

C6498741

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



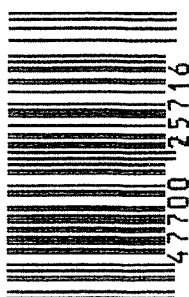

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6498741

ORDER NO.
5716

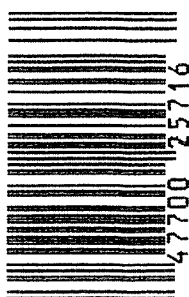
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



UPC



5716 C6498741



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498741

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	90	RW
600	Proof	4 12	90	K
607	Check Headspace	4 12	90	A
610	Dis-assemble Gun	4 12	90	RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		h.s.
617	Drill and Tap Sight Holes		4/23/90	FB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4-28-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-17-90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/4	4 1/2			5/18/90	WB
	G) Safety Off Force	2	2	2			5/18/90	WB
	H) Trigger Pull Test & Retainability						5/17/90	JH
	I) Firing Pin Indent	.023	.023	.023			5/18/90	WB
	J) Assemble Stock						5/18/90	RW
	K) Assemble Swivel Studs						6/14/90	JH
	L) Attach Front and Rear Sight Assemblies						5/18/90	RW
	M) Iron Sight Alignment						5/18/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/18/90	RW
	O) Attach Scope to Rifle						5/18/90	WB
	P) Detach & Attach Scope 20 Times						5/18/90	WB
640	Gallery Target & Test						5-18-90	DH
	A) Time						5-18-90	DH
	B) Malfunctions						5-18-90	DH
	C) Pierced Primers						5-18-90	DH
	D) Optical Clarity of Scope						5-18-90	DH
645	Inspect for Live Ammo						5-18-90	DH
655	Final Inspection							
	A) Headspace						25 May 90	JH
	B) Trigger Pull	280	275	276	281	281	25 May 90	JH
	C) Function						25 May 90	JH
660	Pack						4/20/90	NF



Capital Oxygen Service

PULMONARY CARE SPECIALISTS

OEEO Enricher, Liquid Systems & Concentrators

518/399-2656

MPM4B

New
Stock

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498741
DATE 5/17/90
TESTER JRU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.38	2.30	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.43	2.22	2.75	
PULL #3	2.37	2.46	2.25	2.76	
PULL #4	2.43	2.54	2.35	2.81	
PULL #5	2.42	2.36	2.45	2.81	
TOTAL	11.98	12.17	11.57		
AVG.	2.396	2.434	2.314		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.32		
PULL #2	3.16	3.30		
PULL #3	3.16	3.35		
PULL #4	3.20	3.42		
PULL #5	3.36	3.46		
TOTAL	16.99	16.85		
AVG.	3.198	3.37		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.42		4.37
PULL #2	4.50	4.50		4.11
PULL #3	4.46	4.45		4.41
PULL #4	4.40	4.43		4.45
PULL #5	4.41	4.49		4.50
TOTAL	22.08	22.29		21.84
AVG.	4.416	4.458		4.368

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498741
18 May 1990

CENTROIDAL DISTANCES

0 TO	1	.180887
1 TO	2	.363067
1 TO	3	.297511
1 TO	4	.681966
1 TO	5	.879897

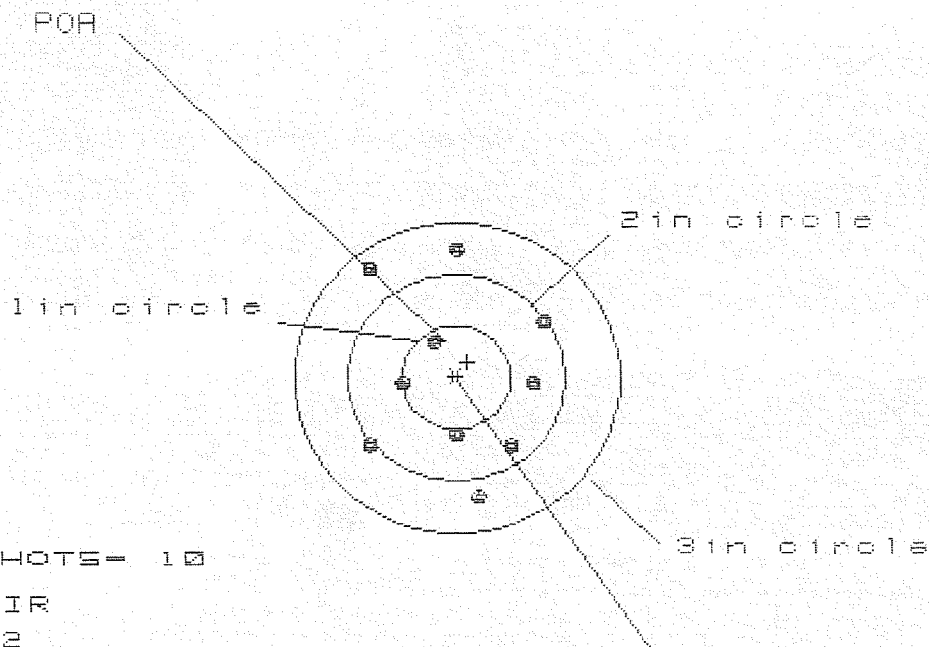
μ^4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .259
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0914
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .274654
THE AMR FOR THIS RIFLE IS: .9002

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498741

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.547

VS= 2.445

GS= 2.449

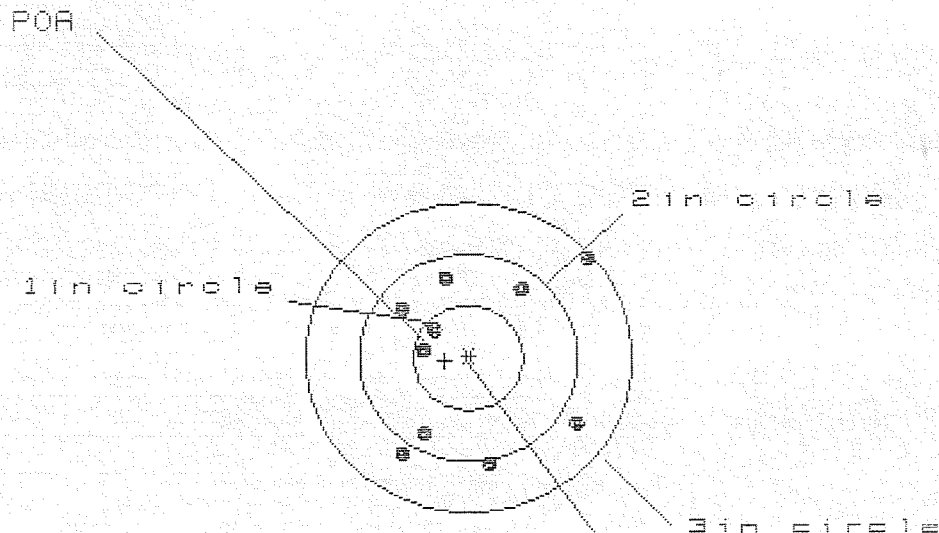
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.815	.728	.722
MINIMUM X	:	-.832	-.919	-.925
MAXIMUM Y	:	1.272	1.388	.795
MINIMUM Y	:	-1.173	-1.057	-.883
CENTROID X	:	-.104	-.017	-.012
CENTROID Y	:	-.148	-.264	-.438
POA TO CENTROID in.	:	.181	.265	.438
MIN RADIUS	:	.397	.455	.289
MEAN RADIUS	:	.876	.817	.723
MAX RADIUS	:	1.301	1.389	1.075
HORIZONTAL SPREAD	:	1.647	1.647	1.647
VERTICAL SPREAD	:	2.445	2.445	1.679
EXTREME SPREAD	:	2.449	2.449	2.040
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498741

CENTERFIRE PATTERNS # 2



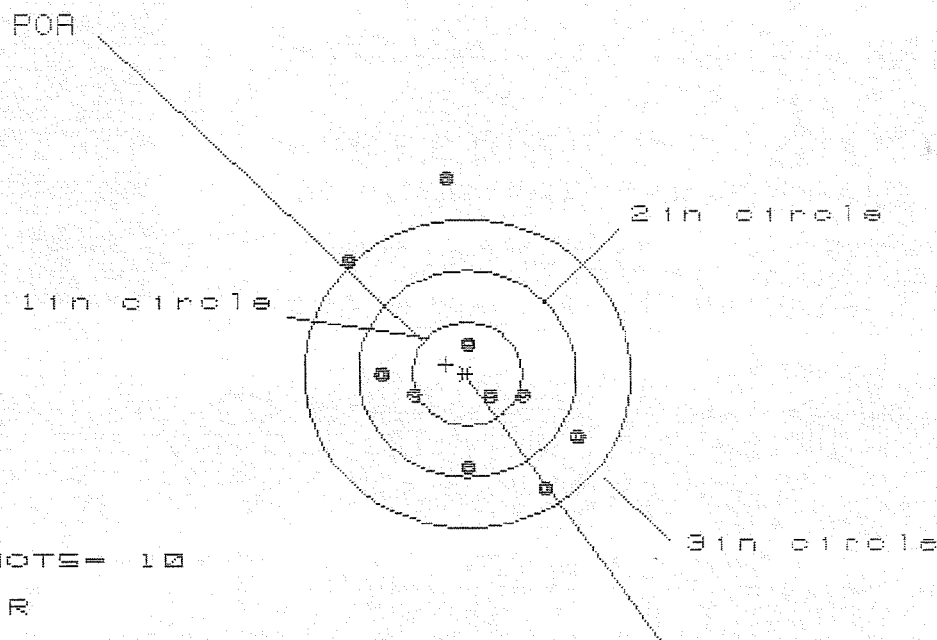
OF SHOTS= 10
 # IN CIR
 1in = 2
 2in = 7
 3in = 10
 HS= 1.712
 VS= 1.989
 GS= 2.596

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	1.125	.736
MINIMUM X	:	-.634	-.514	-.374
MAXIMUM Y	:	1.004	.898	.829
MINIMUM Y	:	-.985	-.873	-.942
CENTROID X	:	.213	.093	-.047
CENTROID Y	:	.029	-.083	-.014
POA TO CENTROID in.	:	.215	.125	.049
MIN RADIUS	:	.425	.300	.224
MEAN RADIUS	:	.902	.820	.727
MAX RADIUS	:	1.473	1.251	1.034
HORIZONTAL SPREAD	:	1.712	1.639	1.110
VERTICAL SPREAD	:	1.989	1.771	1.771
EXTREME SPREAD	:	2.596	2.009	1.965
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

18 May 1938

FILE:/PATTERNING/CENTERFIRE_PATT/06498741

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.121

VS= 3.017

GS= 3.140

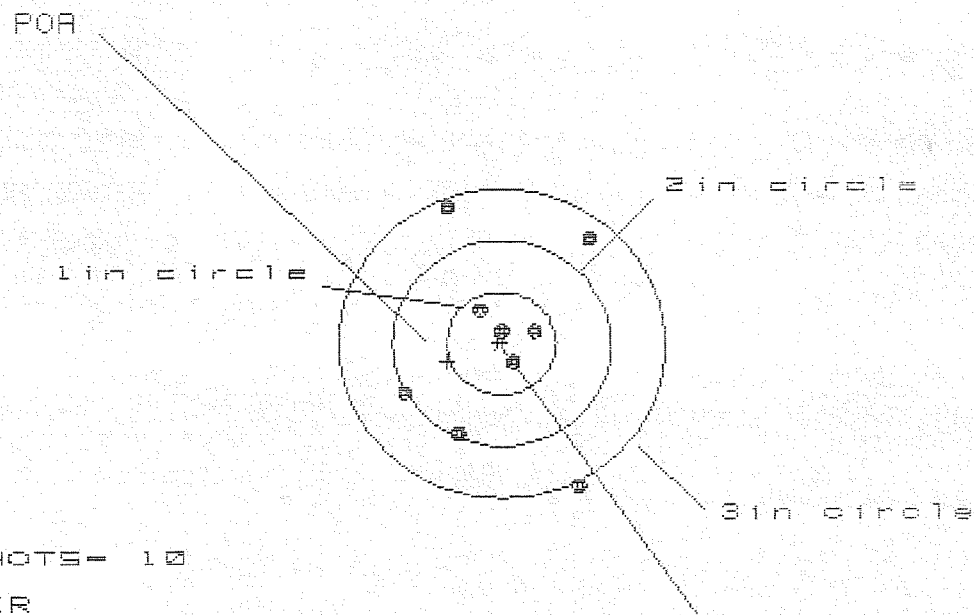
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.009	.991	.850
MINIMUM X	:	-1.112	-1.130	-.942
MAXIMUM Y	:	1.882	1.344	.691
MINIMUM Y	:	-1.135	-.926	-.758
CENTROID X	:	.188	.206	.347
CENTROID Y	:	-.091	-.300	-.468
POA TO CENTROID in.	:	.209	.364	.582
MIN RADIUS	:	.277	.205	.215
MEAN RADIUS	:	.937	.803	.666
MAX RADIUS	:	1.888	1.756	.996
HORIZONTAL SPREAD	:	2.121	2.121	1.792
VERTICAL SPREAD	:	3.017	2.270	1.449
EXTREME SPREAD	:	3.140	2.910	1.869
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B741

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 6

3 in = 9

HS= 1.647

VS= 2.681

GS= 2.957

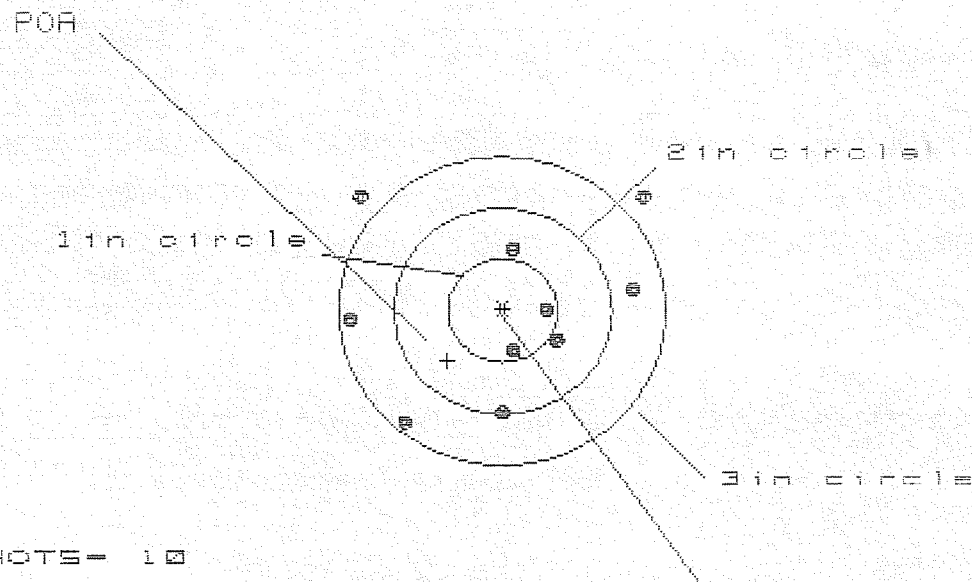
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.777	.860	.808
MINIMUM X	:	-.870	-.787	-.839
MAXIMUM Y	:	1.335	1.186	1.012
MINIMUM Y	:	-1.346	-1.030	-.882
CENTROID X	:	.495	.412	.464
CENTROID Y	:	.178	.327	.179
POA TO CENTROID in.	:	.526	.526	.497
MIN RADIUS	:	.077	.106	.090
MEAN RADIUS	:	.739	.650	.557
MAX RADIUS	:	1.539	1.257	1.295
HORIZONTAL SPREAD	:	1.647	1.647	1.647
VERTICAL SPREAD	:	2.681	2.216	1.894
EXTREME SPREAD	:	2.957	2.254	2.254
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

18 May 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C6498741

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.629

VS= 2.255

GS= 3.109

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.267	1.117	1.217
MINIMUM X	:	-1.362	-1.512	-1.372
MAXIMUM Y	:	1.126	1.245	.857
MINIMUM Y	:	-1.129	-1.010	-.855
CENTROID X	:	.503	.653	.513
CENTROID Y	:	.489	.370	.215
POA TO CENTROID in.	:	.701	.750	.556
MIN RADIUS	:	.397	.270	.143
MEAN RADIUS	:	1.047	.927	.833
MAX RADIUS	:	1.720	1.673	1.380
HORIZONTAL SPREAD	:	2.629	2.629	2.589
VERTICAL SPREAD	:	2.255	2.255	1.712
EXTREME SPREAD	:	3.109	3.109	2.687
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498741
13 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.267925
1 TO	2	.467384
1 TO	3	.442377
1 TO	4	.332277
1 TO	5	.363573

1# <----POA

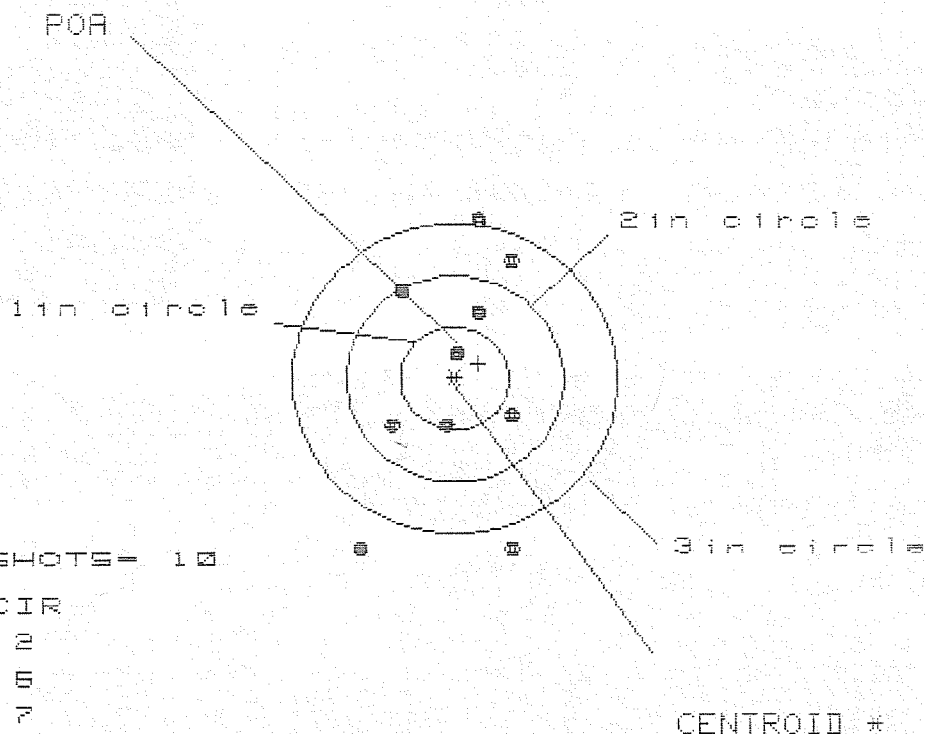
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0458
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0262
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0527644

THE AMR FOR THIS RIFLE IS: .8748

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498741.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 1.463

VS= 3.213

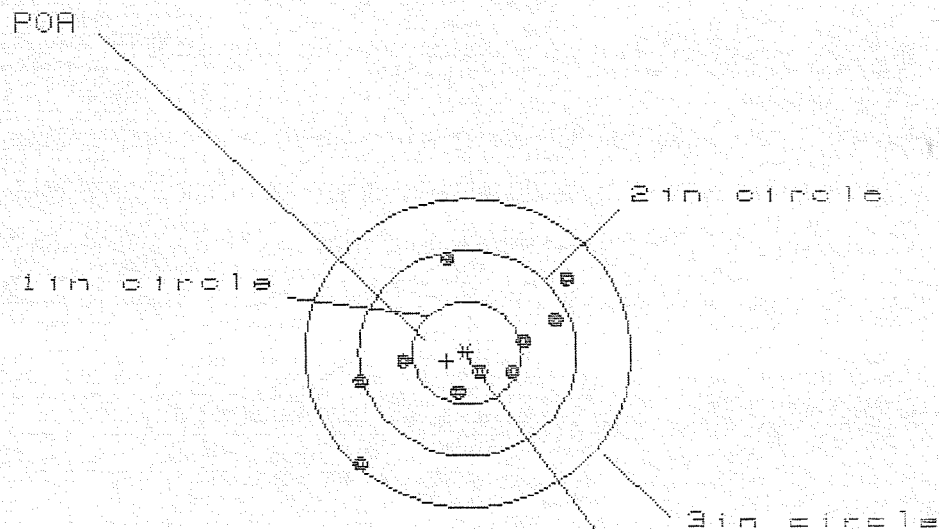
GS= 3.389

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.558	.457	.507
MINIMUM X	-.905	-.724	-.674
MAXIMUM Y	1.582	1.402	1.176
MINIMUM Y	-1.631	-1.811	-.852
CENTROID X	-.222	-.121	-.171
CENTROID Y	-.150	.030	.256
POA TO CENTROID in.	.268	.125	.308
MIN RADIUS	.249	.117	.163
MEAN RADIUS	1.022	.903	.762
MAX RADIUS	1.852	1.854	1.188
HORIZONTAL SPREAD	1.463	1.181	1.181
VERTICAL SPREAD	3.213	3.213	2.028
EXTREME SPREAD	3.389	3.225	2.195
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8436741.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.914

VS= 2.000

GS= 2.579

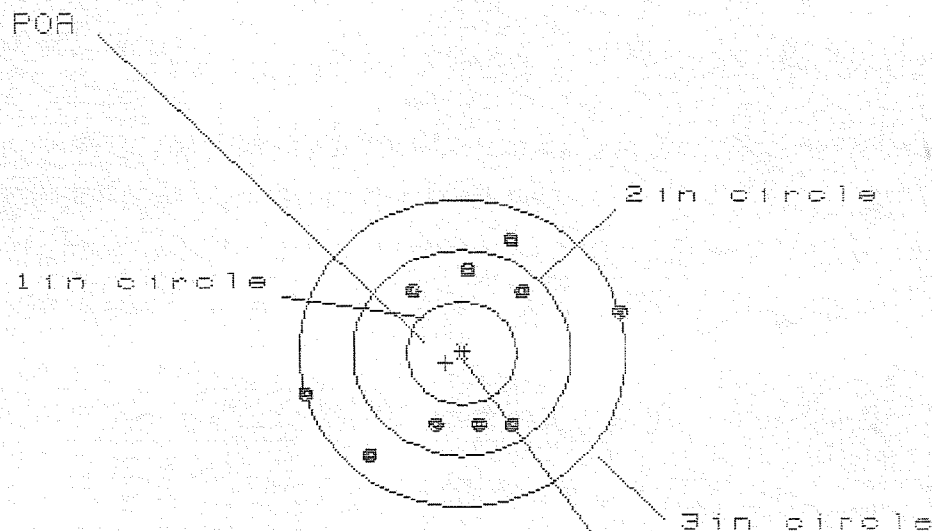
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.894	.780	.828
MINIMUM X	:	-1.020	-1.090	-.992
MAXIMUM Y	:	.959	.843	.915
MINIMUM Y	:	-1.041	-.466	-.394
CENTROID X	:	.186	.300	.202
CENTROID Y	:	.078	.194	.122
POA TO CENTROID in.	:	.202	.357	.236
MIN RADIUS	:	.257	.331	.288
MEAN RADIUS	:	.771	.688	.645
MAX RADIUS	:	1.458	1.146	1.032
HORIZONTAL SPREAD	:	1.914	1.870	1.820
VERTICAL SPREAD	:	2.000	1.309	1.309
EXTREME SPREAD	:	2.579	2.087	1.909
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6496741.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 2.834

VS= 2.180

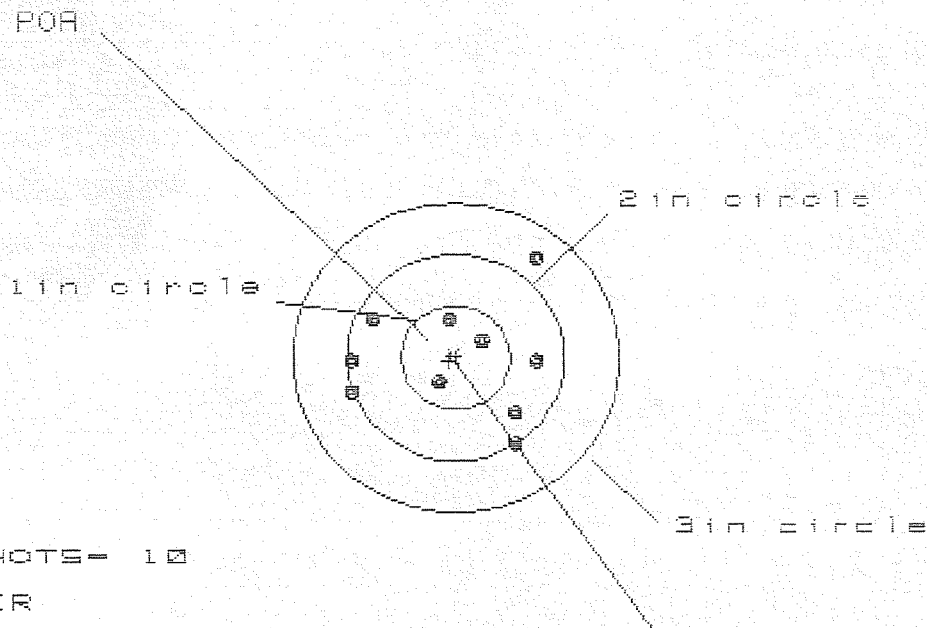
GS= 2.935

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.489	1.251	.518
MINIMUM X	:	-1.425	-1.011	-.854
MAXIMUM Y	:	1.155	1.112	1.154
MINIMUM Y	:	-1.025	-1.068	-1.026
CENTROID X	:	.147	.305	.148
CENTROID Y	:	.094	.137	.095
POA TO CENTROID in.	:	.174	.334	.176
MIN RADIUS	:	.703	.630	.705
MEAN RADIUS	:	1.006	.942	.890
MAX RADIUS	:	1.476	1.471	1.336
HORIZONTAL SPREAD	:	2.834	2.262	1.372
VERTICAL SPREAD	:	2.180	2.180	2.180
EXTREME SPREAD	:	2.935	2.661	2.529
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

13 Jun 1938

FILE:/PATTERNING/CENTERFIRE_PATT/08498741.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.666

VS= 1.835

GS= 2.081

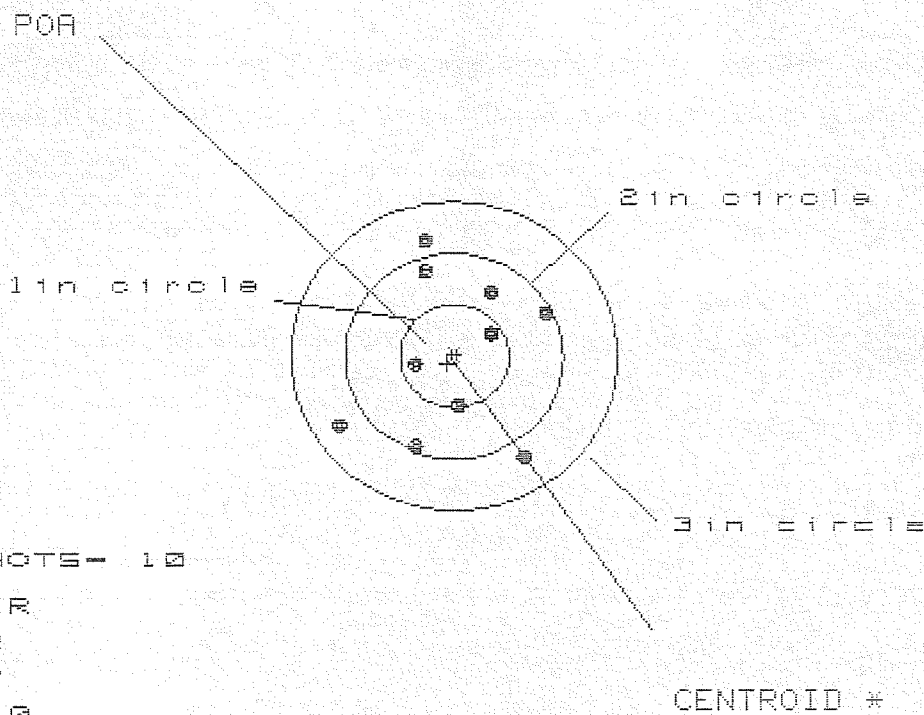
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.722	.800	.882
MINIMUM X	:	-.944	-.866	-.784
MAXIMUM Y	:	.993	.510	.418
MINIMUM Y	:	-.842	-.732	-.471
CENTROID X	:	.056	-.022	-.104
CENTROID Y	:	.032	-.078	.013
POA TO CENTROID in.	:	.064	.081	.105
MIN RADIUS	:	.261	.129	.219
MEAN RADIUS	:	.745	.688	.647
MAX RADIUS	:	1.212	.983	.882
HORIZONTAL SPREAD	:	1.666	1.666	1.666
VERTICAL SPREAD	:	1.835	1.242	.889
EXTREME SPREAD	:	2.081	1.811	1.684
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498741.1

CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.853	.738	.798
MINIMUM X	:	-1.043	-.443	-.383
MAXIMUM Y	:	1.101	1.027	.891
MINIMUM Y	:	-1.008	-1.082	-1.099
CENTROID X	:	.062	.177	.117
CENTROID Y	:	.077	.151	.286
POA TO CENTROID in.	:	.098	.233	.309
MIN RADIUS	:	.340	.300	.322
MEAN RADIUS	:	.830	.771	.706
MAX RADIUS	:	1.240	1.187	1.162
HORIZONTAL SPREAD	:	1.896	1.181	1.181
VERTICAL SPREAD	:	2.109	2.109	1.991
EXTREME SPREAD	:	2.290	2.290	1.991
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	