

C6498792

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

C 4A 70C

M-24.

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6498792

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	RB
600	Proof		8-21-90	RB
607	Check Headspace		8-21-90	RB
610	Dis-assemble Gun		8-21-90	RB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GB
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/28/90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/12/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 ont.	F) Safety On Force	4	4	4			9/12/90	WB
	G) Safety Off Force	2	2	2			9/12/90	WB
	H) Trigger Pull Test & Retainability						9/12/90	WB
	I) Firing Pin Indent	.0225	.0225	.0225			9/12/90	WB
	J) Assemble Stock						9/14/90	KH
	K) Assemble Swivel Studs						9/16/90	928
	L) Attach Front and Rear Sight Assemblies						9/12/90	KH
	M) Iron Sight Alignment						9/12/90	KH
	N) Detach Front & Rear Sights & place in numbered container						9/12/90	KH
	O) Attach Scope to Rifle						9/12/90	KH
	P) Detach & Attach Scope 20 Times						9/12/90	KH
640	Gallery Target & Test						9-15-90	DH
	A) Time						9-15-90	DH
	B) Malfunctions						9-15-90	DH
	C) Pierced Primers						9-15-90	DH
	D) Optical Clarity of Scope						9-15-90	DH
645	Inspect for Live Ammo						9-15-90	DH
655	Final Inspection						9/16/90	928
	A) Headspace						9-16-90	928
	B) Trigger Pull	2.16	2.37	2.49	2.58	2.53	9-16-90	928
	C) Function						9/16/90	928
660	Pack						9/19/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6498792

DATE 9/12/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.32	2.43	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.31	2.55	2.37	
PULL #3	2.55	2.36	2.60	2.49	
PULL #4	2.50	2.45	2.51	2.58	
PULL #5	2.45	2.40	2.52	2.53	
TOTAL	12.45	11.84	12.61	12.12	
AVG.	2.49	2.37	2.52	2.424	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.95		
PULL #2	3.06	3.00		
PULL #3	3.08	3.10		
PULL #4	3.04	3.16		
PULL #5	3.02	3.00		
TOTAL	15.20	15.21		
AVG.	3.04	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.05		4.12
PULL #2	4.16	4.11		4.25
PULL #3	4.07	4.20		4.29
PULL #4	4.13	4.22		4.23
PULL #5	4.22	4.25		4.27
TOTAL	21.70	20.82		21.16
AVG.	4.14	4.16		4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498792
15 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.113031
1 TO	2	.915645
1 TO	3	.688616
1 TO	4	1.08438
1 TO	5	.44561

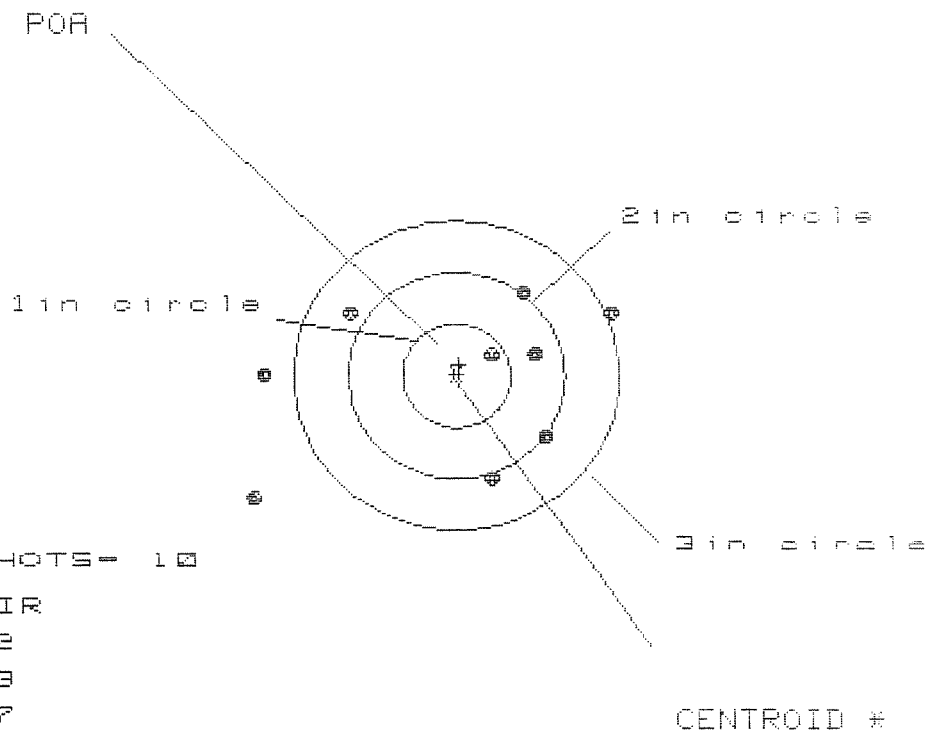
$\bar{x} = \frac{1}{n} \sum_{i=1}^n x_i$ $\bar{y} = \frac{1}{n} \sum_{i=1}^n y_i$ $r = \sqrt{(\bar{x} - x_i)^2 + (\bar{y} - y_i)^2}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5314
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1512
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .552492
THE AMR FOR THIS RIFLE IS: .9734

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498792

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

HS= 3.322

VS= 1.943

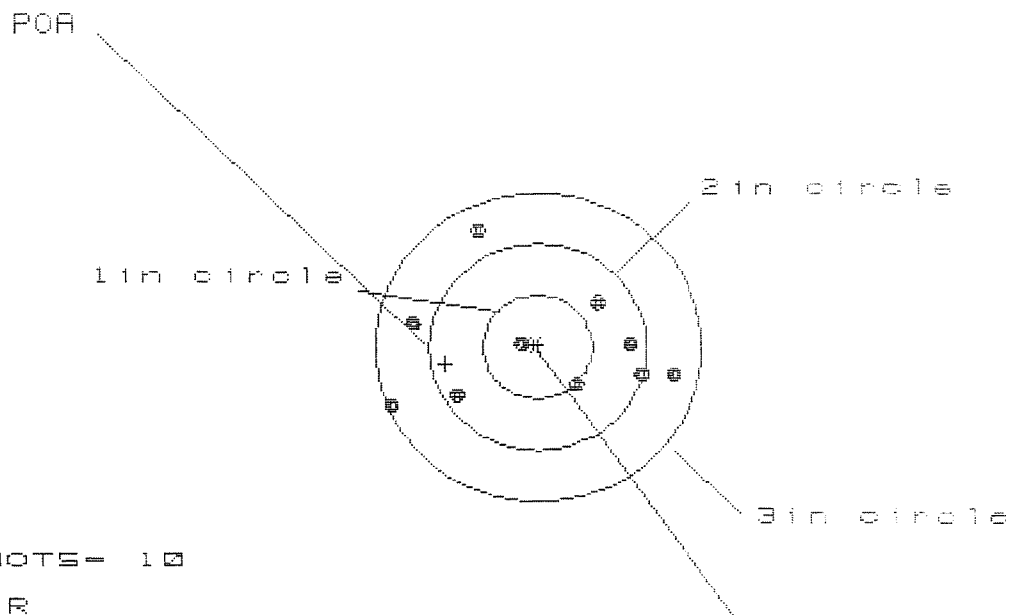
GS= 3.775

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.419	1.208	.964
MINIMUM X	-1.903	-1.953	-1.457
MAXIMUM Y	.792	.664	.652
MINIMUM Y	-1.151	-1.092	-1.104
CENTROID X	-.026	.185	.429
CENTROID Y	-.110	.018	.030
POA TO CENTROID in.	.113	.186	.430
MIN RADIUS	.351	.105	.144
MEAN RADIUS	1.130	.913	.728
MAX RADIUS	2.224	1.956	1.525
HORIZONTAL SPREAD	3.322	3.161	2.421
VERTICAL SPREAD	1.943	1.756	1.756
EXTREME SPREAD	3.775	3.220	2.422
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

15 Sep 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.575

VS= 1.679

GS= 2.595

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	1.051	.968
MINIMUM X	:	-1.373	-1.323	-1.406
MAXIMUM Y	:	1.134	1.073	.477
MINIMUM Y	:	-.545	-.501	-.366
CENTROID X	:	.848	1.000	1.083
CENTROID Y	:	.163	.224	.089
POA TO CENTROID in.	:	.863	1.025	1.087
MIN RADIUS	:	.110	.268	.310
MEAN RADIUS	:	.912	.833	.753
MAX RADIUS	:	1.477	1.337	1.444
HORIZONTAL SPREAD	:	2.575	2.374	2.374
VERTICAL SPREAD	:	1.679	1.574	.844
EXTREME SPREAD	:	2.595	2.424	2.424
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.575

VS = 2.060

GS = 2.594

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.842	.675
MINIMUM X	:	-1.560	-1.334	-.712
MAXIMUM Y	:	1.057	1.078	1.167
MINIMUM Y	:	-1.003	-.982	-.893
CENTROID X	:	.610	.783	.950
CENTROID Y	:	.154	.133	.044
POA TO CENTROID in.	:	.629	.794	.951
MIN RADIUS	:	.354	.305	.186
MEAN RADIUS	:	.923	.811	.678
MAX RADIUS	:	1.572	1.512	1.179
HORIZONTAL SPREAD	:	2.575	2.176	1.387
VERTICAL SPREAD	:	2.060	2.060	2.060
EXTREME SPREAD	:	2.594	2.320	2.163
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

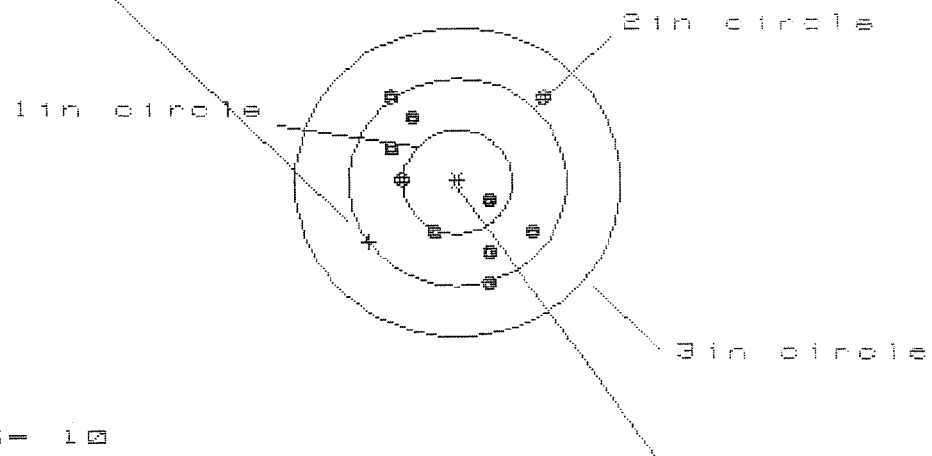
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.313

VS= 1.820

GS= 2.007

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.737	.771	.710
MINIMUM X	:	-.576	-.494	-.555
MAXIMUM Y	:	.866	.945	.872
MINIMUM Y	:	-.954	-.857	-.739
CENTROID X	:	.813	.731	.792
CENTROID Y	:	.577	.480	.362
POA TO CENTROID in.	:	.997	.875	.871
MIN RADIUS	:	.353	.386	.304
MEAN RADIUS	:	.755	.696	.631
MAX RADIUS	:	1.137	1.063	.952
HORIZONTAL SPREAD	:	1.313	1.265	1.265
VERTICAL SPREAD	:	1.820	1.802	1.611
EXTREME SPREAD	:	2.007	2.007	1.764
NUMBER IN ONE INCH CIRCLE =	:	1		
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

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.927

VS= 2.245

GS= 3.104

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	1.470	1.288
MINIMUM X	:	-1.599	-1.457	-1.259
MAXIMUM Y	:	1.117	.865	.940
MINIMUM Y	:	-1.128	-1.004	-.929
CENTROID X	:	.412	.270	.453
CENTROID Y	:	-.028	-.152	-.227
POA TO CENTROID in.	:	.413	.310	.506
MIN RADIUS	:	.345	.165	.259
MEAN RADIUS	:	1.147	1.059	.985
MAX RADIUS	:	1.696	1.658	1.538
HORIZONTAL SPREAD	:	2.927	2.927	2.546
VERTICAL SPREAD	:	2.245	1.869	1.869
EXTREME SPREAD	:	3.104	2.932	2.893
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

Remington[®]


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

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

MODEL 700TM M24	SERIAL NO. C6498792
	ORDER NO. 5716

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

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5716 C6498792

UPC


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