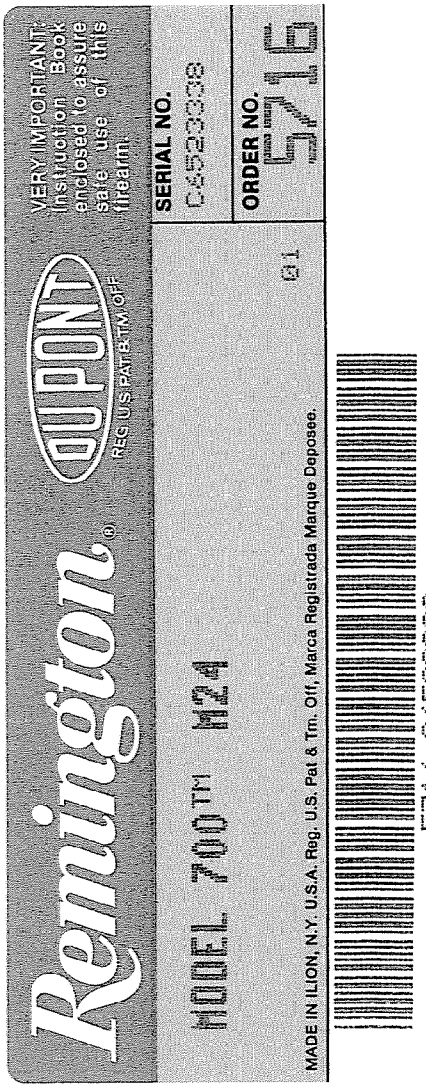
C62338
MODEL 700 TM M24
Model SWS TM
Action
Barrel Length
Capacity
Order No. 5716
*Includes 1 in chamber.
Remington


Remington
DUPONT
REG. U.S. PAT. & T.M. OFF.
VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.
MODEL 700TM M24
SERIAL NO.
C523338
ORDER NO.
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off; Marca Registrada Marque Deposee.
01
5716 C523338
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523338

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 27	90	RW
610	Dis-assemble Gun	9 27	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR
615	Rollmark Caliber		9-26-90	LS
617	Drill and Tap Sight Holes		9/28/90	WB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	TJK
	Apply Coating (Bolt)		10-5-90	TJK
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/11/90	WB

op. #	BARBER - M24 0006335 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/11/90	WB
	G) Safety Off Force	3	3	3			10/11/90	WB
	H) Trigger Pull Test & Retainability						10/11/90	WB
	I) Firing Pin Indent	.0205	.021	.021			10/11/90	WB
	J) Assemble Stock						10/18/90	RW
	K) Assemble Swivel Studs						2NOV90	GS
	L) Attach Front and Rear Sight Assemblies						10/18/90	RW
	M) Iron Sight Alignment						10/18/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/18/90	RW
	O) Attach Scope to Rifle						10/18/90	RW
	P) Detach & Attach Scope 20 Times						10/18/90	RW
640	Gallery Target & Test						10-24-90	DH
	A) Time						10-24-90	DH
	B) Malfunctions						10-24-90	DH
	C) Pierced Primers						10-24-90	DH
	D) Optical Clearity of Scope						10-24-90	DH
645	Inspect for Live Ammo						10-24-90	DH
655	Final Inspection A) Headspace						2NOV90	GS
	B) Trigger Pull	238	229	242	232	223	2NOV90	GS
	C) Function						2NOV90	GS
660	Pack						12/14/90	VF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # ~~C6523400~~ C523338
24 Oct 1990

CENTROIDAL DISTANCES

0	TO	1	.137091
1	TO	2	.156544
1	TO	3	.61264
1	TO	4	.629925
1	TO	5	.561471

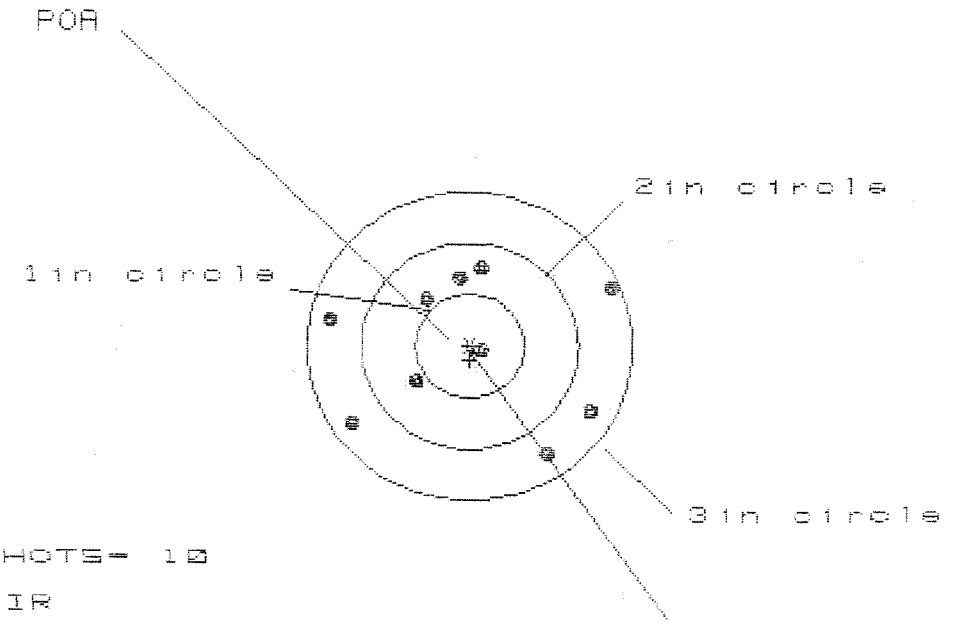
3 4 2 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0358
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194523

THE AMR FOR THIS RIFLE IS: .9742

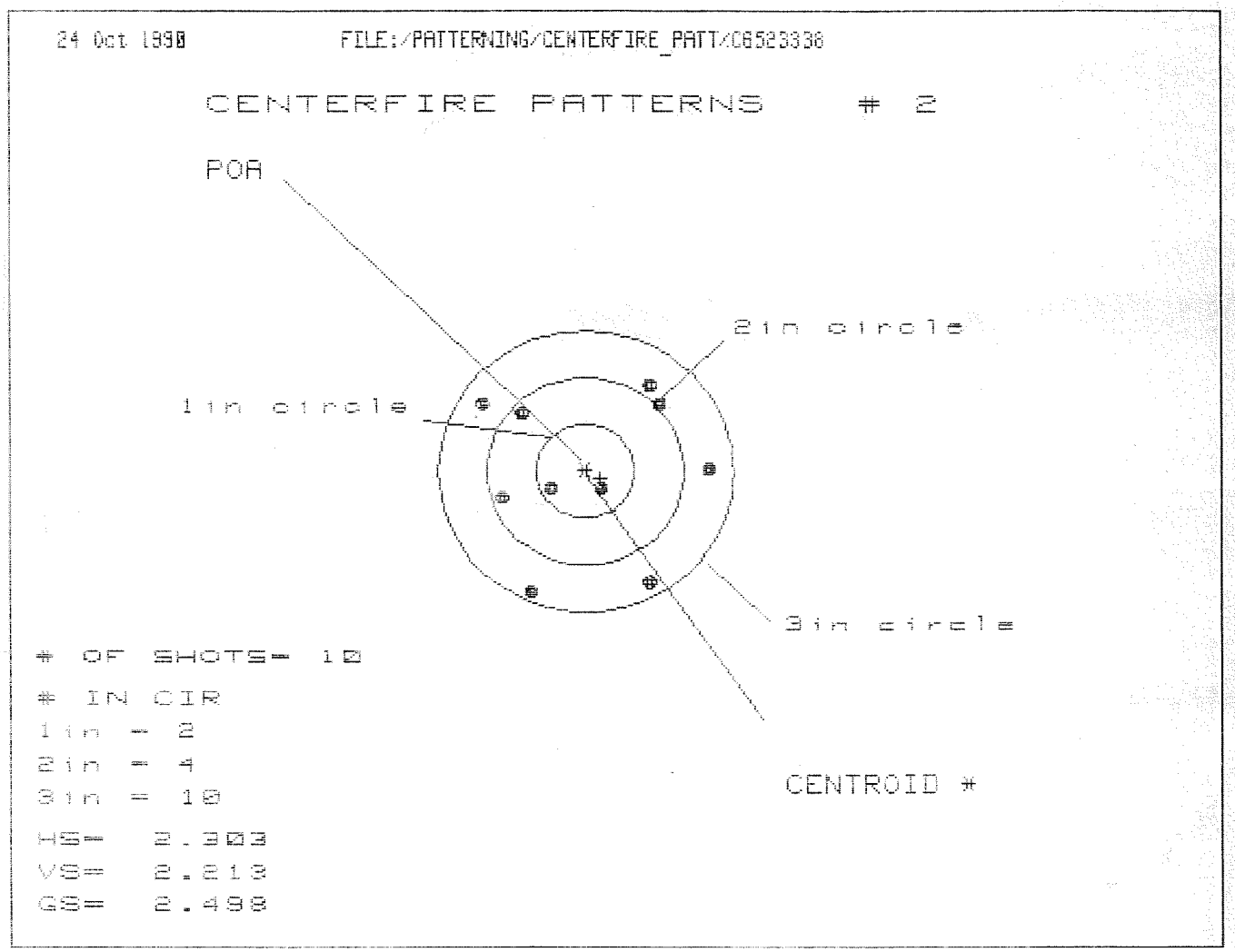
24 Oct 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6523338

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 1
2in = 5
3in = 10
HS= 2.588
VS= 1.813
GS= 2.777

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.337	1.219	1.097
MINIMUM X	:	-1.251	-1.103	-1.225
MAXIMUM Y	:	.780	.839	.754
MINIMUM Y	:	-1.033	-.974	-1.059
CENTROID X	:	-.005	-.153	-.031
CENTROID Y	:	.137	.078	.163
POA TO CENTROID in.	:	.137	.172	.166
MIN RADIUS	:	.059	.215	.089
MEAN RADIUS	:	.924	.866	.804
MAX RADIUS	:	1.440	1.329	1.311
HORIZONTAL SPREAD	:	2.588	2.322	2.322
VERTICAL SPREAD	:	1.813	1.813	1.813
EXTREME SPREAD	:	2.777	2.484	2.484
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.228	1.296
MINIMUM X	:	-1.013	-1.075	-1.007
MAXIMUM Y	:	.956	.816	.654
MINIMUM Y	:	-1.257	-1.303	-.549
CENTROID X	:	-.150	-.088	-.156
CENTROID Y	:	.078	.218	.380
POA TO CENTROID in.	:	.169	.235	.411
MIN RADIUS	:	.274	.378	.553
MEAN RADIUS	:	.984	.944	.880
MAX RADIUS	:	1.375	1.411	1.329
HORIZONTAL SPREAD	:	2.303	2.303	2.303
VERTICAL SPREAD	:	2.213	2.119	1.203
EXTREME SPREAD	:	2.498	2.481	2.410
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

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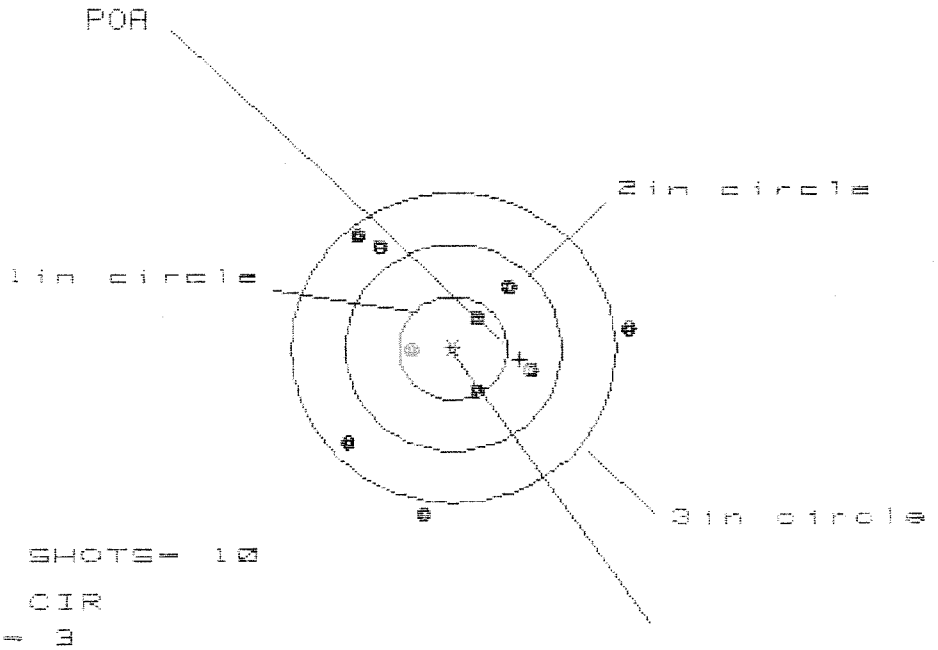
CENTERFIRE PATTERNS # 3

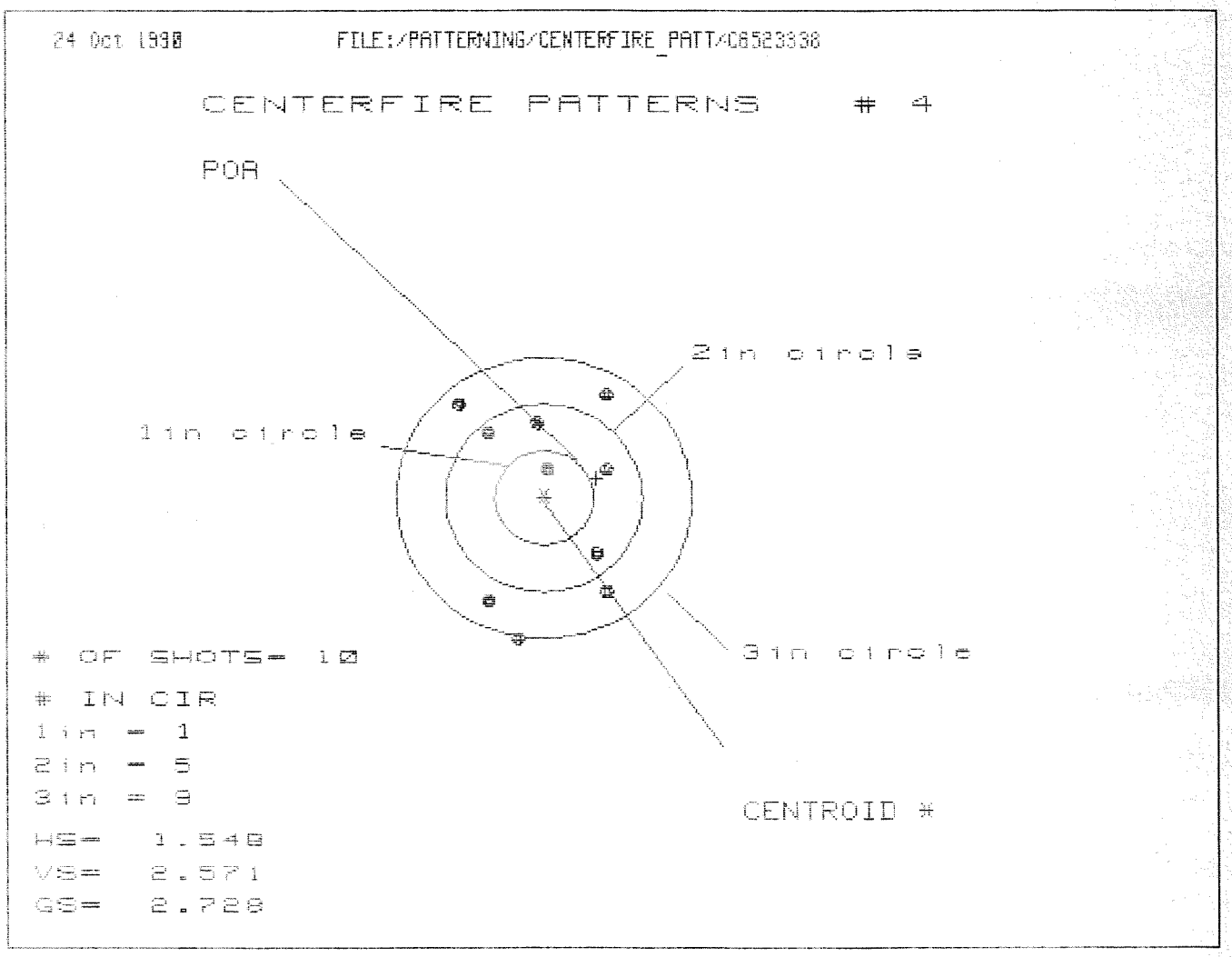


OF SHOTS= 10

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

HS= 2.637
VS= 2.704
GS= 2.841

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.657	.855	.837
MINIMUM X	:	-.980	-.796	-.814
MAXIMUM Y	:	1.133	1.149	.955
MINIMUM Y	:	-1.571	-1.555	-1.088
CENTROID X	:	-.617	-.801	-.783
CENTROID Y	:	.109	.093	.287
POA TO CENTROID in.	:	.626	.806	.834
MIN RADIUS	:	.364	.204	.318
MEAN RADIUS	:	.988	.914	.819
MAX RADIUS	:	1.663	1.561	1.359
HORIZONTAL SPREAD	:	2.637	1.651	1.651
VERTICAL SPREAD	:	2.704	2.704	2.043
EXTREME SPREAD	:	2.841	2.752	2.101
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.642	.608	.491
MINIMUM X	:	-.906	-.940	-.721
MAXIMUM Y	:	1.096	.932	1.036
MINIMUM Y	:	-1.475	-1.304	-1.300
CENTROID X	:	-.534	-.500	-.383
CENTROID Y	:	-.205	-.041	-.145
POA TO CENTROID in.	:	.572	.502	.410
MIN RADIUS	:	.263	.108	.260
MEAN RADIUS	:	1.002	.909	.871
MAX RADIUS	:	1.505	1.424	1.384
HORIZONTAL SPREAD	:	1.548	1.548	1.212
VERTICAL SPREAD	:	2.571	2.236	2.236
EXTREME SPREAD	:	2.728	2.514	2.514
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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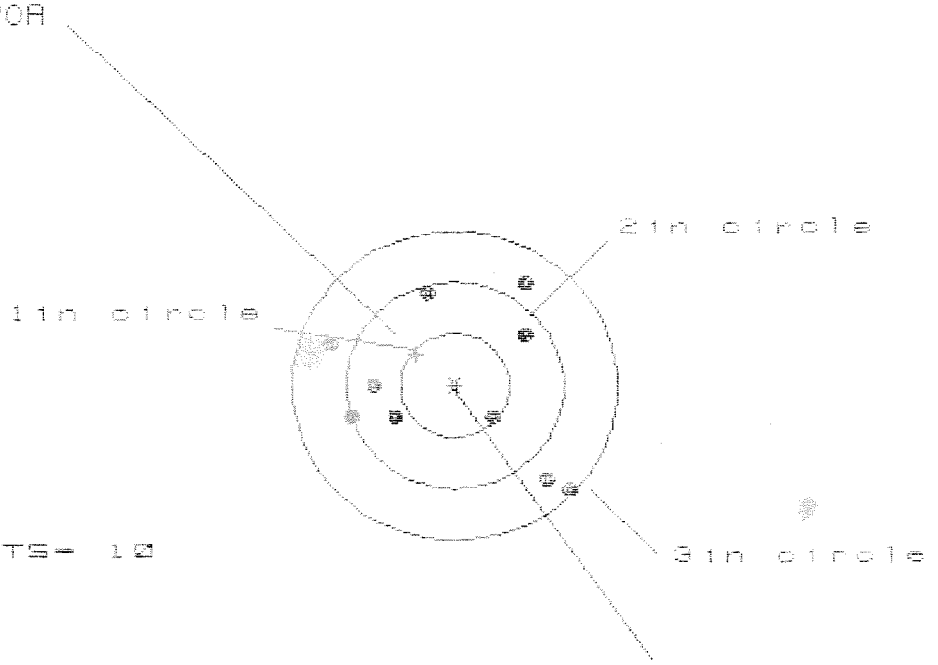
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 1
2in = 6
3in = 10

HS= 2.187
VS= 1.998
GS= 2.635

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	.976	.922
MINIMUM X	:	-1.101	-.980	-.859
MAXIMUM Y	:	.971	.857	.725
MINIMUM Y	:	-1.027	-1.055	-.547
CENTROID X	:	.350	.229	.107
CENTROID Y	:	-.298	-.184	-.052
POA TO CENTROID in.	:	.460	.294	.119
MIN RADIUS	:	.465	.573	.568
MEAN RADIUS	:	.973	.898	.812
MAX RADIUS	:	1.495	1.437	1.173
HORIZONTAL SPREAD	:	2.187	1.956	1.781
VERTICAL SPREAD	:	1.998	1.912	1.272
EXTREME SPREAD	:	2.635	2.396	2.056
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523338
DATE 10/11/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.52	2.50	2.38	MIN. SETTING,
PULL #2	2.32	2.50	2.52	2.39	NO AVG. OF 5
PULL #3	2.52	2.56	2.51	2.42	READINGS ACCEPT-
PULL #4	2.50	2.30	2.45	2.32	ABLE LESS THAN 2#
PULL #5	2.49	2.55	2.46	2.23	
TOTAL	12.32	12.43	12.44		
AVG.	2.46	2.49	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.14		
PULL #2	3.05	3.12		
PULL #3	3.15	3.11		
PULL #4	3.13	3.05		
PULL #5	3.12	3.08		
TOTAL	15.58	15.50		
AVG.	3.11	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.19		4.08
PULL #2	4.10	4.25		4.15
PULL #3	4.13	4.19		4.14
PULL #4	4.03	4.25		4.15
PULL #5	4.09	4.22		4.16
TOTAL	20.43	21.10		20.68
AVG.	4.08	4.22		4.13