

C6523312

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

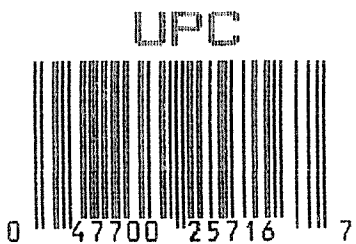
*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6523312
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6523312



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523312

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9/26/90	KR
	Magnaflux Bolt		9/26/90	KR
615	Rollmark Caliber		9/26/90	JS
617	Drill and Tap Sight Holes		9/28/90	LB
618	Polish Barrel RW		10/1/90	WB
620	Apply Coatings (Barrel Action)		10/5/90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/16/90	JS

op. #	BARBER - M24 0005923	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			10/16/90	WB
	G) Safety Off Force	4	4	4			10/16/90	WB
	H) Trigger Pull Test & Retainability						10/16/90	WB
	I) Firing Pin Indent	.020	.020	.020			10/16/90	WB
	J) Assemble Stock						10/22/90	RW
	K) Assemble Swivel Studs						2/18/90	JS
	L) Attach Front and Rear Sight Assemblies						10/22/90	RW
	M) Iron Sight Alignment						10/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/22/90	RW
	O) Attach Scope to Rifle						10/23/90	RW
	P) Detach & Attach Scope 20 Times						10/23/90	RW
640	Gallery Target & Test						10/25/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10/25/90	NF
655	Final Inspection							
	A) Headspace						2/18/90	JS
	B) Trigger Pull	209	216	215	210	221	2/18/90	JS
	C) Function						2/18/90	JS
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523312

DATE 10/16/90

TESTER JPD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.33	2.35	2.09	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.40	2.33	2.16	
PULL #3	2.34	2.36	2.37	2.15	
PULL #4	2.37	2.31	2.37	2.10	
PULL #5	2.41	2.38	2.35	2.21	
TOTAL	11.85	11.78	11.77		
AVG.	2.37	2.356	2.354		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.31		
PULL #2	3.14	3.39		
PULL #3	3.47	3.33		
PULL #4	3.50	3.31		
PULL #5	3.51	3.41		
TOTAL	17.05	16.75		
AVG.	3.41	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.35		4.34
PULL #2	4.18	4.41		4.42
PULL #3	4.32	4.20		4.32
PULL #4	4.25	4.34		4.40
PULL #5	4.27	4.41		4.44
TOTAL	21.26	21.71		21.92
AVG.	4.252	4.342		4.384

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523312
26 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0459674
1 TO	2	.339676
1 TO	3	.0754321
1 TO	4	.137525
1 TO	5	.260219

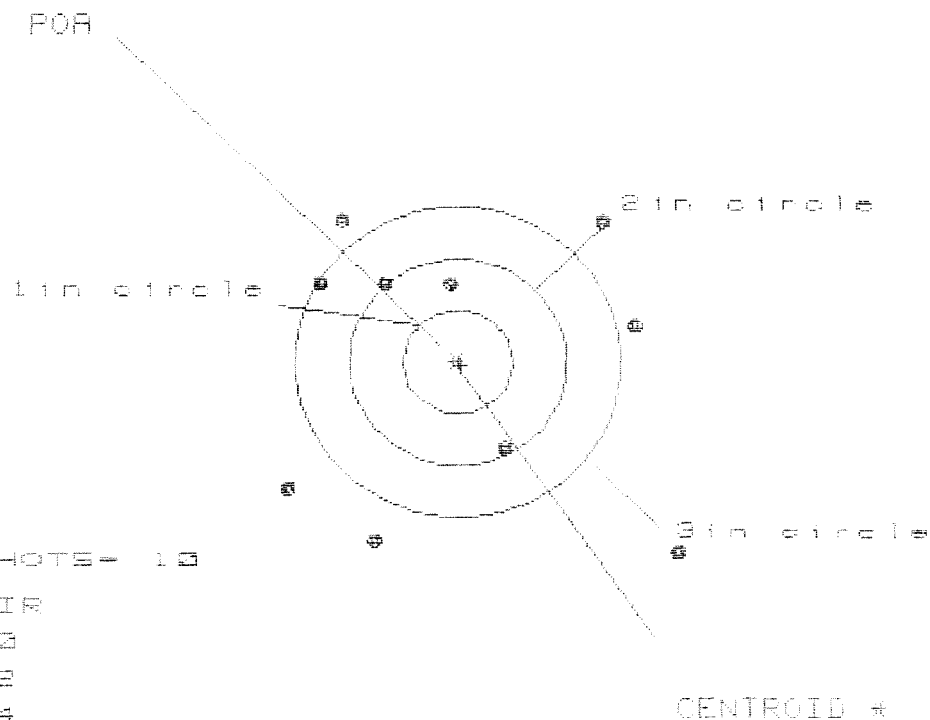
5.412 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0073
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0605
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0610999
THE AMR FOR THIS RIFLE IS: 1.144

28 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523312

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 4

HS= 3.626

VS= 3.205

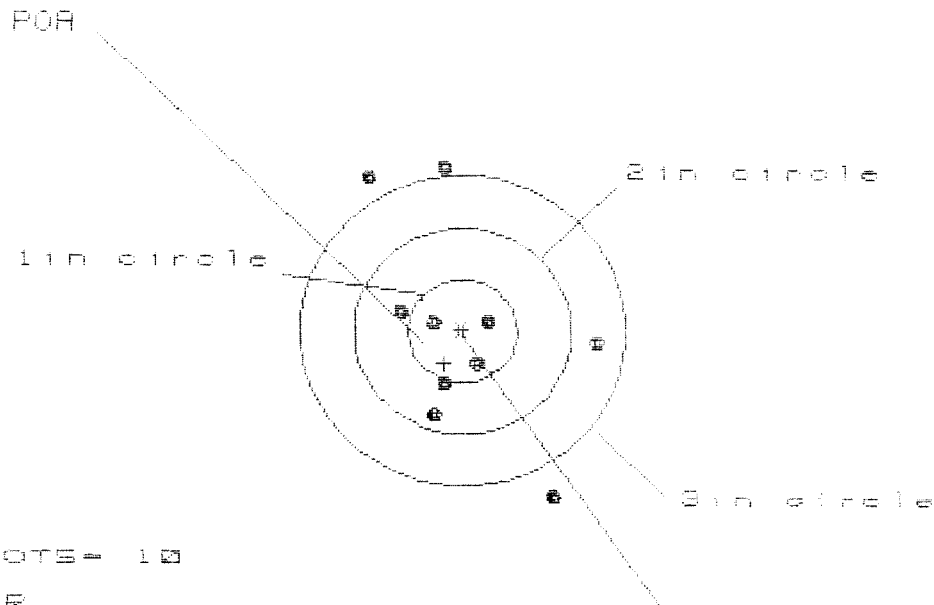
ES= 4.428

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.044	1.846	1.677
MINIMUM X	-1.582	-1.355	-1.181
MAXIMUM Y	1.402	1.201	1.021
MINIMUM Y	-1.803	-1.887	-2.067
CENTROID X	-0.032	-0.259	-0.090
CENTROID Y	0.093	0.234	0.414
POA TO CENTROID in.	0.046	0.349	0.424
MIN RADIUS	0.790	0.613	0.408
MEAN RADIUS	1.614	1.436	1.334
MAX RADIUS	2.726	1.981	2.183
HORIZONTAL SPREAD	3.626	3.201	2.858
VERTICAL SPREAD	3.205	3.088	3.088
EXTREME SPREAD	4.428	3.911	3.710
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	4		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS = 2.046

VS = 3.207

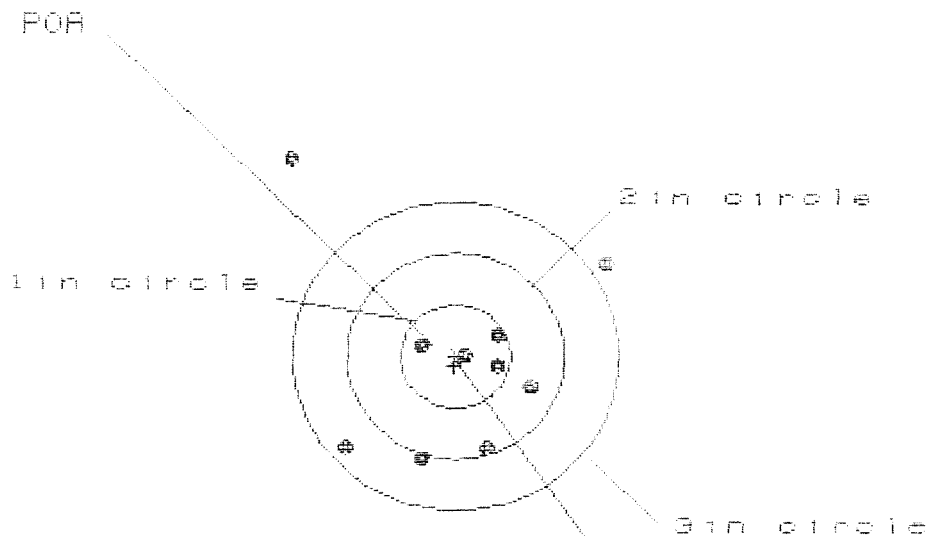
GS = 3.530

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.222	1.312	1.220
MINIMUM X	:	-.824	-.734	-.600
MAXIMUM Y	:	1.599	1.420	1.588
MINIMUM Y	:	-1.608	-1.020	-.852
CENTROID X	:	.166	.076	.168
CENTROID Y	:	.369	.488	.320
POA TO CENTROID in.	:	.351	.493	.361
MIN RADIUS	:	.236	.263	.233
MEAN RADIUS	:	.930	.852	.723
MAX RADIUS	:	1.800	1.530	1.600
HORIZONTAL SPREAD	:	2.046	2.046	1.820
VERTICAL SPREAD	:	3.207	2.440	2.440
EXTREME SPREAD	:	3.530	2.640	2.441
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HSI = 2.902

VS = 2.922

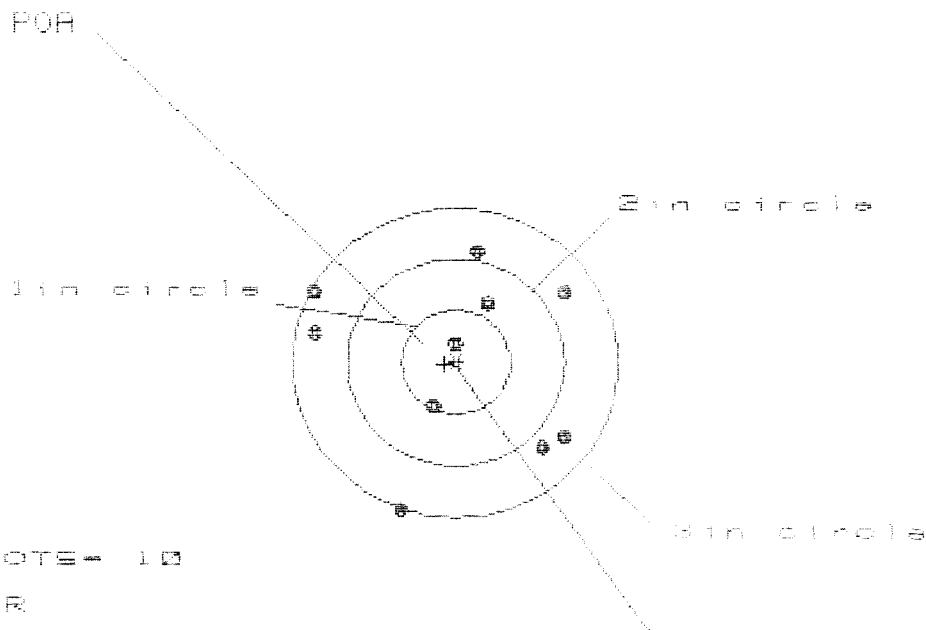
GS = 3.261

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.393
MINIMUM X	-1.509
MAXIMUM Y	1.908
MINIMUM Y	-1.014
CENTROID X	.015
CENTROID Y	.092
POA TO CENTROID in.	.093
MIN RADIUS	.088
MEAN RADIUS	.931
MAX RADIUS	2.432
HORIZONTAL SPREAD	2.902
VERTICAL SPREAD	2.922
EXTREME SPREAD	3.261
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HST = 2.345

VST = 2.509

GST = 2.754

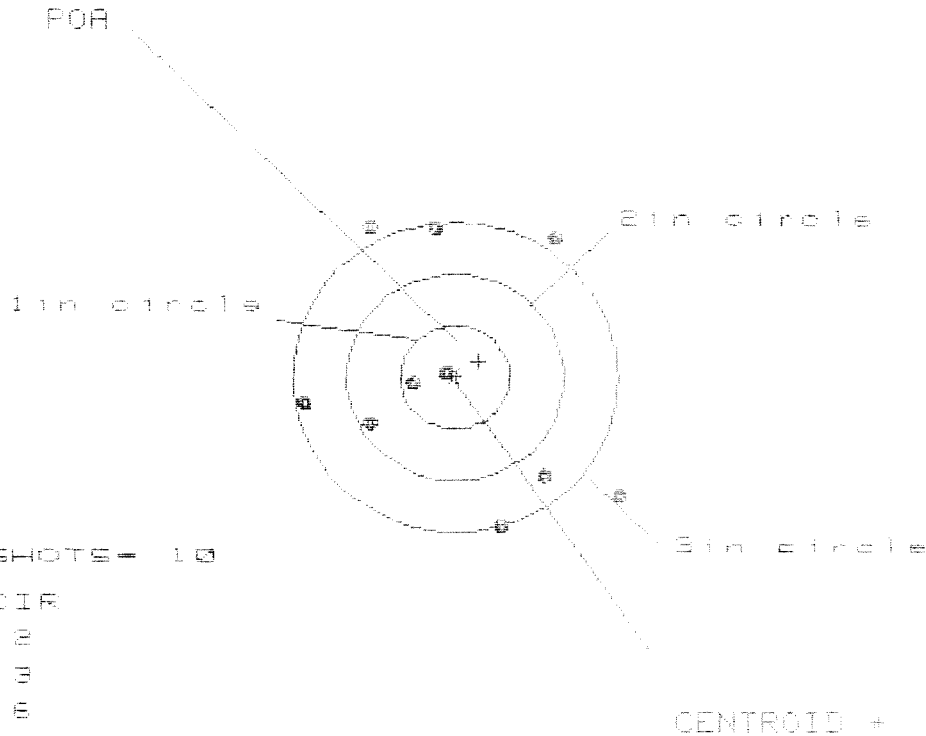
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.035	.982	.811
MINIMUM X	:	-1.310	-1.363	-1.504
MAXIMUM Y	:	1.067	.906	.977
MINIMUM Y	:	-1.442	-1.023	-.952
CENTROID X	:	.105	.158	.329
CENTROID Y	:	.021	.182	.111
POA TO CENTROID in.	:	.107	.241	.347
MIN RADIUS	:	.183	.078	.262
MEAN RADIUS	:	1.032	.953	.892
MAX RADIUS	:	1.520	1.475	1.512
HORIZONTAL SPREAD	:	2.345	2.345	2.315
VERTICAL SPREAD	:	2.509	1.929	1.929
EXTREME SPREAD	:	2.754	2.754	2.502
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 2.815

VS= 2.954

GS= 3.436

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.472	1.089	1.614
MINIMUM X	-1.343	-1.180	-1.256
MAXIMUM Y	1.489	1.365	1.454
MINIMUM Y	-1.465	-1.589	-1.418
CENTROID X	-.215	-.378	-.302
CENTROID Y	-.152	-.028	-.199
POR TO CENTROID in.	.263	.379	.362
MIN RADIUS	.146	.060	.141
MEAN RADIUS	1.211	1.106	1.053
MAX RADIUS	1.847	1.636	1.698
HORIZONTAL SPREAD	2.815	2.269	2.269
VERTICAL SPREAD	2.954	2.954	2.872
EXTREME SPREAD	3.436	3.177	2.932
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		