

C6636283

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



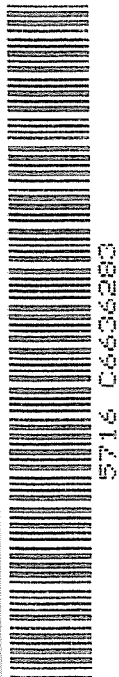
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

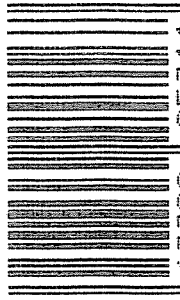
MODEL 700™ M24

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

SERIAL NO. C6636283	ORDER NO. 5716
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UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636283

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	KR
617	Drill and Tap Sight Holes	JUL	2 1991	LB
618	Polish Barrel	JUL	7 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/19/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/19/91	KL
	C) Inspect Ejector Hole for Chamfer		8/19/91	KL
	D) Oil Firing Pin Ass'y		8/19/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/91	KL

op. #	BARBER - M24 0032585	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/20/91	JK
	G) Safety Off Force	2	2	2			8/20/91	JK
	H) Trigger Pull Test & Retainability						8/20/91	JK
	I) Firing Pin Indent	1021	1021	1021			8/20/91	JK
	J) Assemble Stock						8/20/91	JK
	K) Assemble Swivel Studs						8/22/91	JK
	L) Attach Front and Rear Sight Assemblies						8/20/91	JK
	M) Iron Sight Alignment						8/20/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	JK
	O) Attach Scope to Rifle						8/20/91	JK
	P) Detach & Attach Scope 20 Times						8/20/91	JK
640	Gallery Target & Test						8/21/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/21/91	KT
655	Final Inspection						8/21/91	JK
	A) Headspace						8/21/91	JK
	B) Trigger Pull	2.49	2.50	2.60	2.46	2.55	8/22/91	JK
	C) Function						8/22/91	JK
660	Pack						9-18-91	JK

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636283
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.20801
1 TO	2	.0950789
1 TO	3	.247073
1 TO	4	.02
1 TO	5	.127613

4 <----POA

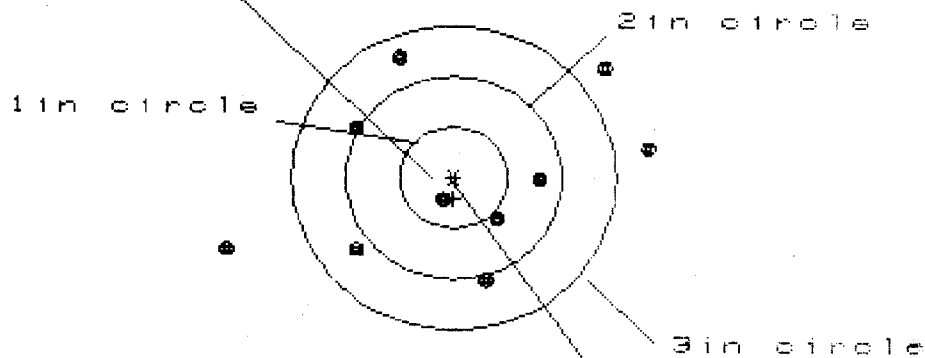
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0052
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1206
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120759
THE AMR FOR THIS RIFLE IS: 1.019

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B3

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 3.937

VS = 2.161

GS = 4.072

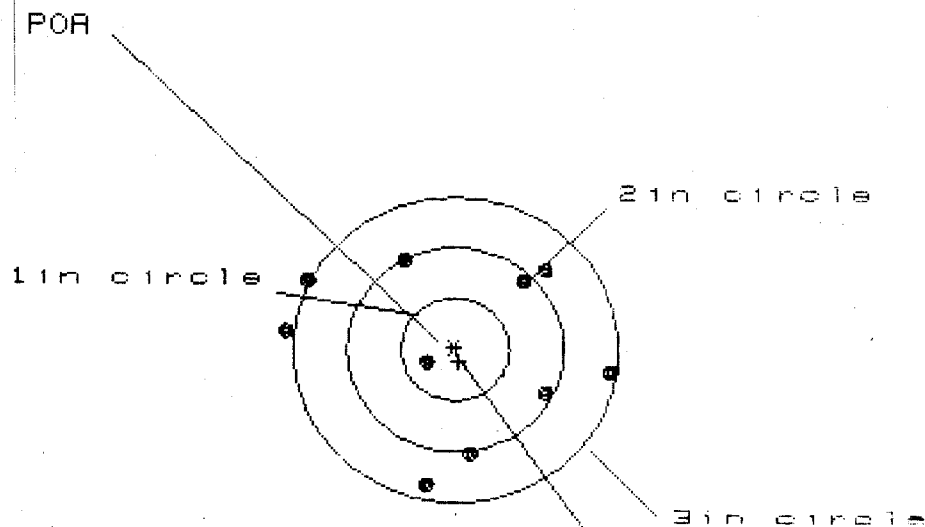
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.805	1.568	1.338
MINIMUM X	:	-2.132	-1.184	-.988
MAXIMUM Y	:	1.186	1.108	1.140
MINIMUM Y	:	-.975	-1.053	-1.021
CENTROID X	:	.002	.239	.043
CENTROID Y	:	.208	.286	.254
POA TO CENTROID in.	:	.208	.373	.257
MIN RADIUS	:	.224	.438	.283
MEAN RADIUS	:	1.193	1.074	.989
MAX RADIUS	:	2.245	1.590	1.680
HORIZONTAL SPREAD	:	3.937	2.752	2.326
VERTICAL SPREAD	:	2.161	2.161	2.161
EXTREME SPREAD	:	4.072	2.942	2.926
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.944

VS = 2.228

GS = 2.868

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.416	1.246	1.058
MINIMUM X	:	-1.528	-1.499	-.795
MAXIMUM Y	:	.876	.895	.980
MINIMUM Y	:	-1.352	-1.333	-1.248
CENTROID X	:	-.034	.136	.324
CENTROID Y	:	.120	.101	.016
POA TO CENTROID in.	:	.124	.170	.324
MIN RADIUS	:	.303	.452	.546
MEAN RADIUS	:	1.107	1.047	.951
MAX RADIUS	:	1.537	1.646	1.409
HORIZONTAL SPREAD	:	2.944	2.745	1.853
VERTICAL SPREAD	:	2.228	2.228	2.228
EXTREME SPREAD	:	2.968	2.880	2.402
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.171

VS= 2.745

GS= 3.255

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.964	2.112	1.272
MINIMUM X	-1.207	-1.059	-.795
MAXIMUM Y	.921	.719	.521
MINIMUM Y	-1.824	-.751	-.661
CENTROID X	.025	-.123	-.387
CENTROID Y	-.038	.164	.074
POA TO CENTROID in.	.046	.205	.394
MIN RADIUS	.273	.317	.260
MEAN RADIUS	1.094	.915	.678
MAX RADIUS	2.255	2.231	1.336
HORIZONTAL SPREAD	3.171	3.171	2.067
VERTICAL SPREAD	2.745	1.470	1.182
EXTREME SPREAD	3.255	3.247	2.131
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.744

VS = 1.777

GS = 2.045

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.627	.503	.535
MINIMUM X	-1.117	-1.196	-1.164
MAXIMUM Y	.751	.709	.576
MINIMUM Y	-1.026	-1.068	-.538
CENTROID X	.002	.126	.094
CENTROID Y	.228	.270	.403
POA TO CENTROID in.	.228	.298	.414
MIN RADIUS	.306	.326	.297
MEAN RADIUS	.757	.688	.635
MAX RADIUS	1.179	1.199	1.166
HORIZONTAL SPREAD	1.744	1.699	1.699
VERTICAL SPREAD	1.777	1.777	1.114
EXTREME SPREAD	2.045	1.850	1.776
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.174

VS = 2.423

GS = 2.553

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	1.118	1.101
MINIMUM X	:	-1.034	-1.056	-.983
MAXIMUM Y	:	1.118	.972	.651
MINIMUM Y	:	-1.310	-.910	-.794
CENTROID X	:	.036	.058	-.015
CENTROID Y	:	.085	.231	.109
POA TO CENTROID in.	:	.093	.238	.110
MIN RADIUS	:	.600	.484	.545
MEAN RADIUS	:	.942	.887	.845
MAX RADIUS	:	1.325	1.136	1.193
HORIZONTAL SPREAD	:	2.174	2.171	2.174
VERTICAL SPREAD	:	2.423	1.888	1.445
EXTREME SPREAD	:	2.553	2.196	2.182
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636283

DATE 8-20-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.36	2.35	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.46	2.38	2.50	
PULL #3	2.51	2.35	2.48	2.60	
PULL #4	2.45	2.35	2.44	2.46	
PULL #5	2.35	2.45	2.35	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.38		
PULL #2	3.29	3.30		
PULL #3	3.35	3.20		
PULL #4	3.34	3.29		
PULL #5	3.25	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.44		4.18
PULL #2	4.48	4.40		4.41
PULL #3	4.50	4.45		4.39
PULL #4	4.25	4.23		4.34
PULL #5	4.28	4.51		4.42
TOTAL				
AVG.				