

C6649047

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Smead®

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

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

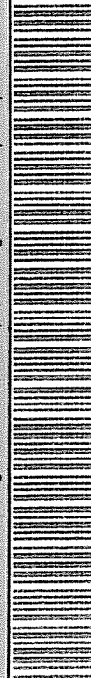
MODEL 700™ M24

SERIAL NO. C6649047

ORDER NO. 5716

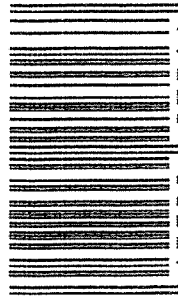
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649047

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649047

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7/22/91	LS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	JK

op. BARBER - M24 0031027	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5		8-15-91	JU
	G) Safety Off Force	3	3	3		8-15-91	JU
	H) Trigger Pull Test & Retainability					8-15-91	JU
	I) Firing Pin Indent	.022	.0215	.0225		8-15-91	JU
	J) Assemble Stock					8-15-91	RW
	K) Assemble Swivel Studs					8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies					8-15-91	RW
	M) Iron Sight Alignment					8-15-91	RW
	N) Detach Front & Rear Sights & place in numbered container					8-15-91	RW
	O) Attach Scope to Rifle					8-15-91	RW
	P) Detach & Attach Scope 20 Times					8-15-91	RW
640	Gallery Target & Test					8-15-91	KT
	A) Time						KT
	B) Malfunctions						KT
	C) Pierced Primers						KT
	D) Optical Clarity of Scope					8-15-91	KT
645	Inspect for Live Ammo					8-15-91	KT
655	Final Inspection						
	A) Headspace					8-17-91	D/H
	B) Trigger Pull	2.29	2.36	2.32	2.40	2.40	8-17-91
	C) Function					8-17-91	D/H
660	Pack					9-19-91	NE

DISTANCE CALCULATIONS

E # 06649047

1991

CENTROIDAL DISTANCES

1 TO	1	.202892
1 TO	2	.409718
1 TO	3	.190683
1 TO	4	.275536
1 TO	5	.289007

POI <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0206

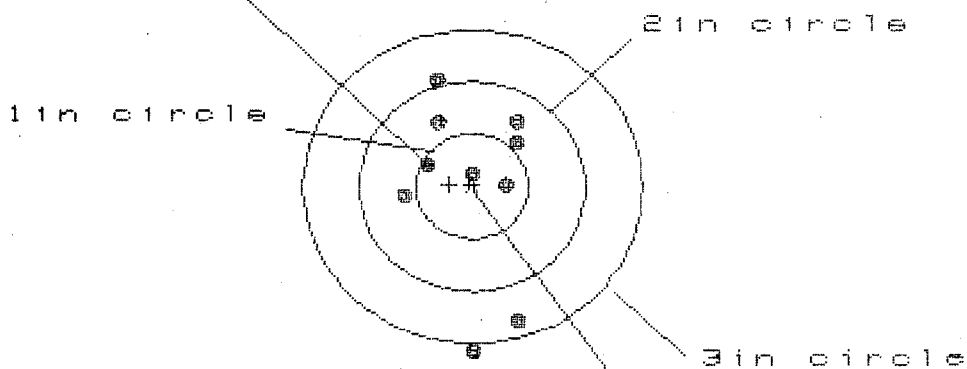
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0528

RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0566763

FOR THIS RIFLE IS: .8152

FILE/PATTERNING/CENTERFIRE_PATT/C6649047

CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.045

VS= 2.630

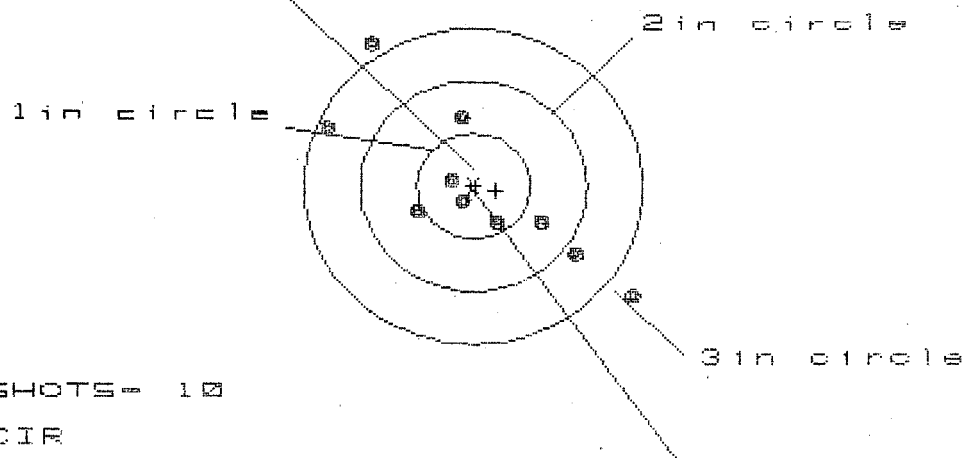
GS= 2.648

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.437	.440	.494
MINIMUM X	-.608	-.605	-.551
MAXIMUM Y	1.009	.829	.649
MINIMUM Y	-1.621	-1.448	-.430
CENTROID X	.282	.199	.145
CENTROID Y	-.019	.161	.341
POA TO CENTROID in.	.203	.255	.371
MIN RADIUS	.097	.084	.269
MEAN RADIUS	.748	.611	.492
MAX RADIUS	1.621	1.510	.699
HORIZONTAL SPREAD	1.045	1.045	1.045
VERTICAL SPREAD	2.630	2.277	1.079
EXTREME SPREAD	2.648	2.384	1.274
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

FILE: PATTERNING/CENTERFIRE_PATT/06645047

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 2.732

VS = 2.387

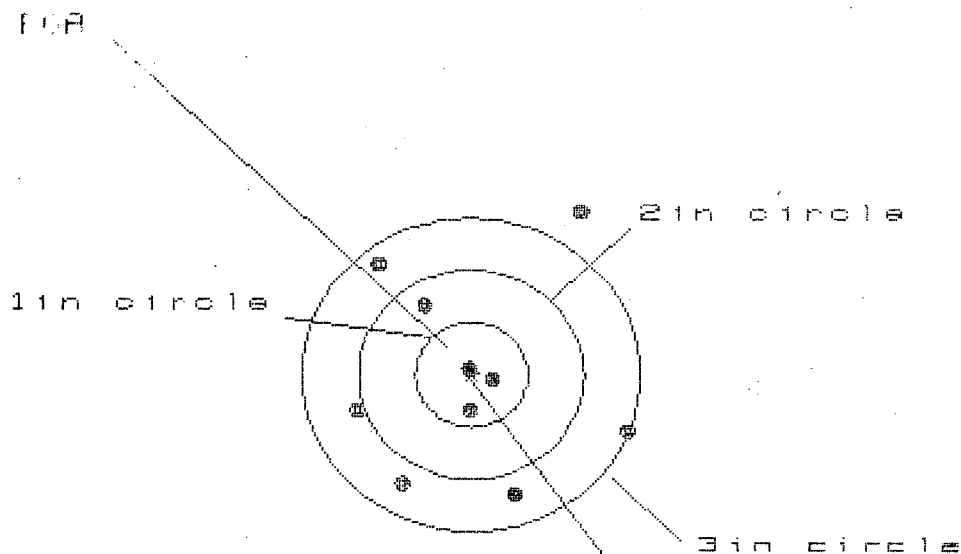
GS = 3.309

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.387	1.074	.980
MINIMUM X	-1.345	-1.191	-1.284
MAXIMUM Y	1.390	1.280	.666
MINIMUM Y	-.997	-.781	-.621
CENTROID X	-.203	-.357	-.264
CENTROID Y	.043	.153	-.007
POA TO CENTROID in.	.208	.389	.264
MIN RADIUS	.152	.071	.088
MEAN RADIUS	.854	.756	.635
MAX RADIUS	1.708	1.483	1.408
HORIZONTAL SPREAD	2.732	2.265	2.265
VERTICAL SPREAD	2.387	2.061	1.287
EXTREME SPREAD	3.309	2.752	2.562
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

FILE: PATTERNING/CENTERFIRE_PATT/C6649047

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 9

HS= 2.417

VS= 2.772

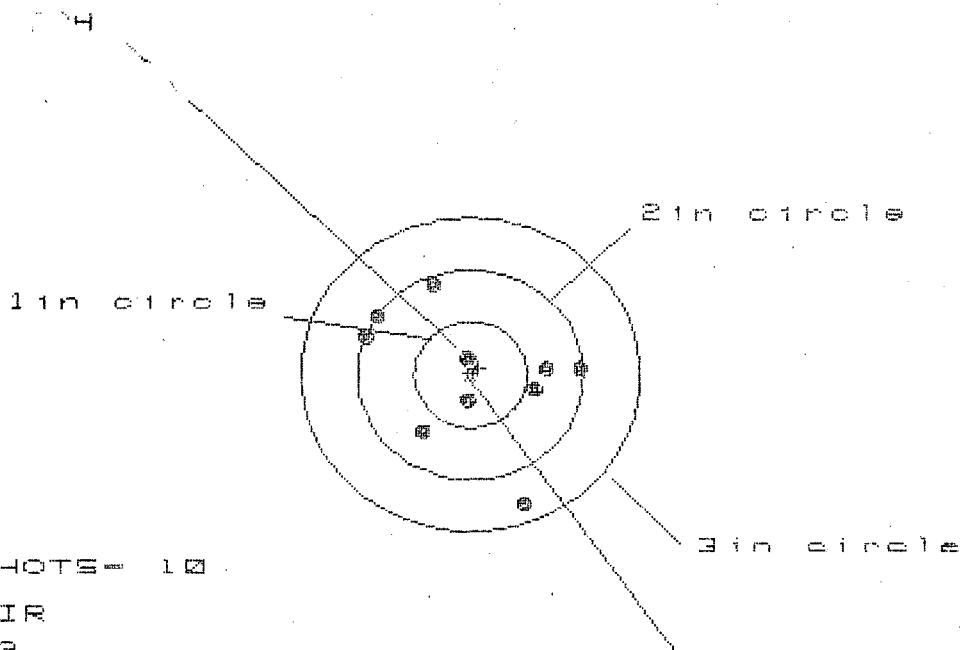
GS= 3.061

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.385	1.489	.652
MINIMUM X	-1.032	-.928	-.742
MAXIMUM Y	1.600	1.225	1.184
MINIMUM Y	-1.172	-.994	-1.035
CENTROID X	.016	-.088	-.274
CENTROID Y	-.061	-.239	-.198
POA TO CENTROID in.	.063	.255	.338
MIN RADIUS	.058	.162	.323
MEAN RADIUS	.942	.837	.765
MAX RADIUS	1.857	1.525	1.280
HORIZONTAL SPREAD	2.417	2.417	1.394
VERTICAL SPREAD	2.772	2.219	2.219
EXTREME SPREAD	3.061	2.662	2.494
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

FILE:/PATTERNING/CENTERFIRE_PATT/06649047

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.926

VS= 2.062

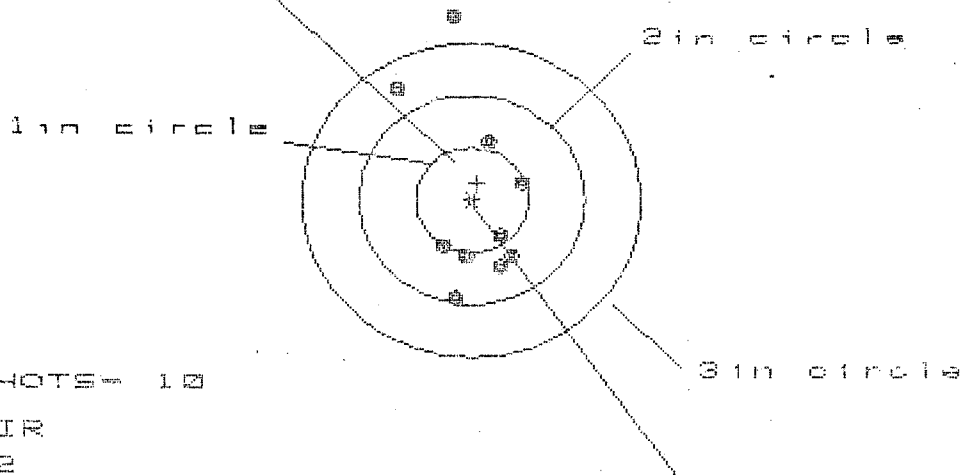
GS= 2.223

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	1.024	.924
MINIMUM X	:	-.950	-.902	-1.001
MAXIMUM Y	:	.843	.707	.766
MINIMUM Y	:	-1.219	-.639	-.580
CENTROID X	:	-.070	-.119	-.019
CENTROID Y	:	-.063	.073	.014
POA TO CENTROID in.	:	.094	.139	.024
MIN RADIUS	:	.185	.064	.123
MEAN RADIUS	:	.755	.689	.648
MAX RADIUS	:	1.294	1.030	1.047
HORIZONTAL SPREAD	:	1.926	1.926	1.926
VERTICAL SPREAD	:	2.062	1.346	1.346
EXTREME SPREAD	:	2.223	1.960	1.960
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

FILE: PATTERNING/CENTERFIRE_PATT/C6649047

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.131

VS= 2.714

GS= 2.714

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.432	.417	.328
MINIMUM X	:	-.699	-.714	-.379
MAXIMUM Y	:	1.742	1.246	.878
MINIMUM Y	:	-.972	-.779	-.623
CENTROID X	:	-.048	-.033	.057
CENTROID Y	:	-.164	-.357	-.513
POA TO CENTROID in.	:	.171	.359	.516
MIN RADIUS	:	.356	.215	.120
MEAN RADIUS	:	.777	.606	.441
MAX RADII	:	1.747	1.436	.878
HORIZONTAL SPREAD	:	1.131	1.131	.706
VERTICAL SPREAD	:	2.714	2.025	1.501
EXTREME SPREAD	:	2.714	2.097	1.525
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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

SERIAL NO. C-6649047DATE 8-15-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.41	2.50	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.44	2.50	2.36	
PULL #3	2.55	2.45	2.53	2.32	
PULL #4	2.58	2.49	2.49	2.40	
PULL #5	2.40	2.52	2.44	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.34		
PULL #2	3.31	3.38		
PULL #3	3.31	3.46		
PULL #4	3.35	3.44		
PULL #5	3.34	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.56		4.60
PULL #2	4.46	4.61		4.54
PULL #3	4.54	4.58		4.45
PULL #4	4.63	4.60		4.32
PULL #5	4.58	4.68		4.41
TOTAL				
AVG.				