

C6649065

MODEL 700TM M24

Model **SWS** TM

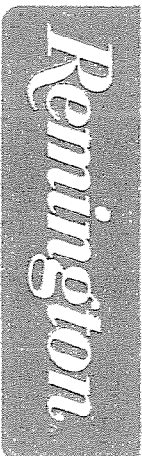
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Simead[®]

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

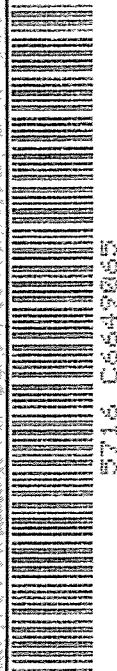
MODEL 700™ H24

SERIAL NO. C6649065

ORDER NO. 5716

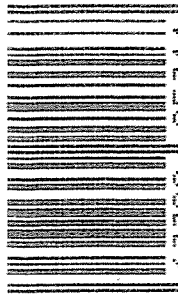
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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



5716 C6649065

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649065

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	ES
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-3-91	AL

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	9/3/91	SH		
	G) Safety Off Force	4	4	4	9/3/91	SH		
	H) Trigger Pull Test & Retainability				9-3-91	SH		
	I) Firing Pin Indent	.0215	.0205	.0205	9-3-91	SH		
	J) Assemble Stock				9/4/91	RW		
	K) Assemble Swivel Studs				9-10-91	AC		
	L) Attach Front and Rear Sight Assemblies				9/4/91	RW		
	M) Iron Sight Alignment				9/4/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				9/4/91	RW		
	O) Attach Scope to Rifle				9/4/91	RW		
	P) Detach & Attach Scope 20 Times				9/4/91	RW		
640	Gallery Target & Test				7-4-91	DH		
	A) Time				7-4-91	DH		
	B) Malfunctions				7-4-91	DH		
	C) Pierced Primers				7-4-91	DH		
	D) Optical Clarity of Scope				7-4-91	DH		
645	Inspect for Live Ammo				7-4-91	DH		
655	Final Inspection							
	A) Headspace				9-10-91	AC		
	B) Trigger Pull	2.43	2.18	2.34	2.25	2.35	9-6-91	SH
	C) Function						9-10-91	AC
660	Pack						9-15-91	AC

SWS TRIGGER PULL TEST

250

100

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-16649065DATE 9-3-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.24	2.31	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.24	2.33	2.18	
PULL #3	2.41	2.28	2.25	2.34	
PULL #4	2.65	2.34	2.35	2.25	
PULL #5	2.58	2.23	2.35	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.69		
PULL #2	3.53	3.66		
PULL #3	3.60	3.59		
PULL #4	3.52	3.66		
PULL #5	3.51	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.25		4.36
PULL #2	4.31	4.46		4.45
PULL #3	4.23	4.41		4.34
PULL #4	4.42	4.34		4.43
PULL #5	4.21	4.41		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649065
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.0669104
1 TO 2	.336013
1 TO 3	.550827
1 TO 4	.341059
1 TO 5	.177505

$\begin{matrix} 4 \\ 2 \end{matrix} \begin{matrix} 5 \\ 3 \end{matrix}$ <----POA

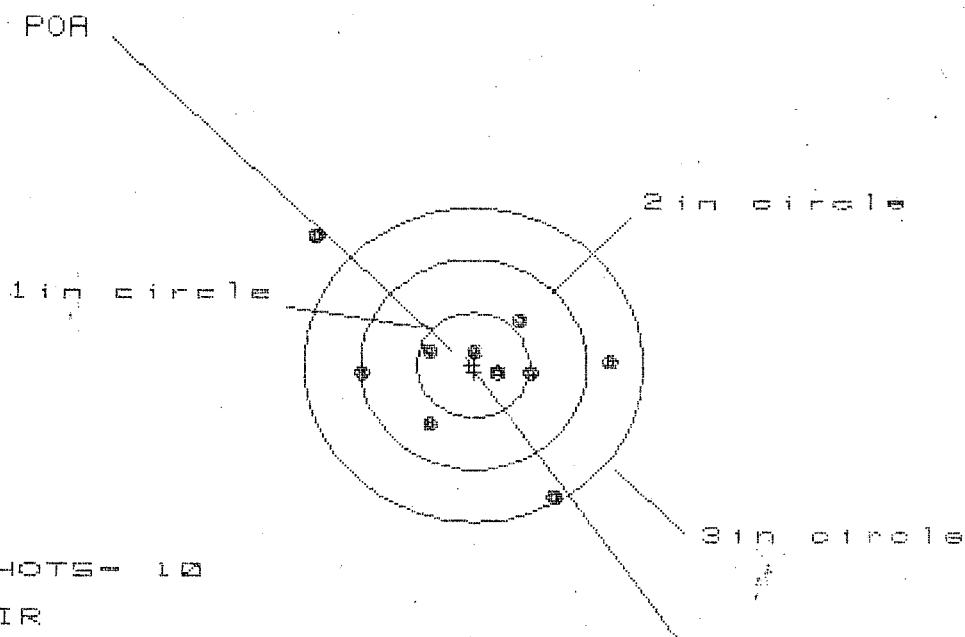
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0186
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0492475

THE AMR FOR THIS RIFLE IS: .8618

+ Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649065

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.620

VS= 2.552

GS= 3.320

CENTROID #

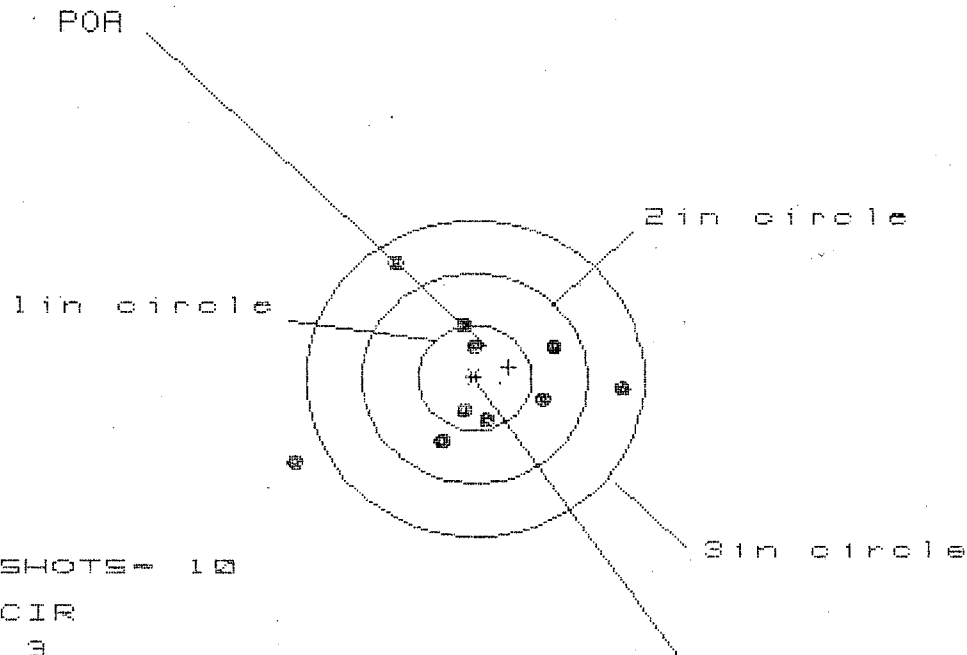
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.246	1.093	1.168
MINIMUM X	:	-1.374	-1.185	-1.110
MAXIMUM Y	:	1.269	.552	.409
MINIMUM Y	:	-1.283	-1.142	-.546
CENTROID X	:	-.011	.142	.067
CENTROID Y	:	.066	-.075	.068
POA TO CENTROID in.	:	.067	.161	.095
MIN RADIUS	:	.139	.124	.137
MEAN RADIUS	:	.821	.700	.596
MAX RADIUS	:	1.871	1.288	1.169
HORIZONTAL SPREAD	:	2.620	2.278	2.278
VERTICAL SPREAD	:	2.552	1.694	.956
EXTREME SPREAD	:	3.320	2.283	2.283
NUMBER IN ONE INCH CIRCLE =	:	3	5	5
NUMBER IN TWO INCH CIRCLE =	:	5	6	6
NUMBER IN THREE INCH CIRCLE =	:	8	9	8

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CENTERFIRE PATTERNS

2



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.937

VS = 1.933

GS = 3.011

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.313	1.132	1.021
MINIMUM X	:	-1.625	-.887	-.551
MAXIMUM Y	:	1.130	1.041	.573
MINIMUM Y	:	-.803	-.649	-.519
CENTROID X	:	-.302	-.122	-.011
CENTROID Y	:	-.102	-.013	-.143
POA TO CENTROID in.	:	.319	.123	.144
MIN RADIUS	:	.285	.317	.332
MEAN RADIUS	:	.802	.677	.577
MAX RADIUS	:	1.812	1.368	1.026
HORIZONTAL SPREAD	:	2.937	2.019	1.572
VERTICAL SPREAD	:	1.933	1.690	1.092
EXTREME SPREAD	:	3.011	2.385	1.627
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 3.523

VS= 2.580

GS= 3.523

PATTERN #

3

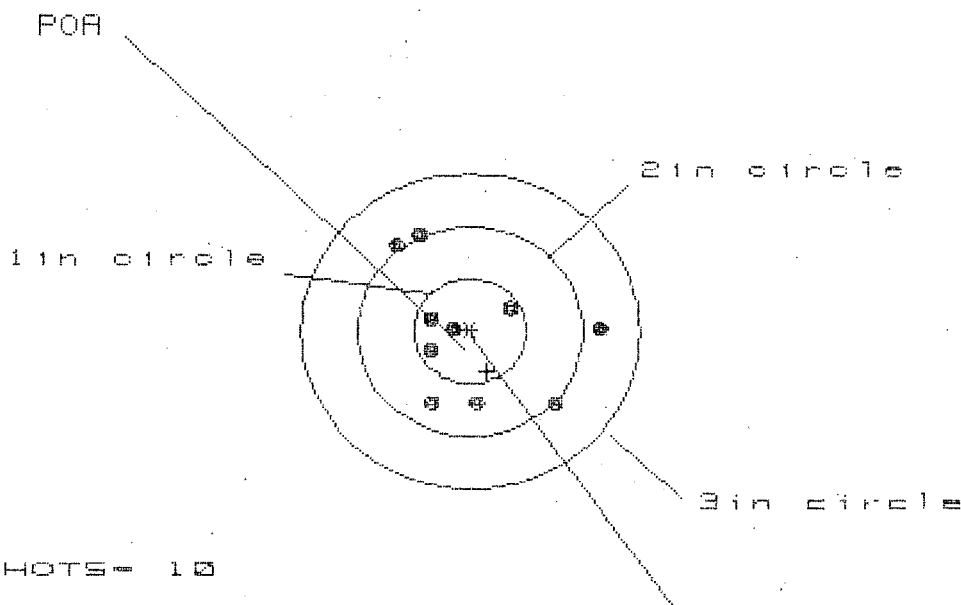
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.143	1.350	1.208
MINIMUM X	-1.380	-1.142	-.614
MAXIMUM Y	1.304	1.275	1.233
MINIMUM Y	-1.276	-1.305	-1.346
CENTROID X	.420	.182	.325
CENTROID Y	-.277	-.248	-.207
POA TO CENTROID in.	.503	.307	.385
MIN RADIUS	.274	.163	.157
MEAN RADIUS	1.195	1.030	1.019
MAX RADIUS	2.159	1.577	1.480
HORIZONTAL SPREAD	3.523	2.492	1.821
VERTICAL SPREAD	2.580	2.580	2.580
EXTREME SPREAD	3.523	2.743	2.743
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 1.857

VS= 1.617

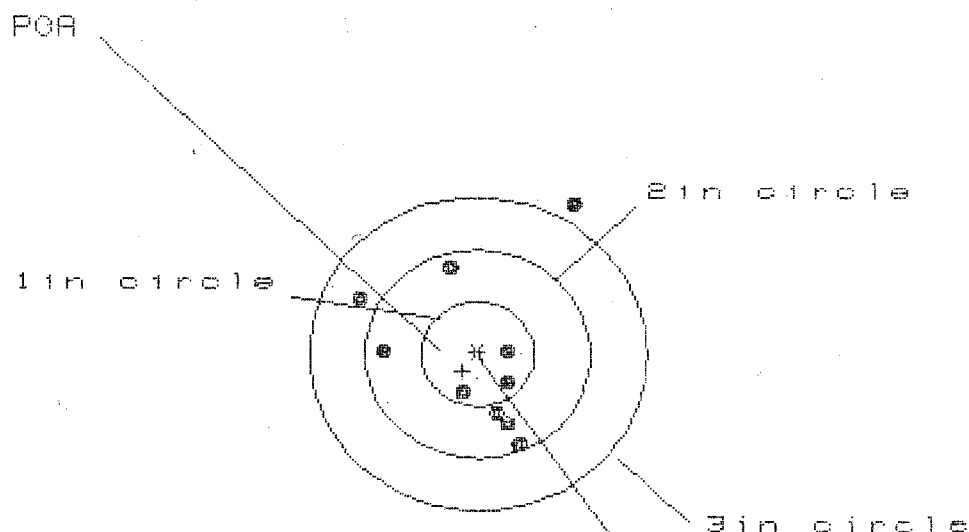
GS= 2.120

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.174	.923	.854
MINIMUM X	-.683	-.552	-.337
MAXIMUM Y	.931	.933	1.041
MINIMUM Y	-.686	-.684	-.576
CENTROID X	-.151	-.282	-.213
CENTROID Y	.377	.375	.267
POA TO CENTROID in.	.406	.469	.341
MIN RADIUS	.152	.027	.128
MEAN RADIUS	.714	.631	.589
MAX RADIUS	1.174	1.132	1.094
HORIZONTAL SPREAD	1.857	1.475	1.191
VERTICAL SPREAD	1.617	1.617	1.617
EXTREME SPREAD	2.120	2.120	1.986
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.854

VS= 2.321

GS= 2.365

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.843	.483	.368
MINIMUM X	:	-1.011	-.917	-.819
MAXIMUM Y	:	1.454	.952	1.035
MINIMUM Y	:	-.867	-.705	-.622
CENTROID X	:	.137	.043	.158
CENTROID Y	:	.164	.002	-.081
POA TO CENTROID in.	:	.214	.043	.177
MIN RADIUS	:	.266	.245	.201
MEAN RADIUS	:	.777	.644	.537
MAX RADIUS	:	1.681	1.133	1.077
HORIZONTAL SPREAD	:	1.854	1.400	1.187
VERTICAL SPREAD	:	2.321	1.657	1.657
EXTREME SPREAD	:	2.365	1.959	1.787
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	