

06594587

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.
C6594587

ORDER NO.
5716

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

20

UPC

0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594587

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		1/8/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/29/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/29/91	KS
	C) Inspect Ejector Hole for Chamfer		1/29/91	KS
	D) Oil Firing Pin Ass'y		1/29/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	9/1

op. #	OP. NAME	READINGS					DATE	INIT
525 cont.	F) Safety On Force	4	4	4			1/30/91	WB
	G) Safety Off Force	3	3	3			1/30/91	WB
	H) Trigger Pull Test & Retainability						1/30/91	JB
	I) Firing Pin Indent	.0205	.021	.0205			1/30/91	WB
	J) Assemble Stock						1/30/91	KS
	K) Assemble Swivel Studs					2-4-91	1/30/91	KS
	L) Attach Front and Rear Sight Assemblies						1/30/91	KS
	M) Iron Sight Alignment						1/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/30/91	KS
	O) Attach Scope to Rifle						1/30/91	KS
	P) Detach & Attach Scope 20 Times						1/30/91	KS
640	Gallery Target & Test						1-31-91	DH
	A) Time						1-31-91	DH
	B) Malfunctions						1-31-91	DH
	C) Pierced Primers						1-31-91	DH
	D) Optical Clarity of Scope						1-31-91	DH
645	Inspect for Live Ammo						1-31-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.31	2.17	2.22	2.23	2.22	2-4-91	JB
	C) Function						2-4-91	AC
660	Pack						3-18-91	AC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6594587DATE 1-30-91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.47	2.24	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.27	2.20	2.17	
PULL #3	2.44	2.53	2.15	2.22	
PULL #4	2.16	2.49	2.22	2.23	
PULL #5	2.50	2.34	2.20	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.34		
PULL #2	3.26	3.11		
PULL #3	3.25	3.26		
PULL #4	3.23	3.34		
PULL #5	3.24	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.50		4.35
PULL #2	4.22	4.37		4.13
PULL #3	4.28	4.47		4.15
PULL #4	4.43	4.32		4.24
PULL #5	4.32	4.48		4.14
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594587
31 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.180314
1 TO	2	.457739
1 TO	3	.137321
1 TO	4	.255885
1 TO	5	.0857263

#2 <----POA

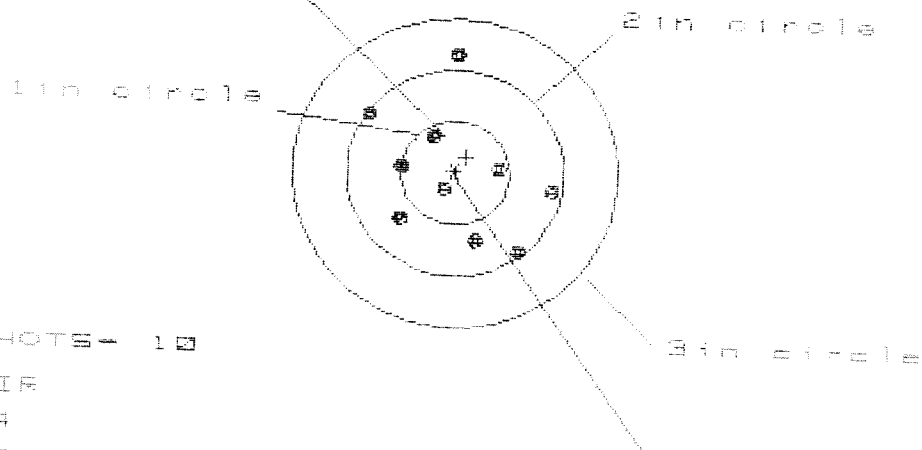
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0178
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0376
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0416005
THE AMR FOR THIS RIFLE IS: .8064

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C63945B7

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

1 in = 1.636

2 in = 1.860

3 in = 1.946

CENTROID *

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.881

.881

.787

MINIMUM X

:

-.755

-.755

-.562

MAXIMUM Y

:

1.140

.679

.541

MINIMUM Y

:

-.728

-.593

-.588

CENTROID X

:

-.897

-.897

-.863

CENTROID Y

:

-.152

-.279

-.364

FOR TO CENTROID in:

:

.181

.295

.364

MIN RADIUS

:

.229

.149

.234

MEAN RADIUS

:

.666

.600

.549

MAX RADIUS

:

1.140

1.015

.788

HORIZONTAL SPREAD

:

1.636

1.636

1.339

VERTICAL SPREAD

:

1.860

1.272

1.049

EXTREME SPREAD

:

1.946

1.837

1.366

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

9

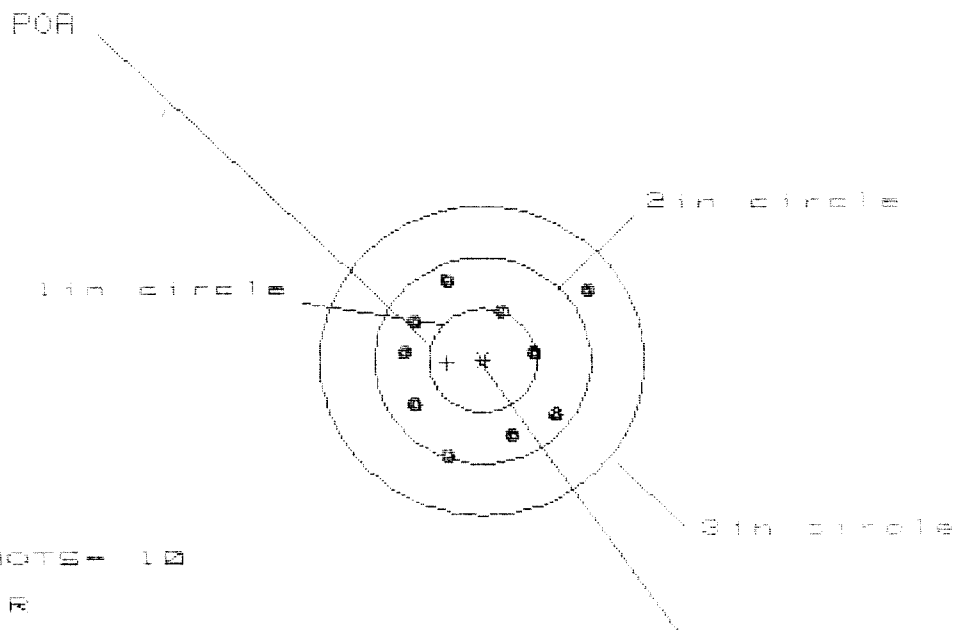
NUMBER IN THREE INCH CIRCLE =

10

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594587

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 9

3 in = 10

HS= 1.719

VS= 1.729

GS= 2.062

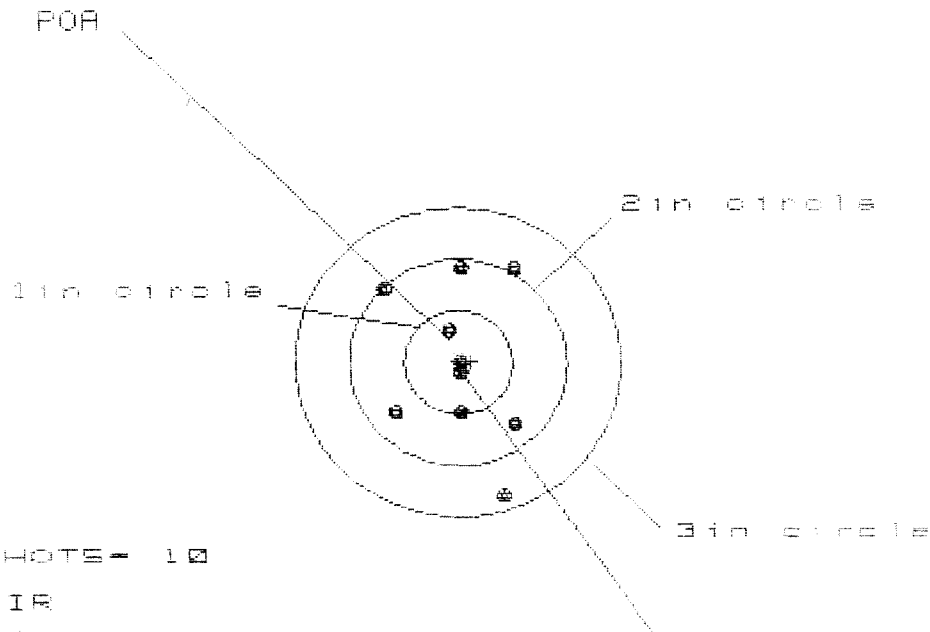
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.992
MINIMUM X	:	-.727
MAXIMUM Y	:	.826
MINIMUM Y	:	-.903
CENTROID X	:	.328
CENTROID Y	:	.018
POA TO CENTROID in.	:	.329
MIN RADIUS	:	.501
MEAN RADIUS	:	.792
MAX RADIUS	:	1.181
HORIZONTAL SPREAD	:	1.719
VERTICAL SPREAD	:	1.729
EXTREME SPREAD	:	2.062
NUMBER IN ONE INCH CIRCLE	=	0
NUMBER IN TWO INCH CIRCLE	=	9
NUMBER IN THREE INCH CIRCLE	=	10

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 1.129

VS = 2.191

GS = 2.257

CENTROID #

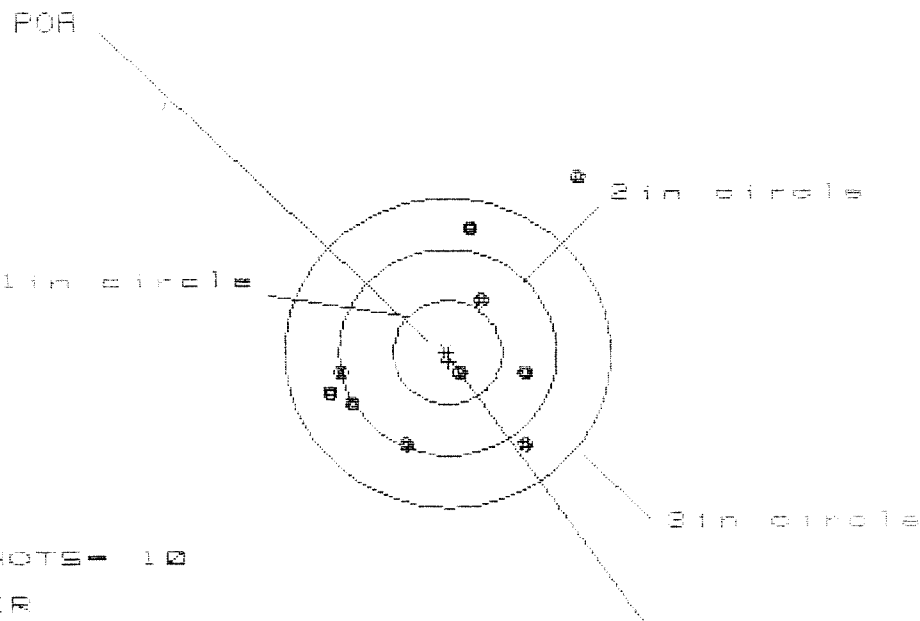
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.483
MINIMUM X	-.646
MAXIMUM Y	.945
MINIMUM Y	-1.246
CENTROID X	-.116
CENTROID Y	-.016
POA TO CENTROID in.	.117
MIN RADIUS	.029
MEAN RADIUS	.668
MAX RADIUS	1.312
HORIZONTAL SPREAD	1.129
VERTICAL SPREAD	2.191
EXTREME SPREAD	2.257
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

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FILE:/PATTERNING/CENTERFIRE_PATT/06594567

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 3.222

VS = 3.599

GS = 3.057

CENTROID #

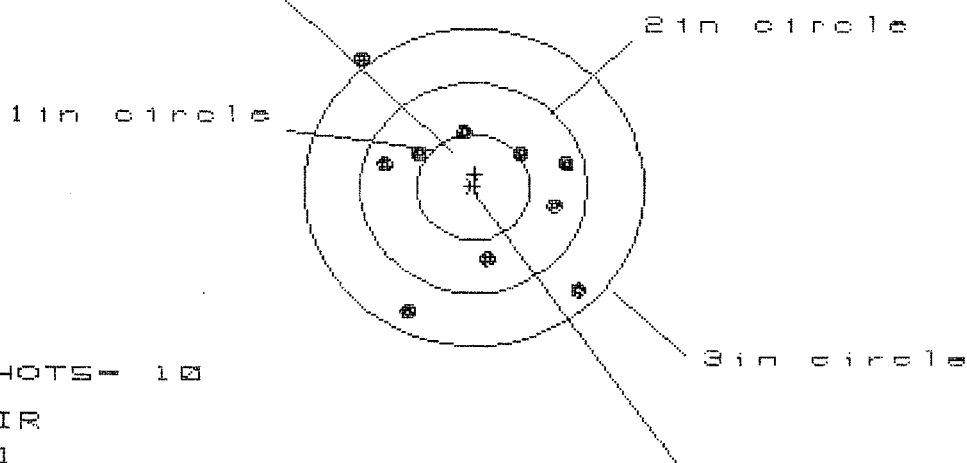
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.181	.888	.932
MINIMUM X	:	-1.041	-.910	-.866
MAXIMUM Y	:	1.674	1.385	.884
MINIMUM Y	:	-.925	-.739	-.566
CENTROID X	:	-.011	-.142	-.186
CENTROID Y	:	.089	-.097	-.270
POA TO CENTROID in.	:	.090	.172	.328
MIN RADIUS	:	.217	.210	.298
MEAN RADIUS	:	1.013	.867	.780
MAX RADIUS	:	2.049	1.429	1.025
HORIZONTAL SPREAD	:	2.222	1.798	1.798
VERTICAL SPREAD	:	2.599	2.124	1.450
EXTREME SPREAD	:	3.057	2.205	1.809
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6594587

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.908

VS= 2.404

GS= 2.958

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	.800	.816
MINIMUM X	:	-.998	-.893	-.794
MAXIMUM Y	:	1.266	.682	.575
MINIMUM Y	:	-1.138	-.997	-1.104
CENTROID X	:	-.015	.095	-.004
CENTROID Y	:	-.127	-.268	-.161
POA TO CENTROID in.	:	.128	.284	.161
MIN RADIUS	:	.490	.525	.504
MEAN RADIUS	:	.893	.809	.749
MAX RADIUS	:	1.612	1.203	1.243
HORIZONTAL SPREAD	:	1.908	1.693	1.609
VERTICAL SPREAD	:	2.404	1.679	1.679
EXTREME SPREAD	:	2.958	2.099	1.955
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	