

C6649248

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

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

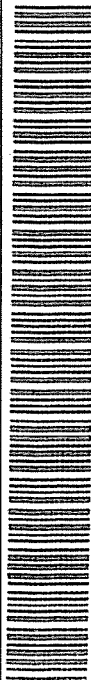
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

MODEL 700™ H24

SERIAL NO. C6649248

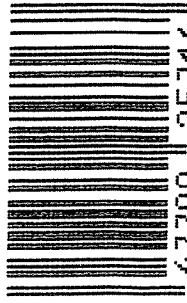
ORDER NO. 5716

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



5716 C6649248

LPC



0 47700 25716 7

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649248

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	LL
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		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-6-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	6	6			9-6-91	DH
	G) Safety Off Force	3	3	2 3/4			9-6-91	DH
	H) Trigger Pull Test & Retainability						9-6-91	DH
	I) Firing Pin Indent	.020	.020	.020			9-6-91	DH
	J) Assemble Stock						9/11/91	RW
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/11/91	RW
	M) Iron Sight Alignment						9/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/91	RW
	O) Attach Scope to Rifle						9/11/91	RW
	P) Detach & Attach Scope 20 Times						9/11/91	RW
640	Gallery Target & Test						9-11-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-11-91	AF
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	2.20	2.29	2.34	2.46	2.53	9-12-91	DL
	C) Function						9-12-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649248
DATE 9-6-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.29	2.31	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.20	2.25	2.29	
PULL #3	2.47	2.13	2.30	2.34	
PULL #4	2.22	2.23	2.36	2.46	
PULL #5	2.33	2.17	2.32	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.22		
PULL #2	3.10	3.12		
PULL #3	3.22	3.16		
PULL #4	3.18	3.20		
PULL #5	3.37	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.37		4.14
PULL #2	4.43	4.34		4.18
PULL #3	4.36	4.10		4.07
PULL #4	4.40	4.44		4.13
PULL #5	4.10	4.48		4.14
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649248
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0404475
1 TO	2	.210509
1 TO	3	.156
1 TO	4	.0565685
1 TO	5	.090802

44 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0728
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0346
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .080604
THE AMP FOR THIS RIFLE IS: .9612

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CR

1 1 1

2 1 0

3 0 0

10 0 0

100 0 0

1000 0 0

PATTERN

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.560

1.472

1.310

MINIMUM X

-1.210

-1.290

-.574

MAXIMUM Y

1.920

1.677

1.848

MINIMUM Y

-2.179

-1.620

-1.459

CENTROID X

-.040

.040

.210

CENTROID Y

-.006

.237

.066

CM TO CENTROID (in.)

.041

.241

.220

CM RANGE

.160

.261

.384

CM RADIUS

1.363

1.271

1.176

CM RADIUS

2.219

1.899

1.899

HORIZONTAL SPREAD

2.770

2.770

1.884

VERTICAL SPREAD

4.099

3.307

3.307

EXTREME SPREAD

4.143

3.775

3.367

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

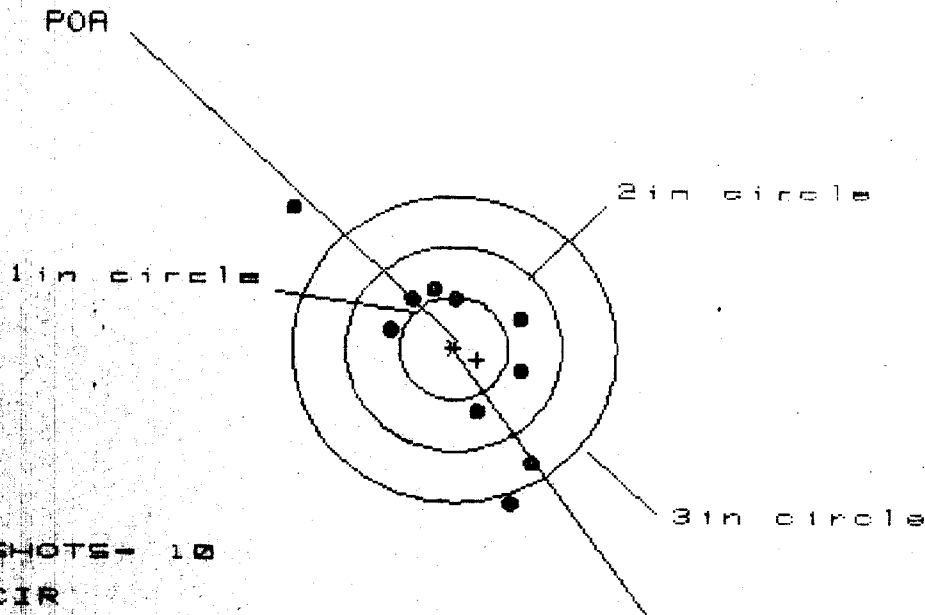
NUMBER IN THREE INCH CIRCLE =

5

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248

CENTERFIRE PATTERNS # 12



OF SLOTS- 10
IN CIR
1 1 0
2 1 4
3 1 0
1 1 1 0
2 1 0 0
3 1 0 0
1 1 1 0
2 1 0 0
3 1 0 0

CENTROID *

PATTERN #				
SLOTS (BEST DF)	1	10	9	8
MEAN X	1	.718	.549	.589
MEAN Y	1	-1.522	-.795	-.695
STDEV X	1	1.417	.712	.537
STDEV Y	1	-1.556	-1.399	-1.117
CENTROID X	1	-.215	-.046	-.086
CENTROID Y	1	.111	-.046	.129
MEAN IN CENTROID IN	1	.242	.065	.155
MEAN X IN	1	.533	.470	.522
MEAN Y IN	1	.942	.814	.706
MEAN X IN	1	2.079	1.495	1.263
MEAN Y IN	1	2.240	1.284	1.284
MEAN X IN	1	2.973	2.111	1.654
MEAN Y IN	1	3.589	2.230	1.943
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 1 1 3

2 1 1 6

3 1 1 9

10 1 1 10

VS# 1.490

GS# 0.957

PATTERN #

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.776

1.154

1.033

MINIMUM X

-1.157

-.970

-.756

MAXIMUM Y

.693

.671

.679

MINIMUM Y

-.797

-.819

-.810

MAXIMUM X

.020

-.177

-.056

MINIMUM X

.138

.150

.151

MAXIMUM Y IN

.140

.239

.161

MINIMUM Y

.647

.163

.046

MAXIMUM X

.788

.652

.610

MINIMUM X

1.787

1.253

1.138

HORIZONTAL SPREAD

2.943

2.124

1.789

VERTICAL SPREAD

1.490

1.490

1.490

EXTREME SPREAD

2.957

2.196

1.813

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

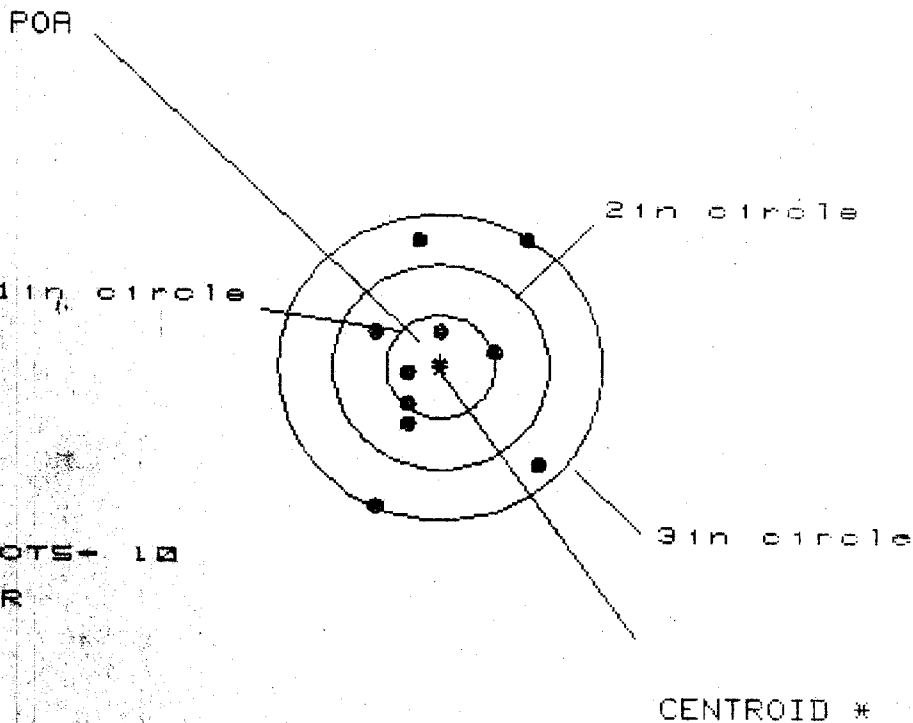
NUMBER IN THREE INCH CIRCLE =

9

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6645248

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

* IN CIR

1 1 1 3

2 1 1 6

3 1 1 9

10 1 1.400

10 2 2.601

10 3 2.983

PATTERN

SHOTS (BEST OF)

10

9

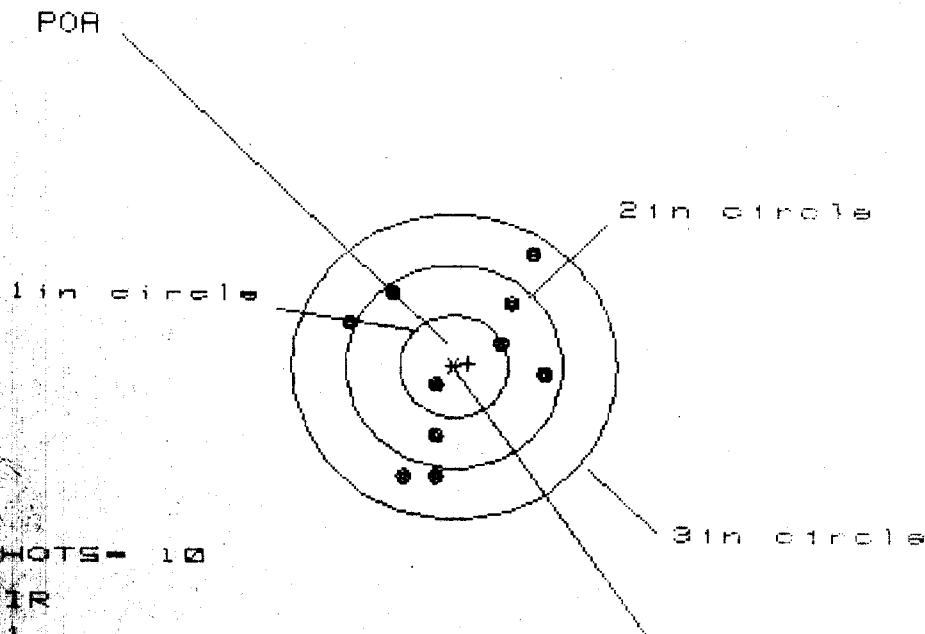
8

EXTREMUM X		.877	.972	.907
MINIMUM X		-.612	-.517	-.576
EXTREMUM Y		1.271	1.337	1.188
MINIMUM Y		-1.938	-1.189	-.996
CENTROID X		-.000	-.095	-.030
CENTROID Y		-.046	-.187	-.038
FOR TO CENTROID in.		.046	.210	.049
EXTREMUMS		.318	.222	.304
MINIMUMS		.046	.746	.678
EXTREMUMS		1.528	1.338	1.347
HORIZONTAL SPREAD		1.409	1.489	1.483
VERTICAL SPREAD		2.601	2.526	2.184
EXTREMUM SPREAD		2.983	2.567	2.416
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6645243

CENTERFIRE PATTERNS # 5



1 OF SHOTS - 10

1 IN CIR

1 1 1

2 1 1 6

3 1 10

10 1.728

20 0.040

30 0.550

CENTROID *

PATTERN #

SHOTS (BEST OF)

10

9

8

MAXIMUM X	: .798	.878	.825
MINIMUM X	: -.938	-.850	-.903
MAXIMUM Y	: 1.157	.876	.757
MINIMUM Y	: -1.083	-.955	-1.074
CENTROID X	: -.129	-.209	-.156
CENTROID Y	: -.624	-.152	-.033
POA TO CENTROID (in)	: .131	.258	.160
MAX SPREAD	: .264	.114	.241
MIN SPREAD	: .865	.793	.762
MAX SPREAD	: 1.361	1.043	1.081
MIN SPREAD	: 1.728	1.728	1.728
VERTICAL SPREAD	: 2.240	1.831	1.831
HORIZONTAL SPREAD	: 2.550	1.937	1.883
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649248
16 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0780577
1 TO	2	.600021
1 TO	3	.448144
1 TO	4	.310103
1 TO	5	.182439

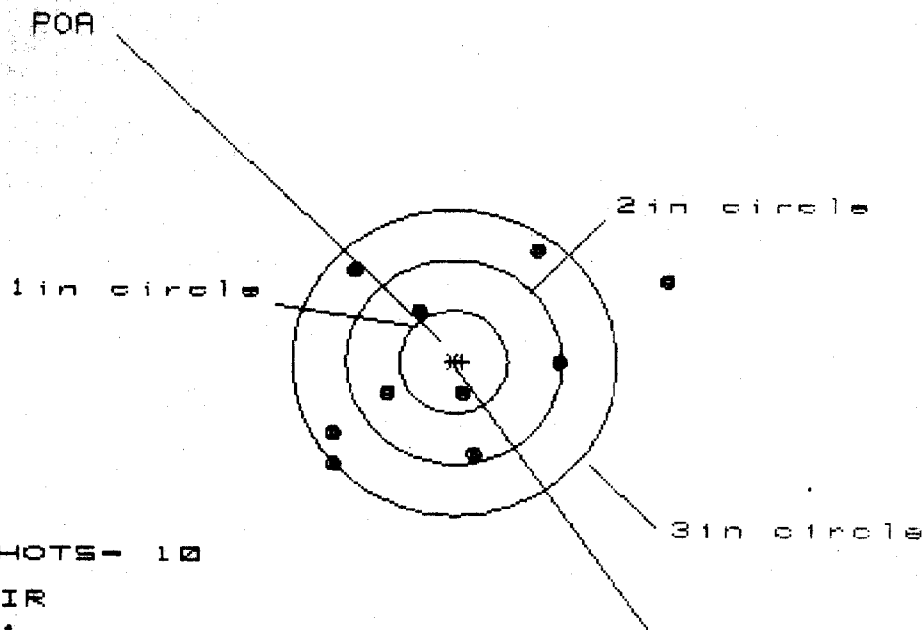
$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1404
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1678
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .21879
THE AMR FOR THIS RIFLE IS: .9638

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 4

HS= 3.069

VS= 2.145

GS= 3.579

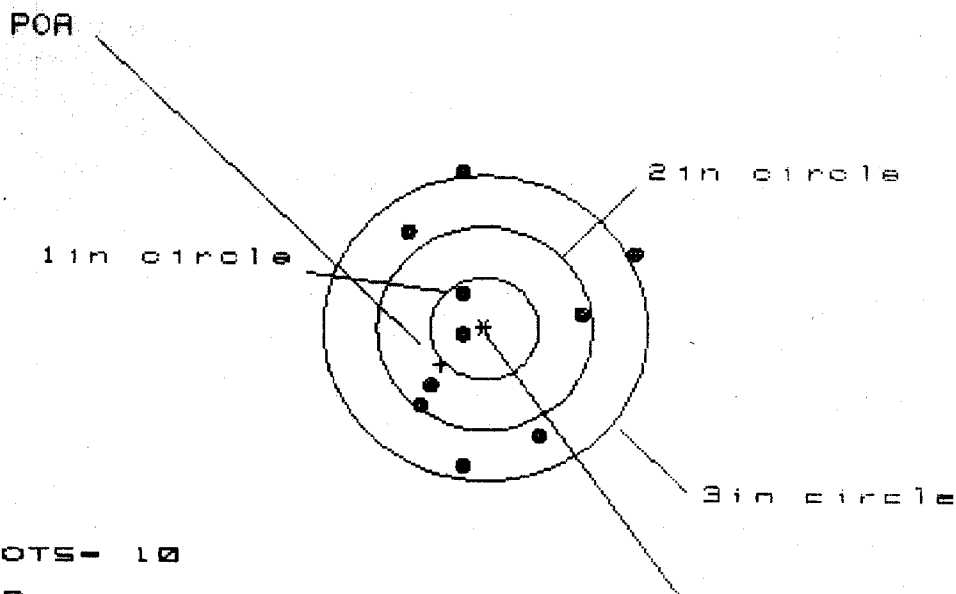
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.981	1.159	1.051
MINIMUM X	:	-1.088	-.867	-.975
MAXIMUM Y	:	1.125	1.217	1.101
MINIMUM Y	:	-1.020	-.928	-.949
CENTROID X	:	-.078	-.299	-.191
CENTROID Y	:	-.003	-.095	.021
POA TO CENTROID in.	:	.078	.313	.192
MIN RADIUS	:	.351	.376	.407
MEAN RADIUS	:	1.109	.959	.924
MAX RADIUS	:	2.148	1.595	1.437
HORIZONTAL SPREAD	:	3.069	2.026	2.026
VERTICAL SPREAD	:	2.145	2.145	2.050
EXTREME SPREAD	:	3.579	2.862	2.655
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.116

VS= 2.849

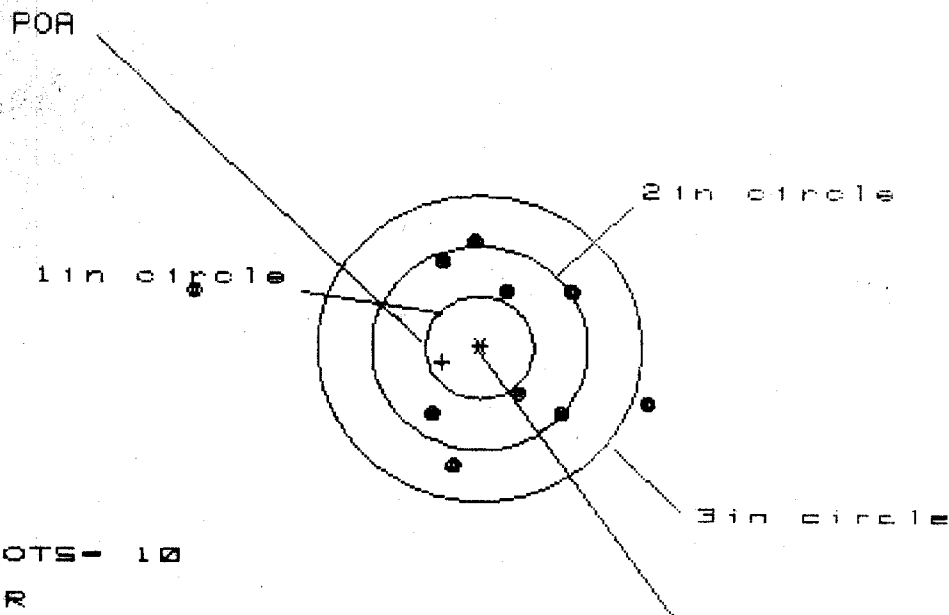
GS= 2.849

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.072	1.066
MINIMUM X	:	-.739	-.586	-.592
MAXIMUM Y	:	1.530	1.611	1.228
MINIMUM Y	:	-1.319	-1.238	-1.036
CENTROID X	:	.405	.252	.258
CENTROID Y	:	.353	.272	.070
POA TO CENTROID in.	:	.537	.370	.268
MIN RADIUS	:	.224	.063	.227
MEAN RADIUS	:	1.012	.915	.822
MAX RADIUS	:	1.559	1.612	1.363
HORIZONTAL SPREAD	:	2.116	1.658	1.658
VERTICAL SPREAD	:	2.849	2.849	2.264
EXTREME SPREAD	:	2.849	2.849	2.319
NUMBER IN ONE INCH CIRCLE	=	2	2	2
NUMBER IN TWO INCH CIRCLE	=	4	4	4
NUMBER IN THREE INCH CIRCLE	=	8	8	8

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248.1

CENTERFIRE PATTERNS # 3



* OF SHOTS - 10

* IN CIR

1 in = 0

2 in = 6

3 in = 8

HS = 4.231

VS = 2.160

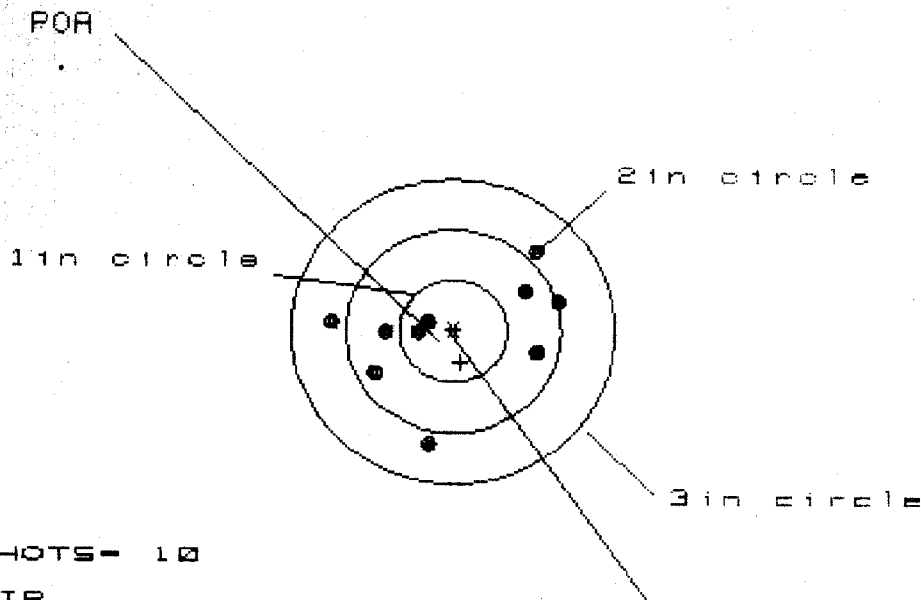
GS = 4.370

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.569	1.273	.676
MINIMUM X	:	-2.662	-.751	-.591
MAXIMUM Y	:	1.045	1.101	1.035
MINIMUM Y	:	-1.115	-1.059	-1.125
CENTROID X	:	.345	.641	.481
CENTROID Y	:	.145	.089	.155
POA TO CENTROID in.	:	.374	.647	.506
MIN RADIUS	:	.587	.425	.530
MEAN RADIUS	:	1.138	.920	.859
MAX RADIUS	:	2.710	1.380	1.187
HORIZONTAL SPREAD	:	4.231	2.024	1.267
VERTICAL SPREAD	:	2.160	2.160	2.160
EXTREME SPREAD	:	4.370	2.384	2.173
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649248.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.019

VS= 1.825

GS= 2.045

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.800	.761
MINIMUM X	-1.097	-.819	-.858
MAXIMUM Y	.766	.777	.646
MINIMUM Y	-1.059	-1.048	-.497
CENTROID X	-.070	.052	.091
CENTROID Y	.307	.296	.427
POA TO CENTROID in.	.315	.300	.436
MIN RADIUS	.209	.330	.368
MEAN RADIUS	.768	.740	.689
MAX RADIUS	1.102	1.093	.991
HORIZONTAL SPREAD	2.019	1.619	1.619
VERTICAL SPREAD	1.825	1.825	1.143
EXTREME SPREAD	2.045	2.045	1.831
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

FILE:/PATTERNING/CENTERFIRE_PATT/06649248.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.199

VS= 1.681

GS= 2.263

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.080	.955	.614
MINIMUM X	:	-1.119	-.967	-.847
MAXIMUM Y	:	.774	.714	.706
MINIMUM Y	:	-.907	-.967	-.975
CENTROID X	:	.100	.225	.105
CENTROID Y	:	.037	.097	.105
POA TO CENTROID in.	:	.107	.245	.149
MIN RADIUS	:	.123	.096	.062
MEAN RADIUS	:	.792	.723	.692
MAX RADIUS	:	1.241	1.059	1.120
HORIZONTAL SPREAD	:	2.199	1.922	1.461
VERTICAL SPREAD	:	1.681	1.681	1.681
EXTREME SPREAD	:	2.263	1.981	1.966
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	