

C6348733

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400062660

Remington		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6348733	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		01	
 5716 C6348733			

UPC



0 47700 25716 7

25

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498733

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	90	RW
600	Proof	5 2	90	RW
607	Check Headspace	5 2	90	RW
610	Dis-assemble Gun	5 2	90	RW
612	Magnaflux Barrel Action	5-8-90		KCR
	Magnaflux Bolt	5-8-90		KCR
615	Rollmark Caliber		5/8/90	GB
617	Drill and Tap Sight Holes		5/9/90	LB
618	Polish Barrel RB		5/10/90	WB
620	Apply Coatings (Barrel Action)		5/16/90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/25/90	94
	G) Safety Off Force	3	3	3			5/25/90	94
	H) Trigger Pull Test & Retainability						5/25/90	98
	I) Firing Pin Indent	.0235	.0235	.0235			5/25/90	94
	J) Assemble Stock						5/29/90	RW
	K) Assemble Swivel Studs						6-6-90	DB
	L) Attach Front and Rear Sight Assemblies						5/29/90	RW
	M) Iron Sight Alignment						5/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/29/90	RW
	O) Attach Scope to Rifle						5/30/90	W.B
	P) Detach & Attach Scope 20 Times						5/30/90	W.B
640	Gallery Target & Test						6-1-90	4
	A) Time						"	4
	B) Malfunctions						"	4
	C) Pierced Primers						"	4
	D) Optical Clarity of Scope						"	4
645	Inspect for Live Ammo						6-1-90	4
655	Final Inspection						6-8-90	988
	A) Headspace							
	B) Trigger Pull	2.85	279	276	298	277	6-6-90	988
	C) Function						6-6-90	988
660	Pack						6-19-90	DA

SWS TRIGGER PULL TEST

TIME

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 06498733

DATE 5/25/90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.46	2.23	2.85	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.14	2.31	2.79	
PULL #3	2.37	2.31	2.36	2.76	
PULL #4	2.39	2.36	2.30	2.88	
PULL #5	2.35	2.30	2.15	2.77	
TOTAL	11.85	11.57	11.35		
AVG.	2.37	2.314	2.27		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.44		
PULL #2	3.33	3.40		
PULL #3	3.21	3.43		
PULL #4	3.34	3.37		
PULL #5	3.31	3.31		
TOTAL	16.57	16.95		
AVG.	3.314	3.39		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.30		4.29
PULL #2	4.12	4.23		4.23
PULL #3	4.95	4.32		4.25
PULL #4	4.43	4.29		4.28
PULL #5	4.26	4.21		4.24
TOTAL	22.07	21.35		21.29
AVG.	4.414	4.27		4.258

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498733
1 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.196367
1 TO	2	.315317
1 TO	3	.14979
1 TO	4	.273659
1 TO	5	.190877

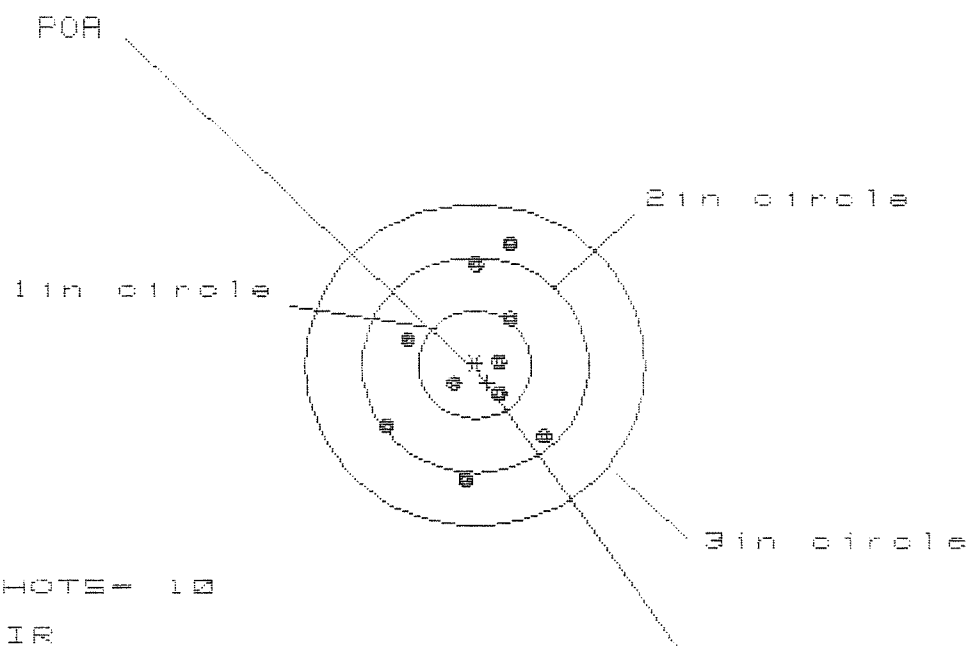
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .027
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0608
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0665255
THE AMR FOR THIS RIFLE IS: .7142

1 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08438733

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.407

VS= 2.127

GS= 2.170

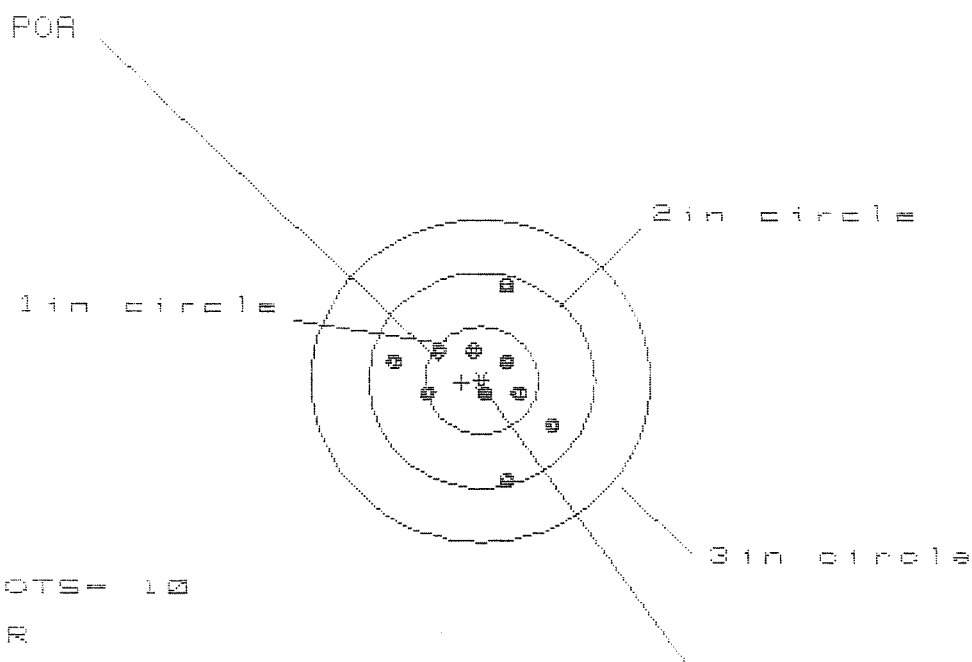
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.603	.637	.627
MINIMUM X	:	-.804	-.770	-.780
MAXIMUM Y	:	1.087	1.055	.940
MINIMUM Y	:	-1.040	-.919	-.637
CENTROID X	:	-.108	-.142	-.132
CENTROID Y	:	.164	.043	.158
POA TO CENTROID in.	:	.196	.149	.206
MIN RADIUS	:	.188	.108	.166
MEAN RADIUS	:	.694	.634	.596
MAX RADIUS	:	1.131	1.055	.948
HORIZONTAL SPREAD	:	1.407	1.407	1.407
VERTICAL SPREAD	:	2.127	1.974	1.577
EXTREME SPREAD	:	2.170	1.977	1.692
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Jun 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.434

VS= 1.839

GS= 1.839

CENTROID #

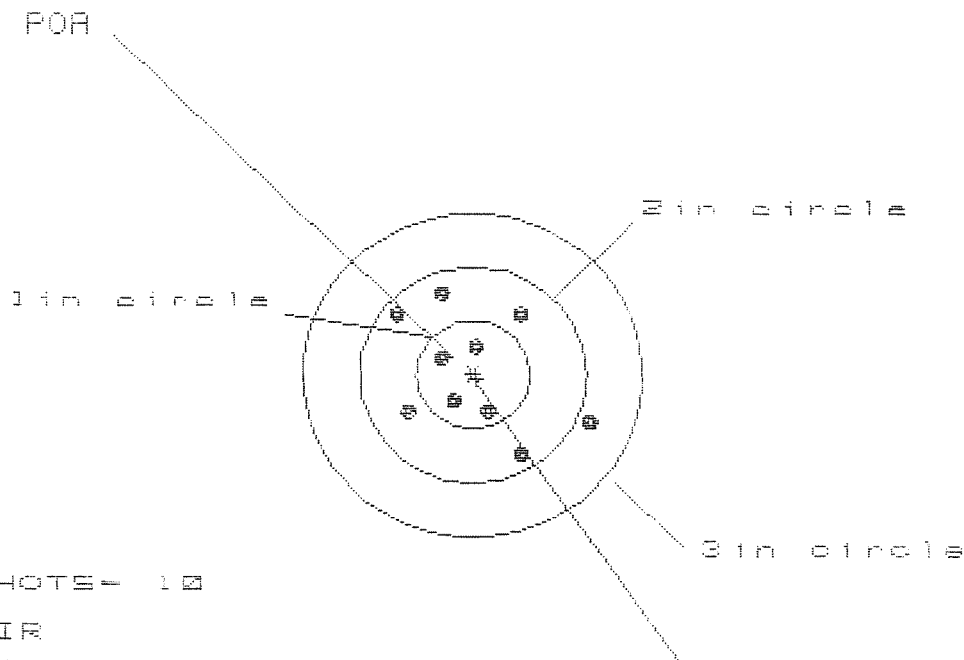
PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.634	.660	.694
MINIMUM X	-.800	-.774	-.740
MAXIMUM Y	.883	.777	.265
MINIMUM Y	-.956	-.558	-.461
CENTROID X	.172	.146	.112
CENTROID Y	.019	.125	.028
POA TO CENTROID in.	.173	.192	.116
MIN RADIUS	.111	.151	.151
MEAN RADIUS	.549	.493	.458
MAX RADIUS	.985	.864	.833
HORIZONTAL SPREAD	1.434	1.434	1.434
VERTICAL SPREAD	1.839	1.335	.726
EXTREME SPREAD	1.839	1.567	1.567
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

1 Jun 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.704

VS= 1.500

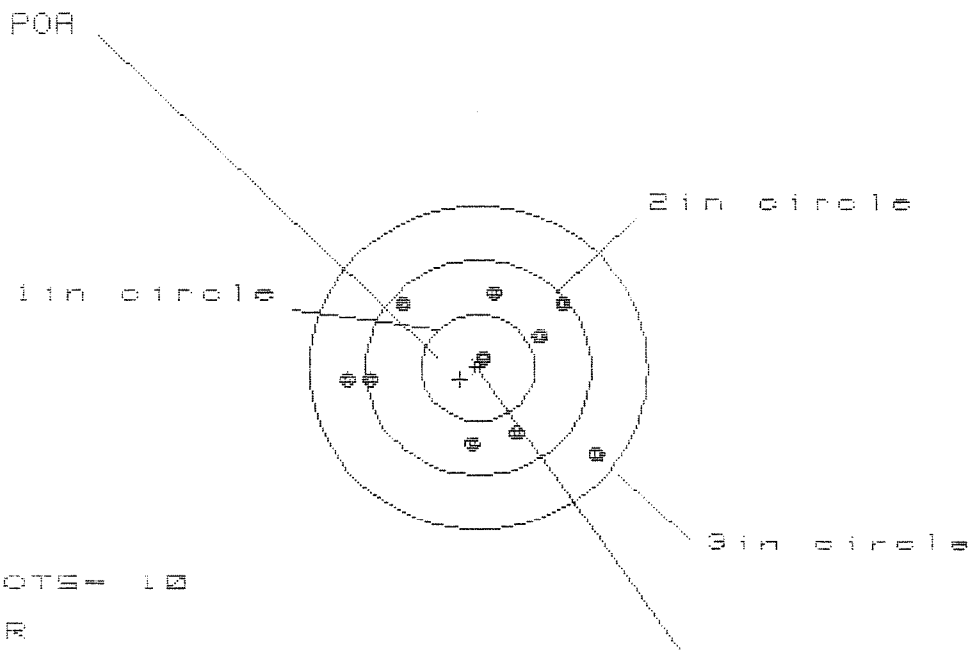
GS= 1.982

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.052	.527	.562
MINIMUM X	:	-.652	-.536	-.470
MAXIMUM Y	:	.727	.673	.570
MINIMUM Y	:	-.773	-.827	-.543
CENTROID X	:	-.027	-.143	-.209
CENTROID Y	:	.038	.091	.194
POA TO CENTROID in.	:	.046	.170	.296
MIN RADIUS	:	.232	.207	.097
MEAN RADIUS	:	.623	.543	.473
MAX RADIUS	:	1.156	.981	.667
HORIZONTAL SPREAD	:	1.704	1.063	1.032
VERTICAL SPREAD	:	1.500	1.500	1.113
EXTREME SPREAD	:	1.982	1.685	1.308
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Jun 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.269

VS= 1.475

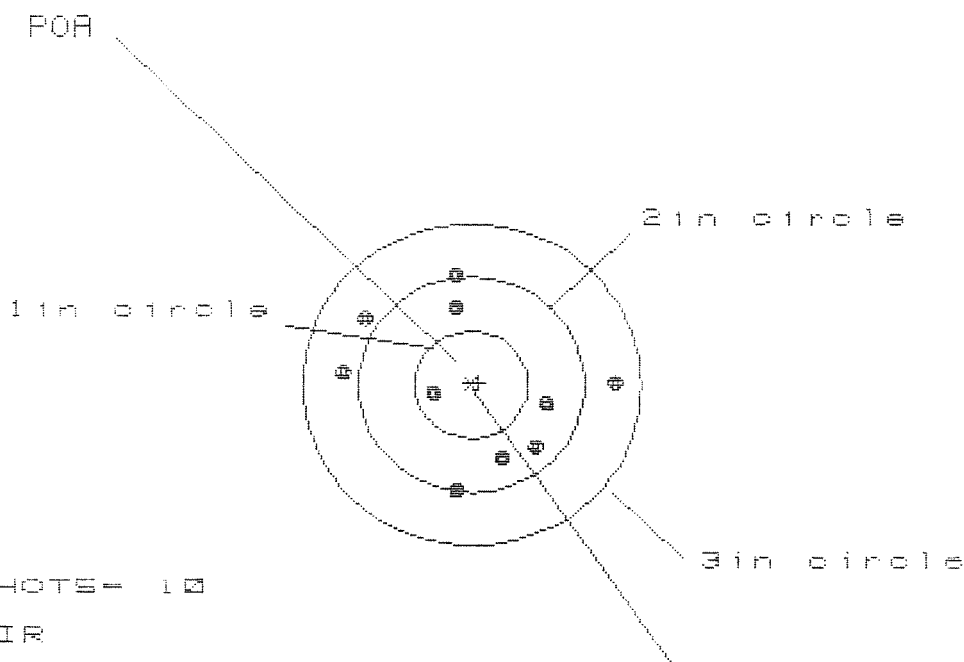
GS= 2.370

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	.869	.736
MINIMUM X	:	-1.180	-1.059	-.963
MAXIMUM Y	:	.699	.613	.591
MINIMUM Y	:	-.776	-.784	-.806
CENTROID X	:	.159	.038	.171
CENTROID Y	:	.104	.190	.212
POA TO CENTROID in.	:	.190	.194	.272
MIN RADIUS	:	.071	.150	.046
MEAN RADIUS	:	.816	.761	.695
MAX RADIUS	:	1.337	1.074	.991
HORIZONTAL SPREAD	:	2.269	1.928	1.699
VERTICAL SPREAD	:	1.475	1.397	1.397
EXTREME SPREAD	:	2.370	2.061	1.863
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

1 JUN 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.322

VS= 1.987

GS= 2.325

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	.825	.721
MINIMUM X	:	-1.097	-.961	-1.065
MAXIMUM Y	:	1.027	1.031	1.106
MINIMUM Y	:	-.960	-.956	-.881
CENTROID X	:	-.061	-.197	-.092
CENTROID Y	:	-.021	-.025	-.100
POA TO CENTROID in.	:	.064	.198	.136
MIN RADIUS	:	.326	.192	.289
MEAN RADIUS	:	.889	.838	.807
MAX RADIUS	:	1.225	1.032	1.117
HORIZONTAL SPREAD	:	2.322	1.786	1.786
VERTICAL SPREAD	:	1.987	1.987	1.987
EXTREME SPREAD	:	2.325	1.989	1.989
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		