

06594501

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

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

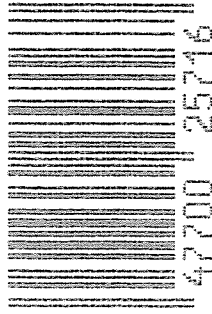
MODEL 700TM M24

SERIAL NO.
C6594501

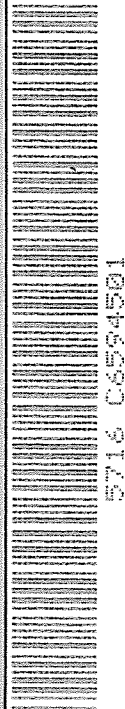
ORDER NO.
5716

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

UPC



0 4700 25716



5716 C6594501

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594501

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/20/90	K.S.
600	Proof		12/20/90	K.S.
607	Check Headspace		12/20/90	K.S.
610	Dis-assemble Gun		12/20/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10 91		LB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/23/91	KS
	C) Inspect Ejector Hole for Chamfer		1/23/91	KS
	D) Oil Firing Pin Ass'y		1/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1/24/91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			1/24/91	WLB
	G) Safety Off Force	2	2	2			1/24/91	WLB
	H) Trigger Pull Test & Retainability						1/24/91	JH
	I) Firing Pin Indent	.0225	.0225	.0225			1/24/91	WLB
	J) Assemble Stock						1/25/91	KS
	K) Assemble Swivel Studs						2-8-91	DH
	L) Attach Front and Rear Sight Assemblies						1/25/91	KS
	M) Iron Sight Alignment						1/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/25/91	KS
	O) Attach Scope to Rifle						1/25/91	KS
	P) Detach & Attach Scope 20 Times						1/25/91	KS
640	Gallery Target & Test						1-28-91	DH
	A) Time						1-28-91	DH
	B) Malfunctions						1-28-91	DH
	C) Pierced Primers						1-28-91	DH
	D) Optical Clarity of Scope						1-28-91	DH
645	Inspect for Live Ammo						1-28-91	DH
655	Final Inspection							
	A) Headspace						2-8-91	DH
	B) Trigger Pull	2.48	2.30	2.51	2.47	2.48	2-1-91	JH
	C) Function						2-8-91	-DH
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 C6594501

DATE 1-24-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.37	2.43	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.13	2.22	2.30	
PULL #3	2.30	2.22	2.40	2.51	
PULL #4	2.39	2.25	2.38	2.47	
PULL #5	2.25	2.20	2.42	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.47		
PULL #2	3.29	3.43		
PULL #3	3.25	3.36		
PULL #4	3.35	3.50		
PULL #5	3.17	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.46		4.24
PULL #2	4.20	4.36		4.42
PULL #3	4.22	4.42		4.42
PULL #4	4.36	4.42		4.44
PULL #5	4.39	4.39		4.19
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594501
28 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.256704
1 TO	2	.149164
1 TO	3	.218002
1 TO	4	.244233
1 TO	5	.269258

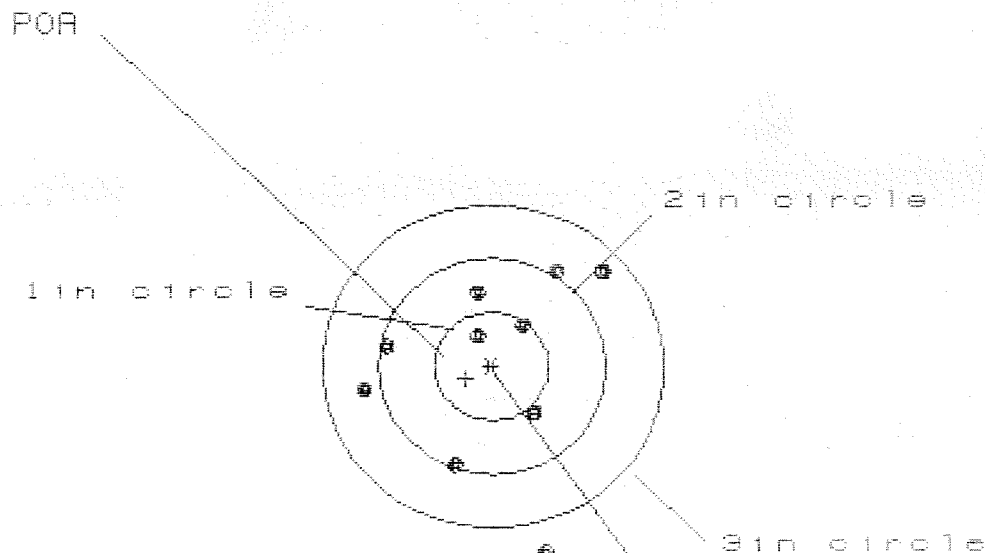
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .204
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0388
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .207657
THE AMR FOR THIS RIFLE IS: .9198

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594501

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.083

VS= 2.659

GS= 2.716

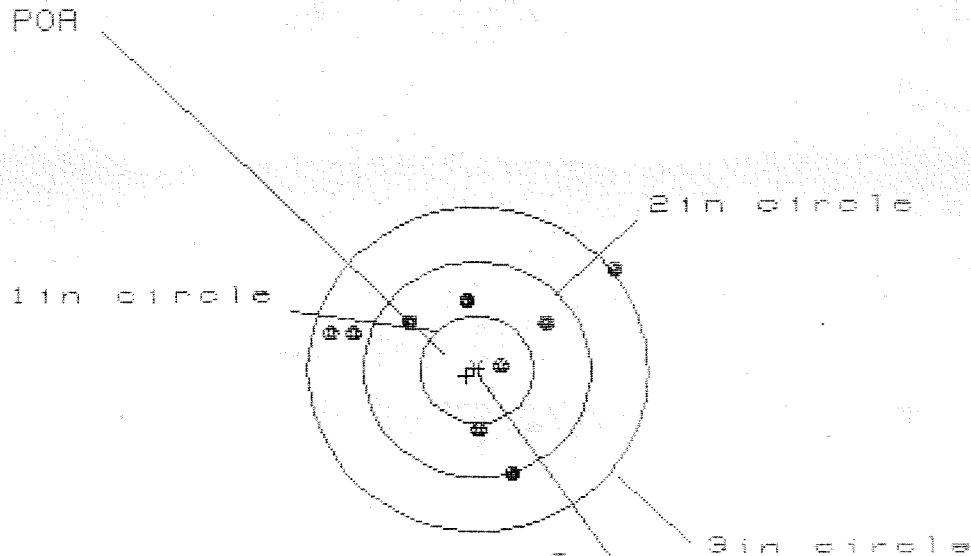
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	1.023	.744
MINIMUM X	:	-1.107	-1.060	-.932
MAXIMUM Y	:	.900	.705	.777
MINIMUM Y	:	-1.759	-1.086	-.998
CENTROID X	:	.229	.182	.054
CENTROID Y	:	.116	.311	.223
POA TO CENTROID in.	:	.256	.361	.230
MIN RADIUS	:	.306	.106	.209
MEAN RADIUS	:	.918	.773	.728
MAX RADIUS	:	1.809	1.242	1.076
HORIZONTAL SPREAD	:	2.083	2.083	1.676
VERTICAL SPREAD	:	2.659	1.791	1.775
EXTREME SPREAD	:	2.716	2.364	2.006
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594501

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.502

VS= 2.683

GS= 2.904

CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	1.269	.826
MINIMUM X	:	-1.314	-1.233	-1.074
MAXIMUM Y	:	.968	.778	.502
MINIMUM Y	:	-1.715	-1.155	-1.058
CENTROID X	:	.092	.011	-.148
CENTROID Y	:	.057	.247	.150
POA TO CENTROID in.	:	.108	.248	.211
MIN RADIUS	:	.218	.345	.463
MEAN RADIUS	:	.976	.863	.786
MAX RADIUS	:	1.864	1.489	1.194
HORIZONTAL SPREAD	:	2.502	2.502	1.900
VERTICAL SPREAD	:	2.683	1.933	1.560
EXTREME SPREAD	:	2.904	2.578	2.090
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594501

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.578

VS= 2.042

GS= 2.095

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.857	.754
MINIMUM X	:	-.847	-.821	-.548
MAXIMUM Y	:	.773	.631	.668
MINIMUM Y	:	-1.270	-.616	-.579
CENTROID X	:	.230	.204	.307
CENTROID Y	:	-.102	.039	.002
POA TO CENTROID in.	:	.252	.208	.307
MIN RADIUS	:	.015	.152	.144
MEAN RADIUS	:	.653	.583	.540
MAX RADIUS	:	1.291	.871	.756
HORIZONTAL SPREAD	:	1.678	1.678	1.294
VERTICAL SPREAD	:	2.042	1.247	1.247
EXTREME SPREAD	:	2.095	1.719	1.311
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Jan 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.462

VS= 2.709

GS= 3.463

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.735	1.543	.943
MINIMUM X	:	-1.727	-1.400	-1.207
MAXIMUM Y	:	1.330	1.261	1.183
MINIMUM Y	:	-1.379	-1.448	-1.526
CENTROID X	:	.170	.362	.169
CENTROID Y	:	-.121	-.052	.026
POA TO CENTROID in.	:	.208	.365	.171
MIN RADIUS	:	.437	.287	.334
MEAN RADIUS	:	1.142	1.062	.952
MAX RADIUS	:	1.836	1.665	1.631
HORIZONTAL SPREAD	:	3.462	2.943	2.150
VERTICAL SPREAD	:	2.709	2.709	2.709
EXTREME SPREAD	:	3.463	2.948	2.710
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594501DATE 2-17-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.51	2.52	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.45	2.75	
PULL #3	2.33	2.49	2.78	
PULL #4	2.54	2.41	2.66	
PULL #5	2.63	2.51	2.63	
TOTAL	12.62	12.38	13.52	
AVG.	2.52	2.47	2.70	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.27	3.23	
PULL #2	3.30	3.23	
PULL #3	3.13	3.22	
PULL #4	3.28	3.24	
PULL #5	3.20	3.19	
TOTAL	16.18	16.11	
AVG.	3.23	3.22	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.06		4.35
PULL #2	4.00	4.10		4.27
PULL #3	4.03	4.19		4.36
PULL #4	3.95	4.09		4.26
PULL #5	4.00	4.07		4.26
TOTAL	20.14	20.51		21.50
AVG.	4.02	4.10		4.30

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594501

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	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			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 ³ / ₄	5 ³ / ₄			2/23/96	WB
	G) Safety Off Force	2 ¹ / ₂	2 ³ / ₄	2 ³ / ₄			2/23/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.55	2.67	2.66	2.78	2.62	2/23/96	WB
	C) Function							
660	Pack							