C6349146

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

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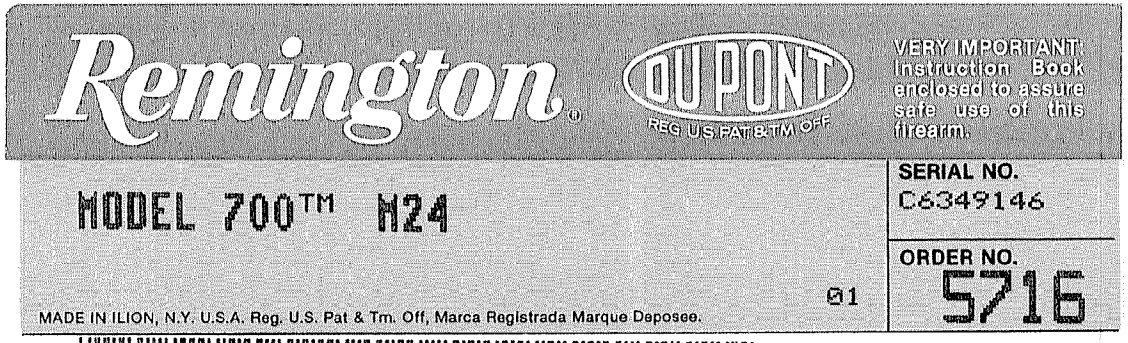

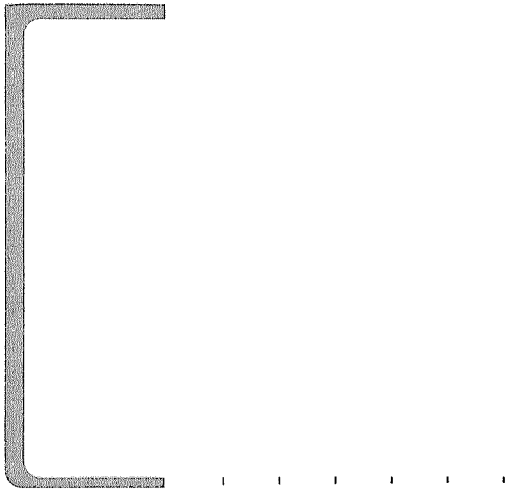

M2400108793

RC 49

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349146

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12-20 89	RW
600	Proof		12-20 89	[illegible]
607	Check Headspace		12-20 89	[illegible]
610	Dis-assemble Gun		12-20 89	RW
612	Magnaflux Barrel Action	1-5-90		KER
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/5/90	JB
617	Drill and Tap Sight Holes		1/8/90	LB
618	Polish Barrel RVB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1/15/90	JK
	Apply Coating (Bolt)		1/15/90	JK
625	Final Assembly A) Clean inside of Bolt Assembly		1/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/16/90	RW
	C) Inspect Ejector Hole for Chamfer		1/16/90	RW
	D) Oil Firing Pin Ass'y		1/16/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		17 Jan 90	DJS

QUALITY AUDIT

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op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1-17-90	JH
	G) Safety Off Force	2	3	3			1-17-90	JH
	H) Trigger Pull Test & Retainability						17 Jan 90	JS
	I) Firing Pin Indent	.021	.020	.0205			1-17-90	JH
	J) Assemble Stock						3/9/90	RW
	K) Assemble Swivel Studs						3/13/90	WB
	L) Attach Front and Rear Sight Assemblies						3/9/90	RW
	M) Iron Sight Alignment						3/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						3/9/90	RW
	O) Attach Scope to Rifle						3/9/90	WB
	P) Detach & Attach Scope 20 Times						3/9/90	WB
640	Gallery Target & Test						3-9-90	JS Temp. Help
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clearity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace						3/13/90	WB
	B) Trigger Pull	2.53	2.50	2.46	2.50	2.36	3/13/90	GS
	C) Function						3/13/90	WB
660	Pack						20 Mar 90	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349146
DATE 17 Jan 90
TESTER JDS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.53	2.53	2.53	MIN. SETTING,
PULL #2	2.34	2.35	2.39	2.50	NO AVG. OF 5
PULL #3	2.32	2.39	2.43	2.46	READINGS ACCEPT-
PULL #4	2.39	2.40	2.38	2.50	ABLE LESS THAN 2#
PULL #5	2.41	2.34	2.36	2.36	
TOTAL	11.91	12.01	12.09		
AVG.	2.382	2.402	2.418		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.21		
PULL #2	3.00	3.09		
PULL #3	2.92	3.04		
PULL #4	2.92	3.02		
PULL #5	2.96	3.04		
TOTAL	14.83	15.38		
AVG.	2.966	3.076		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.05	3.83		3.83
PULL #2	4.22	4.33		3.97
PULL #3	4.26	4.23		3.87
PULL #4	4.29	4.28		3.88
PULL #5	4.23	4.17		3.95
TOTAL	21.05	20.84		19.50
AVG.	4.21	4.168		3.90

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CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349146
9 Mar 1990

CENTROIDAL DISTANCES

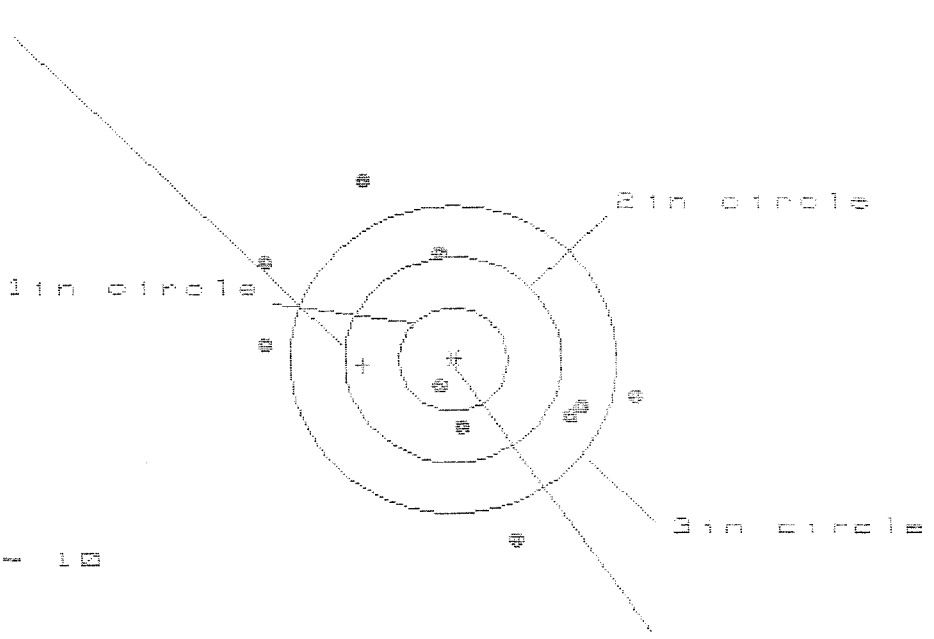
0	TO	1	.83182
1	TO	2	.571864
1	TO	3	.618496
1	TO	4	.490131
1	TO	5	.535212

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .44
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .440085

THE AMR FOR THIS RIFLE IS: .9316

9 Mar 1998 FILE:/PATTERNING/CENTERFIRE_PATT/CG345146

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

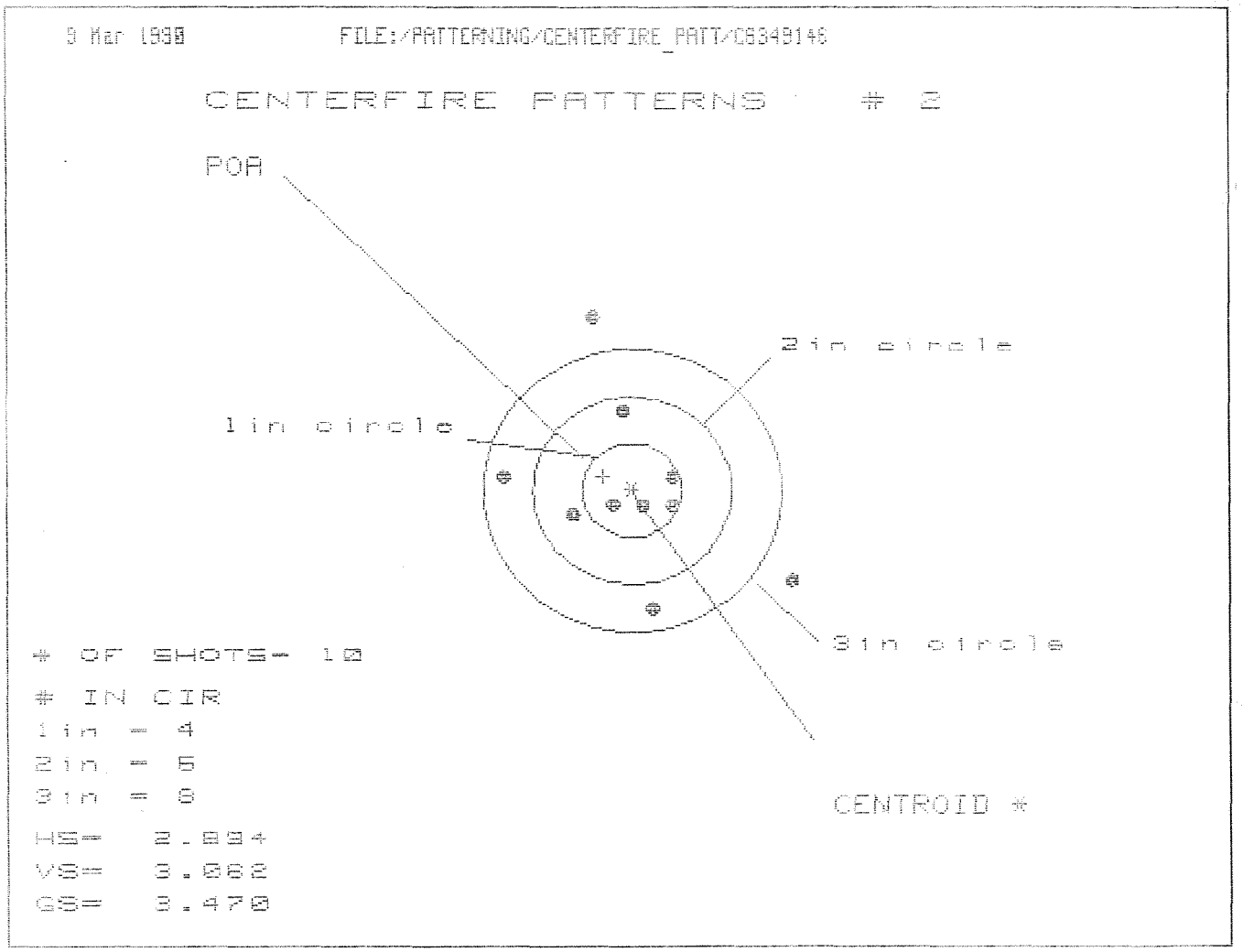
3in = 5

HS= 3.462

VS= 3.418

GS= 3.697

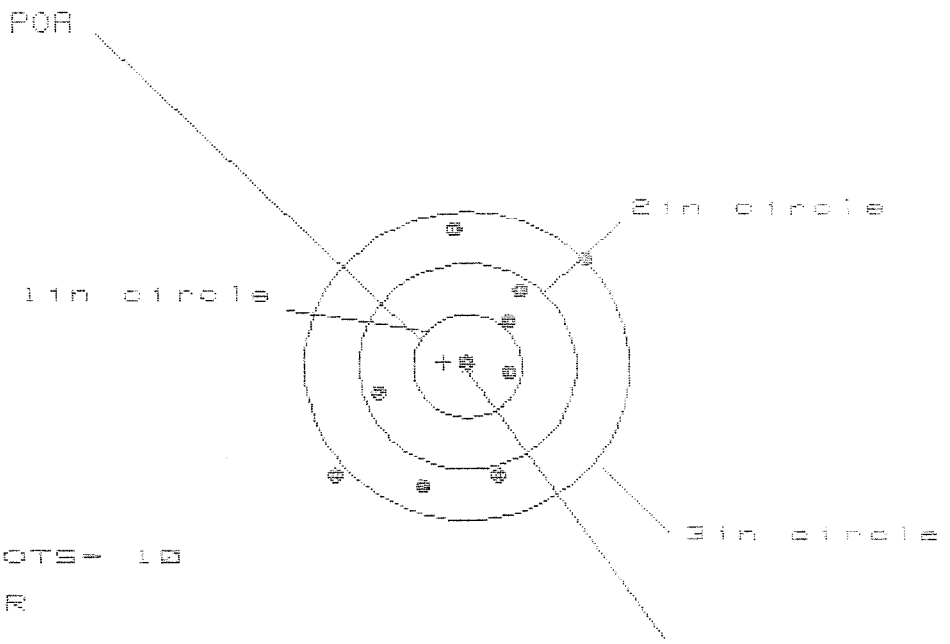
PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.697	1.509	1.383
MINIMUM X	:	-1.765	-1.953	-2.079
MAXIMUM Y	:	1.712	1.818	1.352
MINIMUM Y	:	-1.706	-1.600	-1.373
CENTROID X	:	.830	1.018	1.144
CENTROID Y	:	.055	-.051	-.278
POA TO CENTROID in.	:	.832	1.019	1.178
MIN RADIUS	:	.233	.295	.416
MEAN RADIUS	:	1.348	1.251	1.182
MAX RADIUS	:	1.942	2.081	2.140
HORIZONTAL SPREAD	:	3.462	3.462	3.462
VERTICAL SPREAD	:	3.418	3.418	2.725
EXTREME SPREAD	:	3.697	3.697	3.495
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.600	.555	.523
MINIMUM X	:	-1.293	-1.116	-1.148
MAXIMUM Y	:	1.813	1.703	.995
MINIMUM Y	:	-1.249	-1.359	-1.147
CENTROID X	:	.295	.118	.150
CENTROID Y	:	-.147	-.037	-.249
POA TO CENTROID in.	:	.330	.123	.291
MIN RADIUS	:	.176	.269	.069
MEAN RADIUS	:	.913	.828	.663
MAX RADIUS	:	1.885	1.722	1.188
HORIZONTAL SPREAD	:	2.894	1.671	1.671
VERTICAL SPREAD	:	3.062	3.062	2.142
EXTREME SPREAD	:	3.470	3.120	2.159
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Mar 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C8349146

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

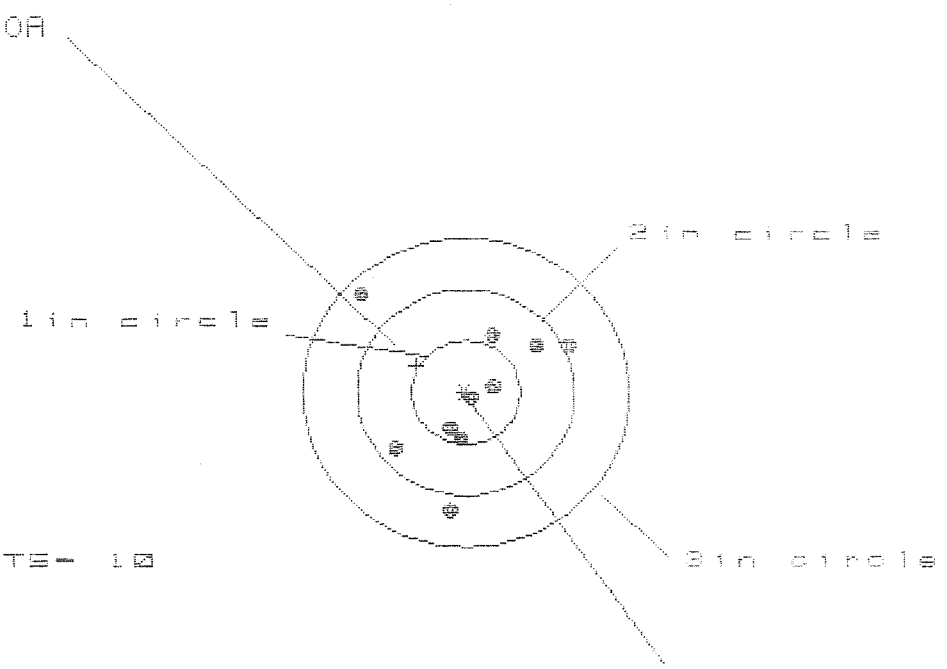
# IN CIR
1in = 2
2in = 5
3in = 8

HS= 2.331
VS= 2.505
GS= 3.106

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.090	.952	.430
MINIMUM X	:	-1.241	-.927	-.807
MAXIMUM Y	:	1.362	1.246	1.358
MINIMUM Y	:	-1.143	-1.259	-1.147
CENTROID X	:	.219	.357	.238
CENTROID Y	:	-.041	.075	-.037
POA TO CENTROID in.	:	.223	.364	.240
MIN. RADIUS	:	.042	.145	.035
MEAN RADIUS	:	.947	.852	.792
MAX RADIUS	:	1.622	1.365	1.370
HORIZONTAL SPREAD	:	2.331	1.879	1.238
VERTICAL SPREAD	:	2.505	2.505	2.505
EXTREME SPREAD	:	3.106	2.611	2.515
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Mar 1998 FILE:/PATTERNING/CENTERFIRE_PATT/CB349146

CENTERFIRE PATTERNS # 4



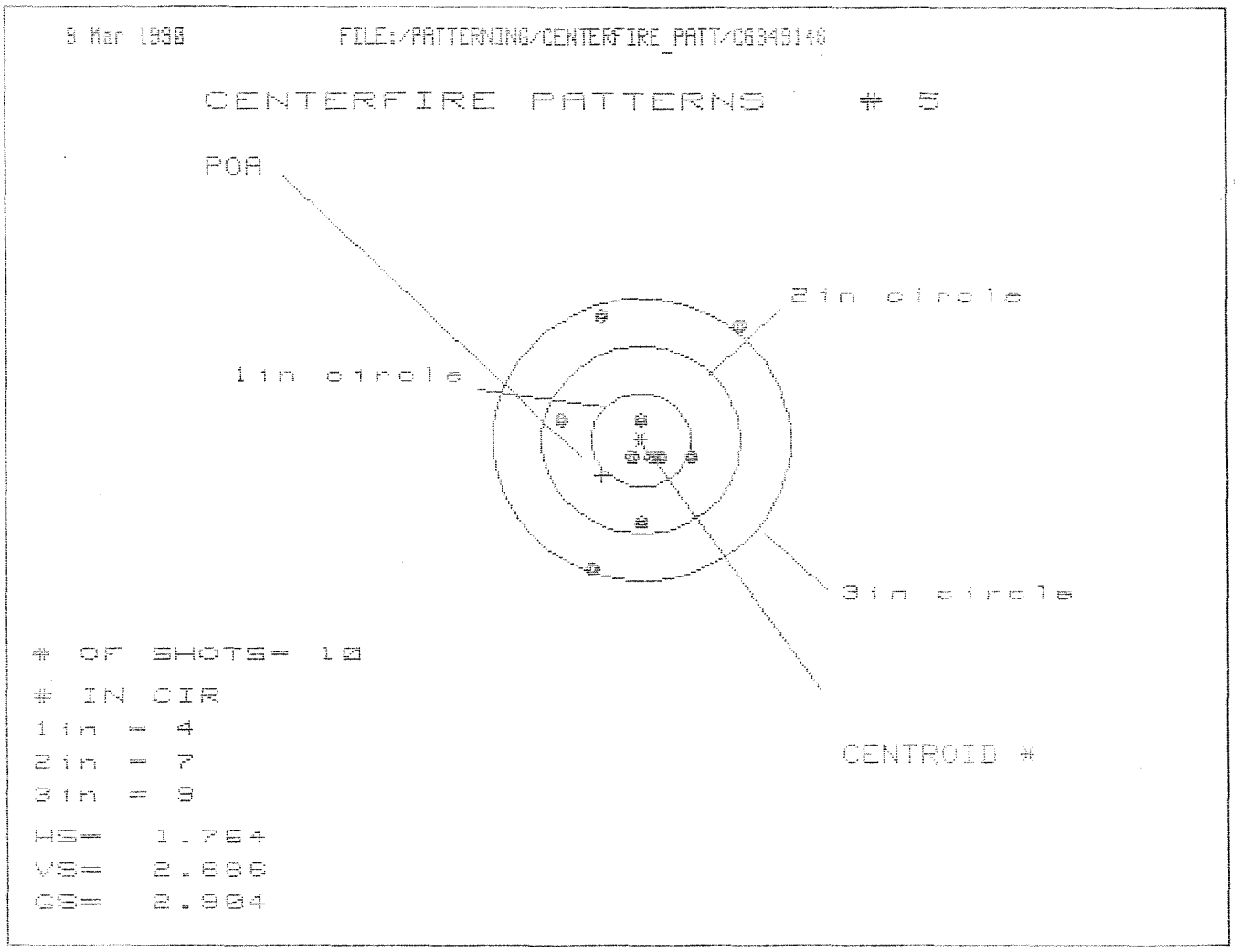
OF SHOTS= 10

IN CIR
1 in = 4
2 in = 7
3 in = 10

HS= 1.898
VS= 2.071
GS= 2.210

PATTERN # : 4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.929	.821	.783
MINIMUM X	:	-.969	-.807	-.845
MAXIMUM Y	:	.954	.696	.570
MINIMUM Y	:	-1.117	-1.011	-.580
CENTROID X	:	.452	.560	.598
CENTROID Y	:	-.257	-.363	-.236
POA TO CENTROID in.	:	.520	.667	.643
MIN RADIUS	:	.103	.057	.136
MEAN RADIUS	:	.700	.604	.546
MAX RADIUS	:	1.360	1.056	.998
HORIZONTAL SPREAD	:	1.898	1.628	1.628
VERTICAL SPREAD	:	2.071	1.707	1.100
EXTREME SPREAD	:	2.210	1.955	1.986
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.970	.608	.561
MINIMUM X	:	-.794	-.686	-.733
MAXIMUM Y	:	1.344	1.474	1.323
MINIMUM Y	:	-1.342	-1.212	-.860
CENTROID X	:	.404	.296	.343
CENTROID Y	:	.379	.249	.400
POA TO CENTROID in.	:	.553	.386	.527
MIN RADIUS	:	.219	.090	.192
MEAN RADIUS	:	.750	.652	.579
MAX RADIUS	:	1.521	1.496	1.357
HORIZONTAL SPREAD	:	1.764	1.294	1.294
VERTICAL SPREAD	:	2.686	2.686	2.183
EXTREME SPREAD	:	2.904	2.689	2.212
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	