

C6587547

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

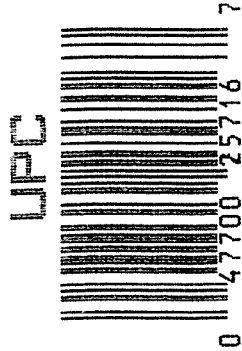
DU PONT

SERIAL NO.
 C6587547

ORDER NO.
 5716

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



GUN SERIAL # C 6587547

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KA
600	Proof		10/22/90	KA
607	Check Headspace		10/22/90	KA
610	Dis-assemble Gun		10/22/90	KA
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes		10/29/90	FB
618	Polish Barrel <i>RoB</i>		11/30/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/28/90	JA

op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	4	4	4	11/29/90	WB	
	G) Safety Off Force	2 1/2	2 3/4	2 1/2	11/29/90	WB	
	H) Trigger Pull Test & Retainability				11-29-90	JS	
	I) Firing Pin Indent	.0205	.0215	.021	11/29/90	WB	
	J) Assemble Stock				11/30/90	KS	
	K) Assemble Swivel Studs				12-4-90	JS	
	L) Attach Front and Rear Sight Assemblies				11/30/90	KS	
	M) Iron Sight Alignment				11/30/90	KS	
	N) Detach Front & Rear Sights & place in numbered container				11/30/90	KS	
	O) Attach Scope to Rifle				11/30/90	KS	
P) Detach & Attach Scope 20 Times				11/30/90	KS		
640	Gallery Target & Test				12/1/90	NF	
	A) Time				"	NF	
	B) Malfunctions				"	NF	
	C) Pierced Primers				"	NF	
	D) Optical Clarity of Scope				"	NF	
645	Inspect for Live Ammo				12/1/90	NF	
655	Final Inspection						
	A) Headspace				12-4-90	JS	
	B) Trigger Pull	270	269	268	271 273	12-4-90	JS
	C) Function				12-4-90	JS	
660	Pack				12-18-90	DH	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587547DATE 11/28/90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.26	2.33	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.32	2.30	2.69	
PULL #3	2.26	2.30	2.31	2.68	
PULL #4	2.24	2.31	2.30	2.71	
PULL #5	2.24	2.29	2.31	2.73	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.31		
PULL #2	3.10	3.36		
PULL #3	3.23	3.34		
PULL #4	3.11	3.37		
PULL #5	3.27	3.39		
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	4.43		4.35
PULL #2	4.41	4.38		4.39
PULL #3	4.28	4.39		4.39
PULL #4	4.37	4.46		4.22
PULL #5	4.41	4.36		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587547
1 Dec 1998

CENTROIDAL DISTANCES

0 TO	1	.344859
1 TO	2	.293886
1 TO	3	.289415
1 TO	4	.897287
1 TO	5	.345326

1g
3+ <----FOR

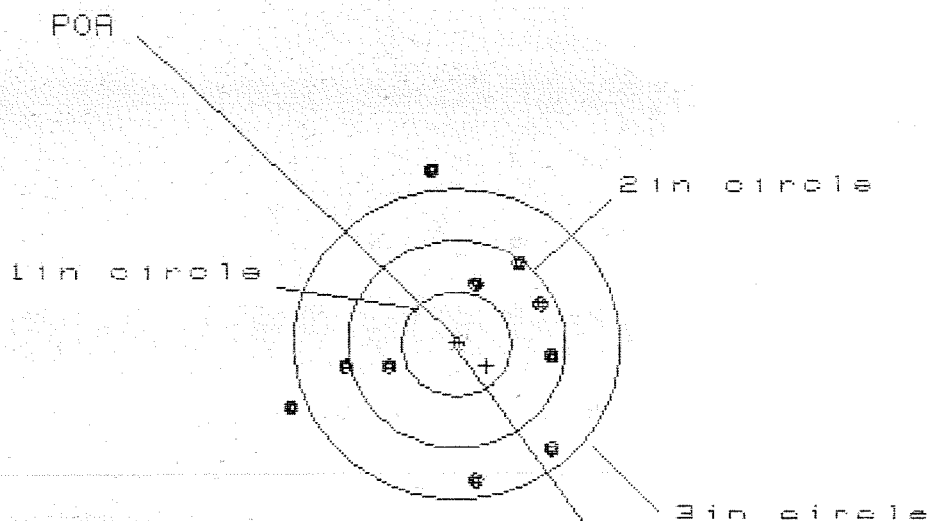
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0516
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0668
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0844085

THE AMR FOR THIS RIFLE IS: .8714

1 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587547

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.450

VS= 2.920

GS= 2.943

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.716	.666
MINIMUM X	-1.561	-1.187	-1.237
MAXIMUM Y	1.639	1.574	.883
MINIMUM Y	-1.281	-1.346	-1.149
CENTROID X	-.272	-.099	-.049
CENTROID Y	.212	.277	.080
POA TO CENTROID in.	.345	.294	.094
MIN RADIUS	.627	.567	.600
MEAN RADIUS	1.092	1.002	.923
MAX RADIUS	1.667	1.624	1.241
HORIZONTAL SPREAD	2.450	1.903	1.903
VERTICAL SPREAD	2.920	2.920	2.032
EXTREME SPREAD	2.943	2.943	2.082
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

1 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587547

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

CENTROID *

HS = 2.845

VS = 2.450

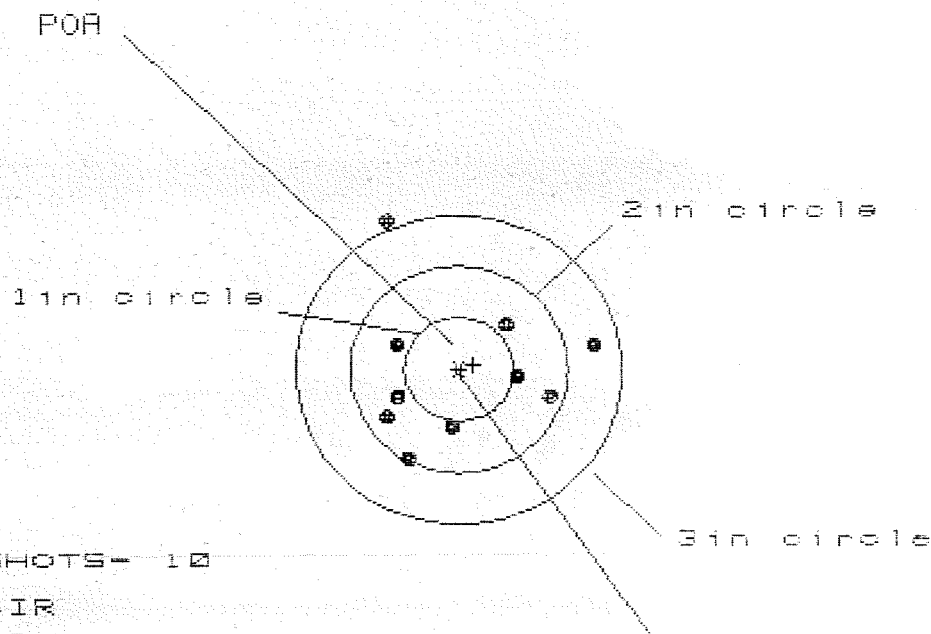
GS = 3.353

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.990
MINIMUM X	-1.855
MAXIMUM Y	1.177
MINIMUM Y	-1.273
CENTROID X	-.012
CENTROID Y	.075
POA TO CENTROID in.	.076
MIN RADIUS	.262
MEAN RADIUS	.893
MAX RADIUS	1.922
HORIZONTAL SPREAD	2.845
VERTICAL SPREAD	2.450
EXTREME SPREAD	3.353
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

1 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08587547

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 9

HS= 1.908

VS= 2.305

GS= 2.310

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.231
MINIMUM X	-.677
MAXIMUM Y	1.485
MINIMUM Y	-.820
CENTROID X	-.137
CENTROID Y	-.044
POA TO CENTROID in.	.144
MIN RADIUS	.506
MEAN RADIUS	.845
MAX RADIUS	1.622
HORIZONTAL SPREAD	1.908
VERTICAL SPREAD	2.305
EXTREME SPREAD	2.310
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 8
NUMBER IN THREE INCH CIRCLE	= 9

1 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587547

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.422

VS = 1.629

GS = 2.523

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.461	1.259	.695
MINIMUM X	:	-.961	-.799	-.641
MAXIMUM Y	:	.932	.896	.897
MINIMUM Y	:	-.697	-.733	-.732
CENTROID X	:	.168	.006	-.152
CENTROID Y	:	-.570	-.534	-.535
POA TO CENTROID in.	:	.594	.534	.556
MIN RADIUS	:	.202	.054	.123
MEAN RADIUS	:	.846	.745	.670
MAX RADIUS	:	1.496	1.259	.953
HORIZONTAL SPREAD	:	2.422	2.050	1.336
VERTICAL SPREAD	:	1.629	1.629	1.629
EXTREME SPREAD	:	2.523	2.086	1.825
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Dec 1990

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.762

VS= 1.931

GS= 2.041

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.796	.688	.680
MINIMUM X	-.966	-.580	-.588
MAXIMUM Y	.826	.900	.771
MINIMUM Y	-1.105	-1.031	-.518
CENTROID X	-.005	.103	.111
CENTROID Y	-.007	-.081	.048
POA TO CENTROID in.	.008	.131	.121
MIN RADIUS	.121	.090	.194
MEAN RADIUS	.681	.616	.570
MAX RADIUS	1.172	1.070	.969
HORIZONTAL SPREAD	1.762	1.268	1.268
VERTICAL SPREAD	1.931	1.931	1.289
EXTREME SPREAD	2.041	1.999	1.747
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	