

C65221B2

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522182

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KL
600	Proof		7/10/90	KL
607	Check Headspace		7/10/90	KL
610	Dis-assemble Gun		7/10/90	KL
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	GL
617	Drill and Tap Sight Holes		7/23/90	EB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	SA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/90	KS
	C) Inspect Ejector Hole for Chamfer		8/13/90	KS
	D) Oil Firing Pin Ass'y		8/13/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-12-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/13/90	QJ
	G) Safety Off Force	3	3	3			8/13/90	QJ
	H) Trigger Pull Test & Retainability						9-12-90	QJ
	I) Firing Pin Indent	.0235	.0235	.0235			8/13/90	QJ
	J) Assemble Stock						8/14/90	KS
	K) Assemble Swivel Studs						8/13/90	QJ
	L) Attach Front and Rear Sight Assemblies						8/14/90	KS
	M) Iron Sight Alignment						8/14/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/14/90	KS
	O) Attach Scope to Rifle						8/14/90	KS
	P) Detach & Attach Scope 20 Times						8/14/90	KS
640	Gallery Target & Test						8/15/90	A
	A) Time						8/15/90	A
	B) Malfunctions						8/15/90	A
	C) Pierced Primers						8/15/90	A
	D) Optical Clarity of Scope						8/15/90	A
645	Inspect for Live Ammo						8/15/90	A
655	Final Inspection							
	A) Headspace						9/13/90	QJ
	B) Trigger Pull	2.25	2.33	2.25	2.29	2.29	9-2-90	QJ
	C) Function						9/13/90	QJ
660	Pack						9-18-90	QJ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522182

DATE 9-12-90

TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.36	2.38	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.37	2.35	2.33	
PULL #3	2.27	2.36	2.37	2.25	
PULL #4	2.30	2.36	2.34	2.29	
PULL #5	2.33	2.37	2.37	2.29	
TOTAL	11.84	11.82	11.81	11.41	
AVG.	2.368	2.364	2.362	2.282	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.28		
PULL #2	3.27	3.28		
PULL #3	3.26	3.26		
PULL #4	3.27	3.33		
PULL #5	3.29	3.34		
TOTAL	16.31	16.49		
AVG.	3.262	3.298		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.36		4.38
PULL #2	4.33	4.33		4.35
PULL #3	4.33	4.36		4.39
PULL #4	4.28	4.39		4.34
PULL #5	4.35	4.37		4.40
TOTAL	21.59	21.81		21.86
AVG.	4.318	4.362		4.372

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522182
16 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.158152
1 TO	2	.408476
1 TO	3	.267002
1 TO	4	.138224
1 TO	5	.0751798

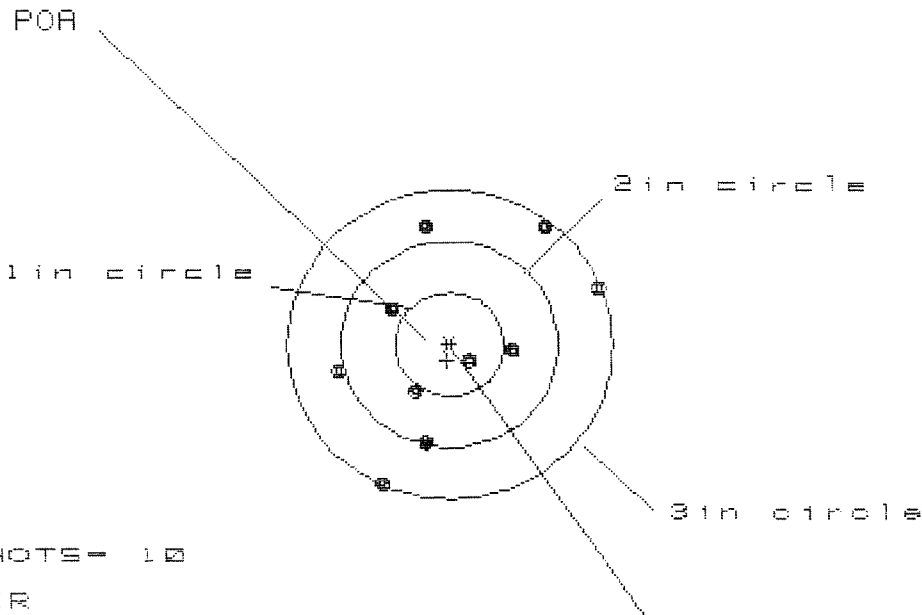
3.6
2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0544
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0474
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0721534
THE ANR FOR THIS RIFLE IS: .9894

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522182

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.365

VS= 2.575

GS= 2.915

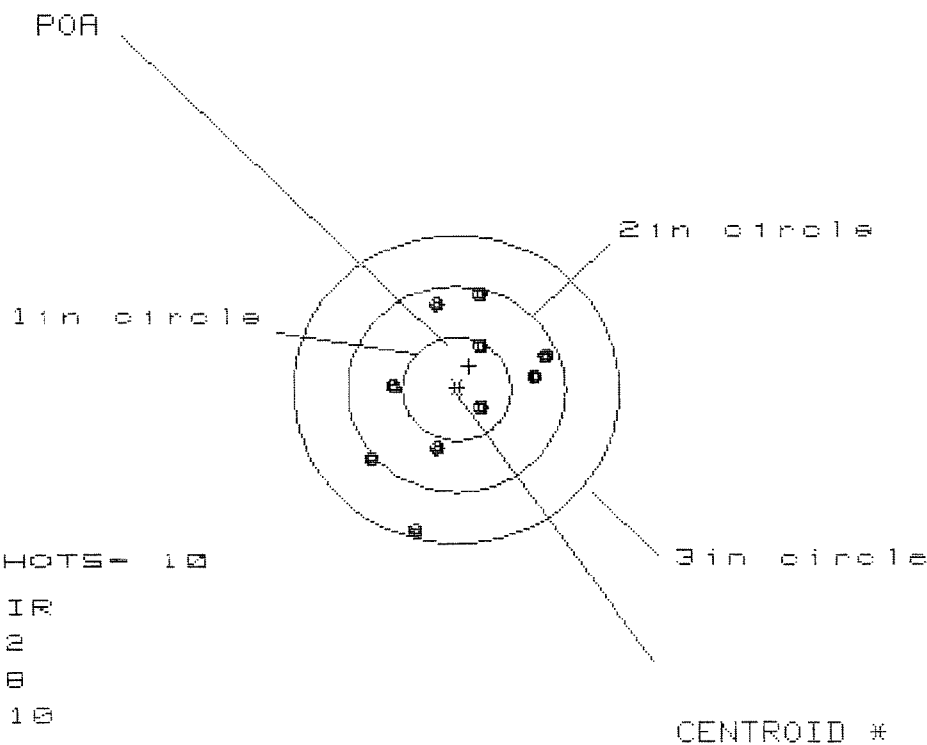
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.383	1.315	.980
MINIMUM X	-.982	-1.050	-.886
MAXIMUM Y	1.191	1.038	1.001
MINIMUM Y	-1.384	-1.104	-1.061
CENTROID X	.026	.094	-.070
CENTROID Y	.156	.309	.266
POA TO CENTROID in.	.158	.323	.275
MIN RADIUS	.179	.273	.324
MEAN RADIUS	.953	.901	.825
MAX RADIUS	1.514	1.360	1.405
HORIZONTAL SPREAD	2.365	2.365	1.866
VERTICAL SPREAD	2.575	2.142	2.142
EXTREME SPREAD	2.915	2.487	2.354
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

16 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.679

VS= 2.290

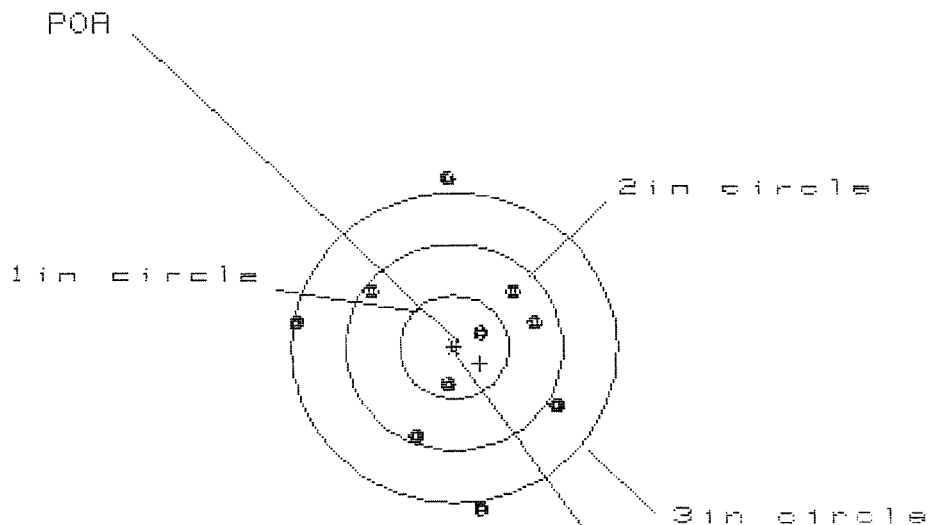
GS= 2.376

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.857	.812	.704
MINIMUM X	:	-.822	-.867	-.724
MAXIMUM Y	:	.967	.820	.718
MINIMUM Y	:	-1.323	-.812	-.863
CENTROID X	:	-.116	-.071	.037
CENTROID Y	:	-.227	-.080	.022
POA TO CENTROID in.	:	.255	.107	.043
MIN RADIUS	:	.225	.319	.177
MEAN RADIUS	:	.787	.704	.619
MAX RADIUS	:	1.384	1.188	.943
HORIZONTAL SPREAD	:	1.679	1.679	1.427
VERTICAL SPREAD	:	2.290	1.632	1.581
EXTREME SPREAD	:	2.376	1.967	1.645
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

16 Aug 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.409

VS= 3.163

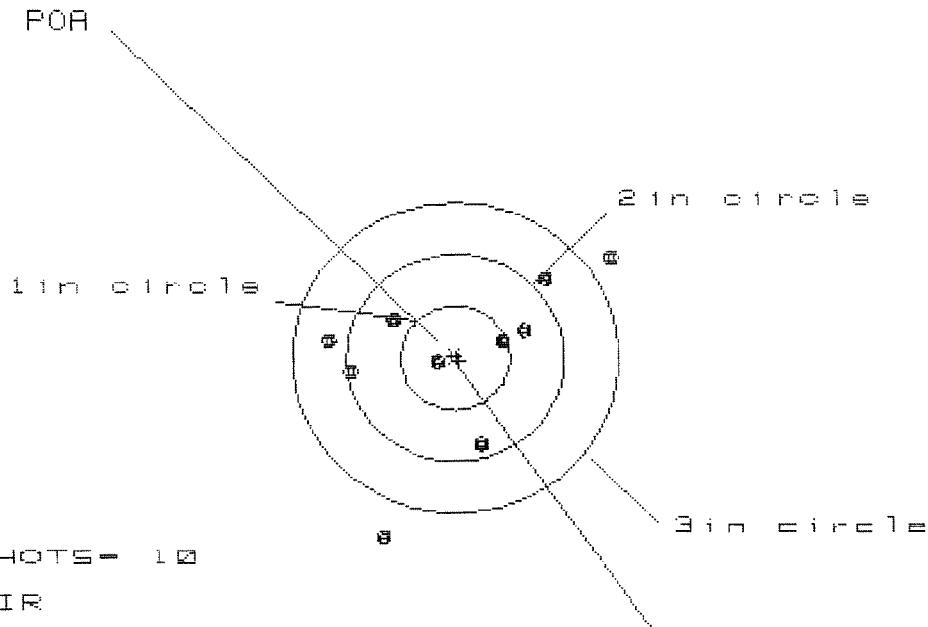
GS= 3.172

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.990
MINIMUM X	-1.419
MAXIMUM Y	1.646
MINIMUM Y	-1.517
CENTROID X	-.241
CENTROID Y	.157
POA TO CENTROID in.	.288
MIN RADIUS	.232
MEAN RADIUS	.978
MAX RADIUS	1.646
HORIZONTAL SPREAD	2.409
VERTICAL SPREAD	3.163
EXTREME SPREAD	3.172
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.632

VS= 2.691

GS= 3.450

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.448	1.369	.915
MINIMUM X	:	-1.184	-1.263	-1.092
MAXIMUM Y	:	.928	.732	.702
MINIMUM Y	:	-1.763	-.979	-.887
CENTROID X	:	-.033	.046	-.125
CENTROID Y	:	.031	.227	.136
POA TO CENTROID in.	:	.045	.232	.185
MIN RADIUS	:	.139	.321	.156
MEAN RADIUS	:	.975	.963	.759
MAX RADIUS	:	1.901	1.553	1.153
HORIZONTAL SPREAD	:	2.632	2.632	2.007
VERTICAL SPREAD	:	2.691	1.711	1.589
EXTREME SPREAD	:	3.450	2.751	2.118
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 3.208

VS= 2.555

GS= 3.305

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.638	1.581	1.406
MINIMUM X	:	-1.578	-1.396	-1.319
MAXIMUM Y	:	1.458	1.395	1.415
MINIMUM Y	:	-1.097	-1.160	-1.139
CENTROID X	:	.092	-.090	.085
CENTROID Y	:	.120	.183	.163
POA TO CENTROID in.	:	.151	.204	.183
MIN RADIUS	:	.397	.206	.381
MEAN RADIUS	:	1.254	1.179	1.153
MAX RADIUS	:	1.726	1.617	1.559
HORIZONTAL SPREAD	:	3.208	2.977	2.725
VERTICAL SPREAD	:	2.555	2.555	2.555
EXTREME SPREAD	:	3.305	2.982	2.975
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

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

MODEL 700™ H24

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

SERIAL NO.
C6522182

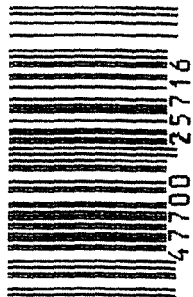
ORDER NO.
5716

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



5716 C6522182

UPC



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