

C6636096

MODEL 700TM M24

Model **S&S** TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

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

MODEL 700TM M24

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.

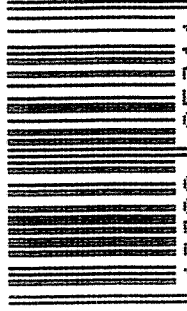
SERIAL NO.
C6636096

ORDER NO.
5716

20



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636096

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action	APR	9 1991	KR
	Magnaflux Bolt	APR	9 1991	U
615	Rollmark Caliber	APR	9 1991	LS
617	Drill and Tap Sight Holes	APR	9 1991	FB
618	Polish Barrel	APR	19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	AB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-16-91	JK
	G) Safety Off Force	4	4	4			5-16-91	JK
	H) Trigger Pull Test & Retainability						5-16-91	JK
	I) Firing Pin Indent	0.0205	0.0205	0.0205			5-16-91	JK
	J) Assemble Stock						5/18/91	RW
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/18/91	RW
	M) Iron Sight Alignment						5/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/18/91	RW
	O) Attach Scope to Rifle						5/18/91	RW
	P) Detach & Attach Scope 20 Times						5/18/91	RW
640	Gallery Target & Test						5/20/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						5/20/91	KJ
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.26	2.35	2.41	2.53	2.57	5/21/91	JK
	C) Function						5-21-91	D/H
660	Pack						6-17-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6636096

DATE 5-16-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.21	2.27	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.24	2.41	2.35	
PULL #3	2.27	2.23	2.23	2.41	
PULL #4	2.23	2.38	2.39	2.53	
PULL #5	2.21	2.36	2.40	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.30		
PULL #2	3.32	3.35		
PULL #3	3.36	3.42		
PULL #4	3.40	3.41		
PULL #5	3.33	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.33		4.34
PULL #2	4.25	4.21		4.36
PULL #3	4.25	4.33		4.35
PULL #4	4.26	4.28		4.21
PULL #5	4.25	4.26		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636896
20 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.15412
1 TO	2	.177496
1 TO	3	.396445
1 TO	4	.0878635
1 TO	5	.0588218

-----POA

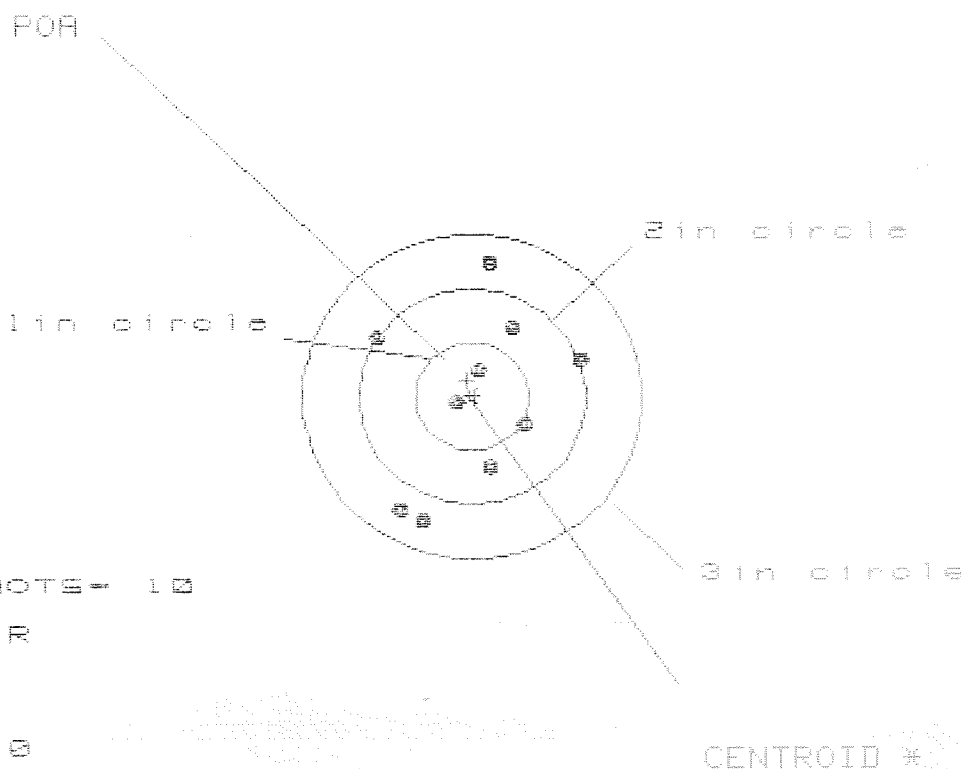
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0482
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0688
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .064004

THE AMR FOR THIS RIFLE IS: 1.119

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636096

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.003

VS = 2.403

GS = 2.539

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.005	1.028	.945
MINIMUM X	:	-.878	-.855	-.938
MAXIMUM Y	:	1.296	.806	.689
MINIMUM Y	:	-1.107	-.963	-1.000
CENTROID X	:	.043	.020	.103
CENTROID Y	:	-.148	-.292	-.175
POA TO CENTROID in.	:	.154	.293	.203
MIN RADIUS	:	.156	.176	.214
MEAN RADIUS	:	.821	.766	.702
MAX RADIUS	:	1.312	1.149	1.197
HORIZONTAL SPREAD	:	1.883	1.883	1.883
VERTICAL SPREAD	:	2.403	1.769	1.769
EXTREME SPREAD	:	2.539	2.209	2.056

NUMBER IN TWO INCH CIRCLE = 5
 NUMBER IN THREE INCH CIRCLE = 10

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB36096

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 3.167

VS = 3.495

GS = 3.684

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.394

1.341

1.112

MINIMUM Y

:

1.772

-1.926

-1.562

MINIMUM Y	:	-2.153	-1.145	-1.197
CENTROID X	:	-.081	-.028	.201
CENTROID Y	:	-.021	.219	.271
POA TO CENTROID in.	:	.083	.220	.337
MIN RADIUS	:	.910	.814	.581
MEAN RADIUS	:	1.378	1.272	1.162
MAX RADIUS	:	2.205	1.874	1.564
HORIZONTAL SPREAD	:	3.167	3.167	2.676
VERTICAL SPREAD	:	3.495	2.247	2.247
EXTREME SPREAD	:	3.684	3.387	2.784
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C5530096

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.540

VS= 3.907

GS= 3.920

PATTERN #

3

MAXIMUM X	:	1.287	1.190	1.109
MINIMUM X	:	-1.253	-1.350	-1.431
MAXIMUM Y	:	2.585	.756	.626
MINIMUM Y	:	-1.322	-1.034	-.566
CENTROID X	:	-.169	-.072	.009
CENTROID Y	:	.187	-.101	.029
POA TO CENTROID in.	:	.252	.124	.030
MIN RADIUS	:	.196	.021	.148
MEAN RADIUS	:	1.021	.769	.694
MAX RADIUS	:	2.728	1.353	1.432
HORIZONTAL SPREAD	:	2.540	2.540	2.540
VERTICAL SPREAD	:	3.907	1.790	1.192
EXTREME SPREAD	:	3.920	2.554	2.554
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636096

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 4.174

VS= 2.430

GS= 4.230

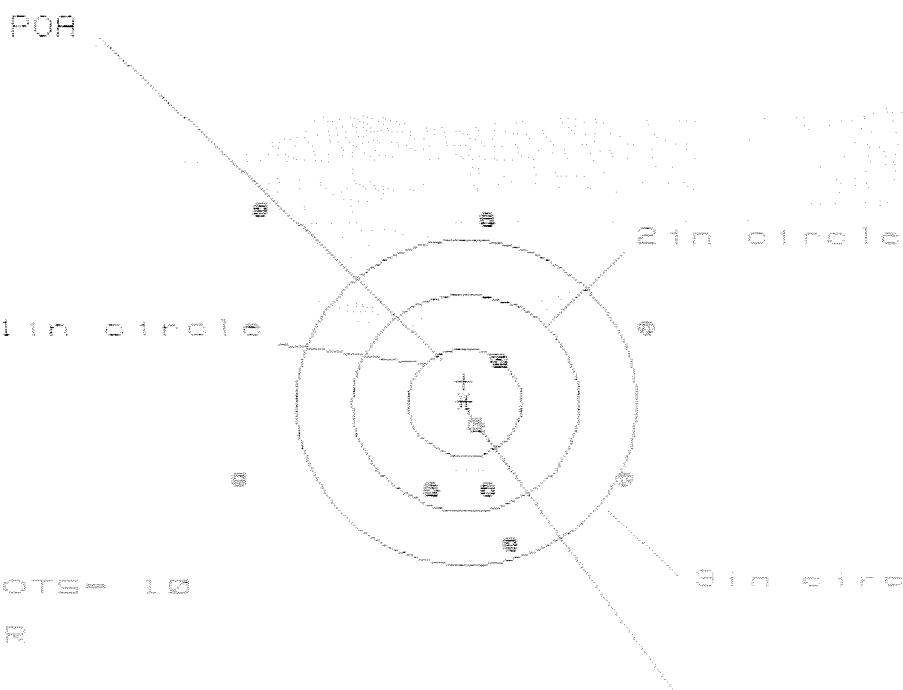
CENTROID #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.882	1.627	.765
MINIMUM X	-2.292	-.980	-.777
MAXIMUM Y	1.317	1.276	1.131
MINIMUM Y	-1.113	-1.154	-.969
CENTROID X	-.043	.212	.009
CENTROID Y	-.166	-.125	.020
POA TO CENTROID in.	.171	.246	.022
MIN RADIUS	.226	.206	.267
MEAN RADIUS	1.043	.887	.733
MAX RADIUS	2.322	1.995	1.152
HORIZONTAL SPREAD	4.174	2.607	1.542
VERTICAL SPREAD	2.430	2.430	2.100
EXTREME SPREAD	4.239	2.916	2.188
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638096

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 5

HS= 1.533

CENTROID #

VS= 3.106
GS= 4.073

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.573	1.374	1.104
MINIMUM X	:	-1.960	-2.159	-.733
MAXIMUM Y	:	1.797	1.867	1.801
MINIMUM Y	:	-1.309	-1.109	-1.175
CENTROID X	:	.009	.209	.479
CENTROID Y	:	-.196	-.396	-.330
POB TO CENTROID in.	:	.196	.447	.582
MIN RADIUS	:	.220	.118	.394
MEAN RADIUS	:	1.331	1.137	1.021
MAX RADIUS	:	2.540	2.221	1.827
HORIZONTAL SPREAD	:	3.533	3.533	1.837
VERTICAL SPREAD	:	3.106	2.976	2.976
EXTREME SPREAD	:	4.073	3.817	2.981
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	