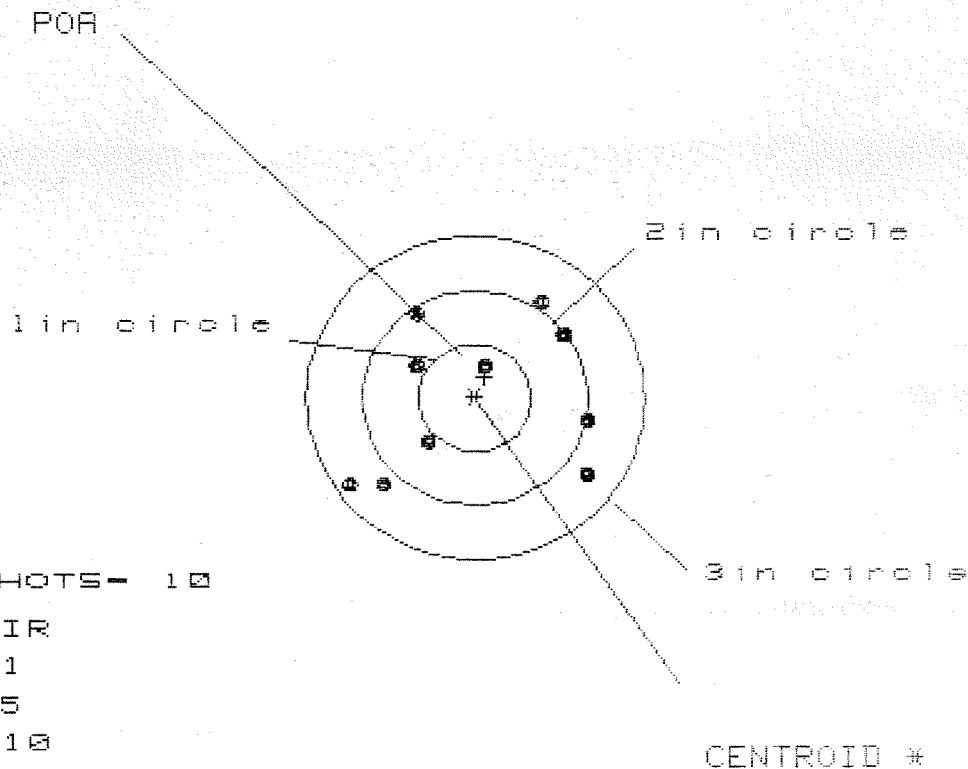
GS- 3.580

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.362
MINIMUM X	-1.522
MAXIMUM Y	1.058
MINIMUM Y	-1.394
CENTROID X	-.152
CENTROID Y	.018
POA TO CENTROID in.	.153
MIN RADIUS	.253
MEAN RADIUS	1.088
MAX RADIUS	1.856
HORIZONTAL SPREAD	2.884
VERTICAL SPREAD	2.452
EXTREME SPREAD	3.580
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.116

VS= 1.758

GS= 2.420

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.002	.878	.944
MINIMUM X	:	-1.114	-.988	-.878
MAXIMUM Y	:	.908	.819	.716
MINIMUM Y	:	-.850	-.939	-1.042
CENTROID X	:	-.085	.039	-.071
CENTROID Y	:	-.194	-.105	-.002
POA TO CENTROID in.	:	.212	.112	.071
MIN RADIUS	:	.352	.254	.166
MEAN RADIUS	:	.935	.871	.802
MAX RADIUS	:	1.372	1.363	1.363
HORIZONTAL SPREAD	:	2.116	1.866	1.822
VERTICAL SPREAD	:	1.758	1.758	1.758
EXTREME SPREAD	:	2.420	2.288	2.288
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.342

VS= 1.796

GS= 2.839

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	.969	.654
MINIMUM X	:	-1.235	-.881	-.760
MAXIMUM Y	:	.800	.711	.607
MINIMUM Y	:	-.996	-1.085	-.996
CENTROID X	:	-.015	.122	.001
CENTROID Y	:	-.168	-.079	-.168
POA TO CENTROID in.	:	.169	.145	.168
MIN RADIUS	:	.298	.315	.291
MEAN RADIUS	:	.798	.704	.640
MAX RADIUS	:	1.474	1.225	1.092
HORIZONTAL SPREAD	:	2.342	1.850	1.414
VERTICAL SPREAD	:	1.796	1.796	1.603
EXTREME SPREAD	:	2.839	2.364	1.769
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	