

06587512

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*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™ M24

SERIAL NO. C6587512

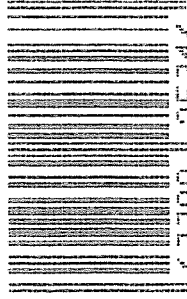
ORDER NO. 5716

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



5716 C6587512

UPC



0 47700 25716

7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587512

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY CONTROL LOG	10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel <i>LB</i>		11/7/90	LB
620	Apply Coatings (Barrel Action)		12/26/90	<i>LB</i>
	Apply Coating (Bolt)		12/26/90	<i>LB</i>
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-4-91	<i>LB</i>

op. #	BARBER - M24 0021785 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	4.50	4.75			1/2/91	KZ
	G) Safety Off Force	2.75	2.75	2.75			1/2/91	KZ
	H) Trigger Pull Test & Retainability						1-4-91	JH
	I) Firing Pin Indent	.021	.021	.021			1/2/91	KZ
	J) Assemble Stock						1-4-91	KS
	K) Assemble Swivel Studs						1-14-91	JH
	L) Attach Front and Rear Sight Assemblies						1-4-91	KS
	M) Iron Sight Alignment						1-4-91	KS
	N) Detach Front & Rear Sights & place in numbered container						1-4-91	KS
	O) Attach Scope to Rifle						1-4-91	KS
	P) Detach & Attach Scope 20 Times						1-4-91	KS
640	Gallery Target & Test						1-13-91	AC
	A) Time						1-13-91	AC
	B) Malfunctions						1-13-91	AC
	C) Pierced Primers						1-13-91	AC
	D) Optical Clarity of Scope						1-13-91	AC
645	Inspect for Live Ammo						1-13-91	AC
655	Final Inspection A) Headspace						1-14-91	JH
	B) Trigger Pull	2.54	2.26	2.24	2.13	2.13	1-14-91	JH
	C) Function						1-14-91	JH
660	Pack						3-18-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06587512

DATE 1-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.35	2.29	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.40	2.33	2.26	
PULL #3	2.47	2.36	2.27	2.21	
PULL #4	2.29	2.38	2.28	2.13	
PULL #5	2.33	2.37	2.20	2.13	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.33		
PULL #2	3.35	3.31		
PULL #3	3.30	3.33		
PULL #4	3.29	3.24		
PULL #5	3.31	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.33		4.28
PULL #2	4.39	4.30		4.20
PULL #3	4.30	4.30		4.24
PULL #4	4.30	4.31		4.24
PULL #5	4.29	4.38		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587512
14 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.272413
1 TO 2	.690566
1 TO 3	.384064
1 TO 4	.290043
1 TO 5	.479517

51 <----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0818
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105106

THE AMR FOR THIS RIFLE IS: .919

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587512

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.548

VS = 2.318

GS = 2.548

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.435	1.000	.990
MINIMUM X	:	-1.113	-.954	-.964
MAXIMUM Y	:	1.089	1.089	.936
MINIMUM Y	:	-1.229	-1.229	-.792
CENTROID X	:	.272	.113	.123
CENTROID Y	:	.015	.016	.169
POA TO CENTROID in.	:	.273	.114	.209
MIN RADIUS	:	.480	.553	.681
MEAN RADIUS	:	1.024	.979	.940
MAX RADIUS	:	1.435	1.231	1.109
HORIZONTAL SPREAD	:	2.548	1.954	1.954
VERTICAL SPREAD	:	2.318	2.318	1.728
EXTREME SPREAD	:	2.548	2.333	2.063
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

14 Jan 1991

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

H= 1.704

V= 3.126

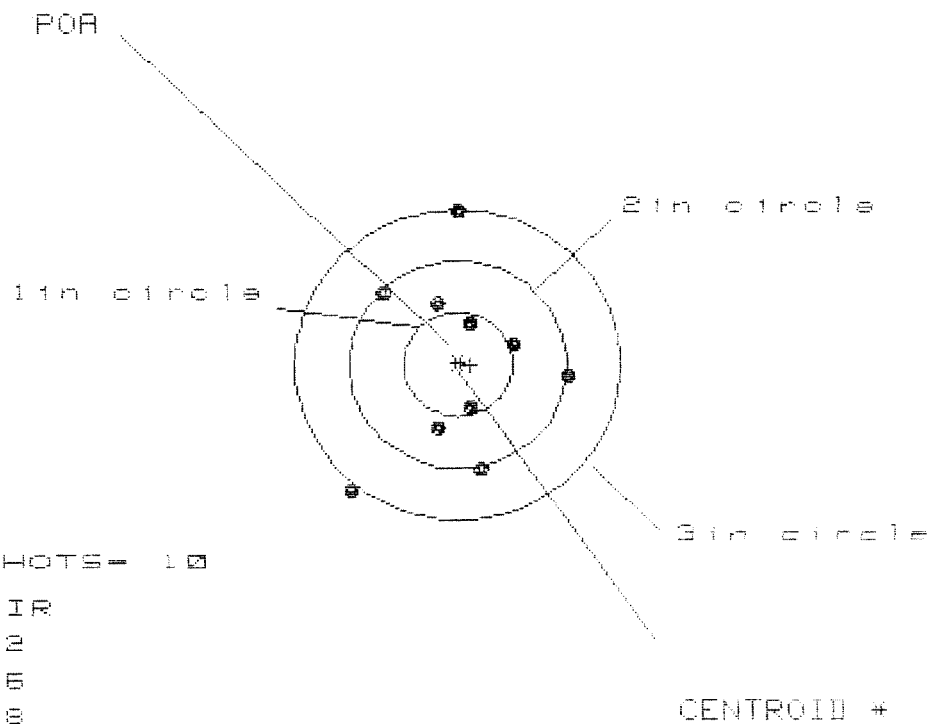
GS= 3.131

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.836	.837	.889
MINIMUM X	:	-.868	-.867	-.815
MAXIMUM Y	:	1.193	.978	.796
MINIMUM Y	:	-1.933	-1.458	-1.365
CENTROID X	:	.367	.366	.314
CENTROID Y	:	-.669	-.454	-.272
POA TO CENTROID in.	:	.763	.583	.415
MIN RADIUS	:	.217	.285	.107
MEAN RADIUS	:	.980	.833	.700
MAX RADIUS	:	1.933	1.516	1.365
HORIZONTAL SPREAD	:	1.704	1.704	1.704
VERTICAL SPREAD	:	3.126	2.436	2.161
EXTREME SPREAD	:	3.131	2.532	2.164
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.056

VS= 2.714

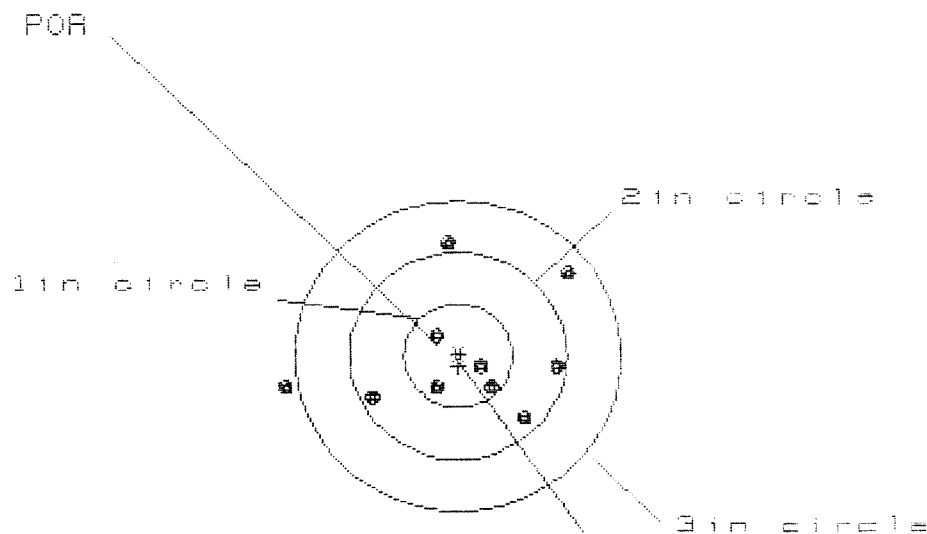
GS= 2.921

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.029
MINIMUM X	-1.027
MAXIMUM Y	1.504
MINIMUM Y	-1.210
CENTROID X	-.112
CENTROID Y	.008
POA TO CENTROID in.	.112
MIN RADIUS	.406
MEAN RADIUS	.872
MAX RADIUS	1.588
HORIZONTAL SPREAD	2.056
VERTICAL SPREAD	2.714
EXTREME SPREAD	2.921
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587512

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.654

VS= 1.665

CS= 2.877

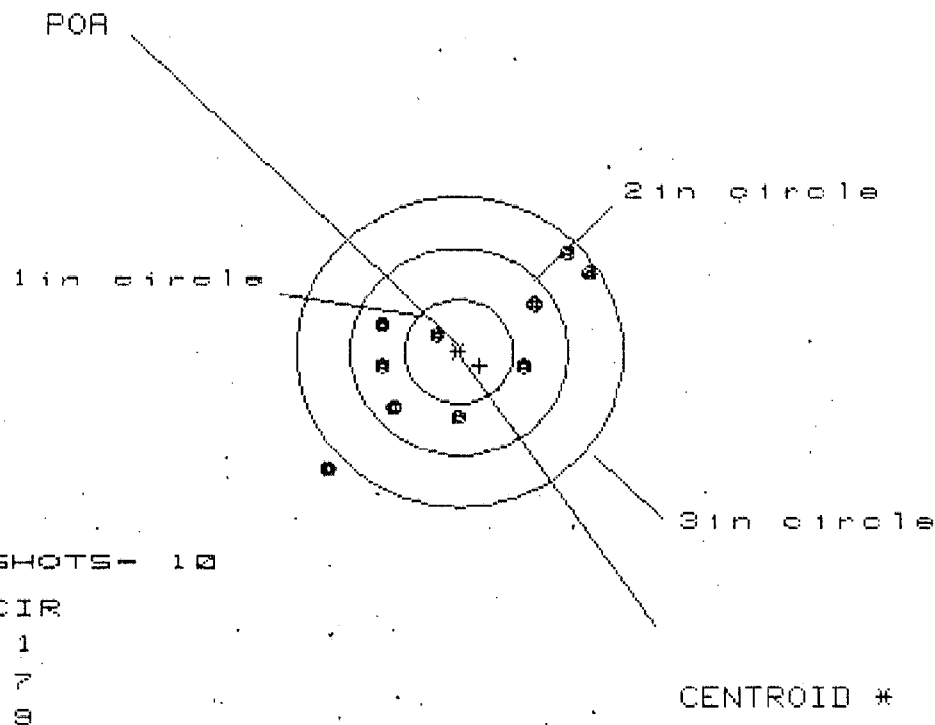
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.019	.837	.795
MINIMUM X	:	-1.635	-.964	-.859
MAXIMUM Y	:	1.077	1.042	1.138
MINIMUM Y	:	-.588	-.623	-.527
CENTROID X	:	-.005	.177	.072
CENTROID Y	:	.101	.136	.040
POA TO CENTROID in.	:	.101	.223	.082
MIN RADIUS	:	.234	.104	.149
MEAN RADIUS	:	.795	.682	.687
MAX RADIUS	:	1.664	1.134	1.151
HORIZONTAL SPREAD	:	2.654	1.801	1.654
VERTICAL SPREAD	:	1.665	1.665	1.665
EXTREME SPREAD	:	2.877	2.177	1.792
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jan 1991

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CENTERFIRE PATTERNS # 5



HS= 2.415

VS= 2.187

GS= 3.122

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.236	1.105	1.036
MINIMUM X	-1.179	-.874	-.736
MAXIMUM Y	1.013	.882	.967
MINIMUM Y	-1.174	-.815	-.730
CENTROID X	-.192	-.061	-.199
CENTROID Y	.136	.267	.182
POA TO CENTROID in.	.235	.273	.270
MIN RADIUS	.222	.309	.192
MEAN RADIUS	.924	.847	.762
MAX RADIUS	1.664	1.294	1.417
HORIZONTAL SPREAD	2.415	1.979	1.772
VERTICAL SPREAD	2.187	1.697	1.697
EXTREME SPREAD	3.122	2.331	2.303
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	