

C6522132

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®

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

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

MODEL 700™ H24

SERIAL NO.
06522132

ORDER NO.
5716

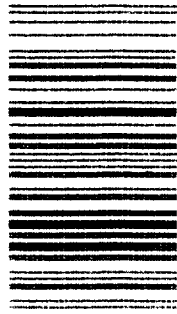
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 06522132

UPC



0 47700 25716

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522132

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9 90	90	RW
600	Proof	10 9 90	90	RW
607	Check Headspace	10 9 90	90	RW
610	Dis-assemble Gun	10 9 90	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	GL
617	Drill and Tap Sight Holes		10/18/90	FB
618	Polish Barrel RB		10/18/90	WS
620	Apply Coatings (Barrel Action)		11-5-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-10-91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.0	4.0	4.25			1/8/91	KJ
	G) Safety Off Force	3.50	3.50	3.25			1/8/91	KJ
	H) Trigger Pull Test & Retainability						1-10-91	JLL
	I) Firing Pin Indent	.020	.020	.020			1/8/91	KJ
	J) Assemble Stock						1/11/91	RW
	K) Assemble Swivel Studs						1/14/91	JLL
	L) Attach Front and Rear Sight Assemblies						1/11/91	RW
	M) Iron Sight Alignment						1/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/11/91	RW
	O) Attach Scope to Rifle						1/11/91	RW
	P) Detach & Attach Scope 20 Times						1/11/91	RW
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	JU
	B) Trigger Pull	2.28	2.41	2.30	2.41	2.44	1-14-91	JLL
	C) Function						1-14-91	JLL
660	Pack						3-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522152

DATE 1-10-91

TESTER JRL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.35	2.40	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.43	2.40	2.41	
PULL #3	2.44	2.40	2.41	2.30	
PULL #4	2.38	2.41	2.38	2.41	
PULL #5	2.37	2.20	2.44	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.17		
PULL #2	3.24	3.21		
PULL #3	3.21	3.17		
PULL #4	3.23	3.34		
PULL #5	3.25	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.34		4.38
PULL #2	4.41	4.32		4.38
PULL #3	4.39	4.34		4.30
PULL #4	4.41	4.30		4.41
PULL #5	4.32	4.42		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6522132
 14 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.333143
1 TO	2	.417404
1 TO	3	.512445
1 TO	4	.29045
1 TO	5	.652511

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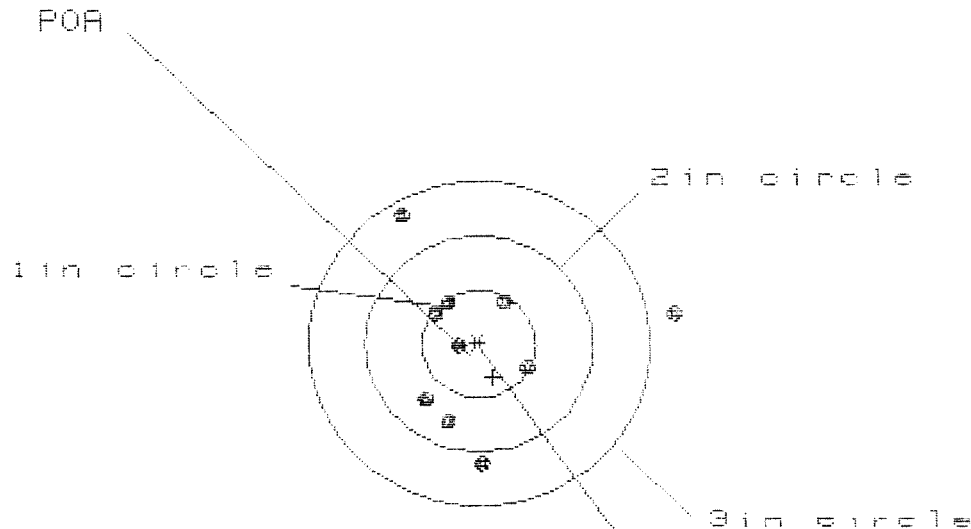
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1046
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0328
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1114
 THE AMP FOR THIS RIFLE IS: .8954

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522132

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.461

VS= 2.323

GS= 2.641

CENTROID +

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.739	.614	.548
MINIMUM X	:	-.722	-.528	-.340
MAXIMUM Y	:	1.206	1.233	.568
MINIMUM Y	:	-1.117	-1.090	-.935
CENTROID X	:	-.122	-.316	-.250
CENTROID Y	:	.310	.283	.128
POA TO CENTROID in.	:	.333	.424	.281
MIN RADIUS	:	.208	.067	.234
MEAN RADIUS	:	.788	.650	.577
MAX RADIUS	:	1.757	1.342	.949
HORIZONTAL SPREAD	:	2.461	1.142	.888
VERTICAL SPREAD	:	2.323	2.323	1.588
EXTREME SPREAD	:	2.641	2.443	1.529
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08522132

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 1.793

VS = 2.463

GS = 2.580

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.700	.691
MINIMUM X	:	-.973	-.882	-.891
MAXIMUM Y	:	1.336	1.469	1.066
MINIMUM Y	:	-1.127	-.994	-.818
CENTROID X	:	.127	.036	.045
CENTROID Y	:	-.025	-.158	-.342
POA TO CENTROID in.	:	.130	.162	.345
MIN RADIUS	:	.448	.287	.205
MEAN RADIUS	:	.971	.888	.779
MAX RADIUS	:	1.451	1.471	1.183
HORIZONTAL SPREAD	:	1.793	1.582	1.582
VERTICAL SPREAD	:	2.463	2.463	1.876
EXTREME SPREAD	:	2.580	2.580	2.242
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08522132

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.324

VS= 3.022

GS= 3.575

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.240	1.165	.878
MINIMUM X	:	-1.084	-1.159	-1.013
MAXIMUM Y	:	.999	.775	.627
MINIMUM Y	:	-2.023	-1.032	-.935
CENTROID X	:	.180	.255	.109
CENTROID Y	:	-.104	.120	.023
POA TO CENTROID in.	:	.208	.282	.111
MIN RADIUS	:	.149	.174	.243
MEAN RADIUS	:	.860	.682	.599
MAX RADIUS	:	2.131	1.399	1.027
HORIZONTAL SPREAD	:	2.324	2.324	1.891
VERTICAL SPREAD	:	3.022	1.807	1.562
EXTREME SPREAD	:	3.575	2.546	1.927
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522132

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 1.905

VS= 2.251

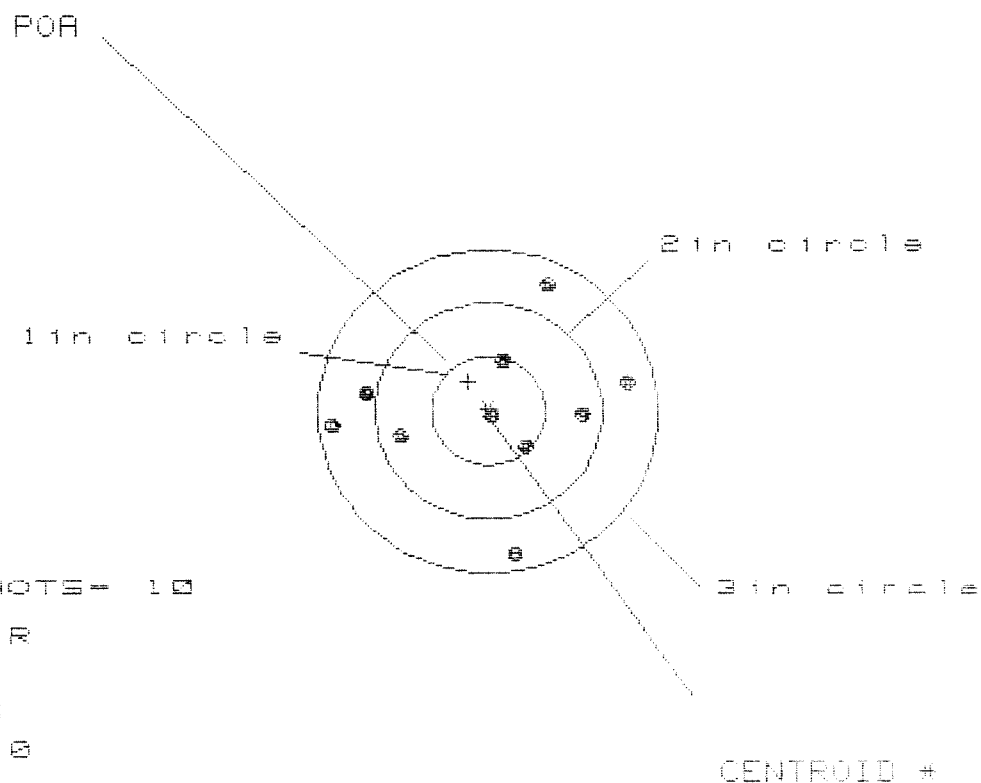
GS= 2.568

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.888	.986	.871
MINIMUM X	:	-1.017	-.919	-.866
MAXIMUM Y	:	1.171	1.051	1.118
MINIMUM Y	:	-1.080	-1.035	-.968
CENTROID X	:	.163	.065	.180
CENTROID Y	:	.254	.374	.307
POA TO CENTROID in.	:	.301	.379	.356
MIN RADIUS	:	.551	.573	.599
MEAN RADIUS	:	.962	.908	.880
MAX RADIUS	:	1.394	1.061	1.143
HORIZONTAL SPREAD	:	1.905	1.905	1.737
VERTICAL SPREAD	:	2.251	2.086	2.086
EXTREME SPREAD	:	2.568	2.088	2.088
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.5288

VS= 2.447

GS= 2.634

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.224	1.072	1.085
MINIMUM X	:	-1.374	-1.241	-1.228
MAXIMUM Y	:	1.150	1.131	.967
MINIMUM Y	:	-1.297	-1.316	-.490
CENTROID X	:	.175	.327	.314
CENTROID Y	:	-.271	-.252	-.088
POA TO CENTROID in.	:	.322	.413	.327
MIN RADIUS	:	.072	.107	.234
MEAN RADIUS	:	.896	.825	.766
MAX RADIUS	:	1.384	1.320	1.229
HORIZONTAL SPREAD	:	2.598	2.313	2.313
VERTICAL SPREAD	:	2.447	2.447	1.457
EXTREME SPREAD	:	2.634	2.463	2.314
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	