

C6587524

MODEL 700TM M24

Model **SWS** TM

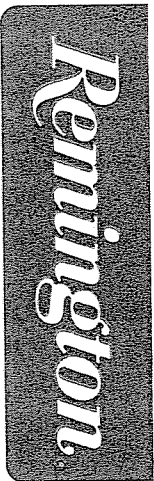
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



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

Remington®

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

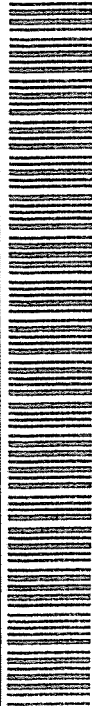
DUPONT

MODEL 700™ M24

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

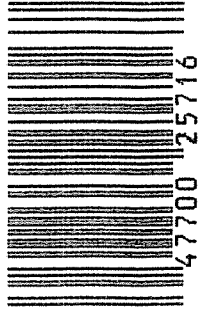
SERIAL NO.
C6587524

ORDER NO.
5715



5715 C6587524

LIPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587524

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/19/90	KA
600	Proof		10/19/90	KA
607	Check Headspace		10/19/90	KA
610	Dis-assemble Gun		10/19/90	KA
612	Magnaflux Barrel Action		10/22/90	KE
	Magnaflux Bolt		10/22/90	KE
615	Rollmark Caliber		10/22/90	LS
617	Drill and Tap Sight Holes		10/23/90	FB
618	Polish Barrel RB		10/24/90	WB
620	Apply Coatings (Barrel Action)		11-6-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11-6-90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	KS
	C) Inspect Ejector Hole for Chamfer		11-6-90	KS
	D) Oil Firing Pin Ass'y		11-6-90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/12/90	GS

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4.0	4. 1/2	11-7-90	KS
	G) Safety Off Force	2 1/4	2.0	2. 1/4	11-7-90	KS
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.021	.020	.021	11-7-90	KS
	J) Assemble Stock				11/12/90	KS
	K) Assemble Swivel Studs				11/19/90	JS
	L) Attach Front and Rear Sight Assemblies				11/12/90	KS
	M) Iron Sight Alignment				11/12/90	KS
	N) Detach Front & Rear Sights & place in numbered container				11/12/90	KS
	O) Attach Scope to Rifle				11/12/90	KS
	P) Detach & Attach Scope 20 Times				11/12/90	KS
640	Gallery Target & Test				11-13-90	AC
	A) Time				11-13-90	AC
	B) Malfunctions				11-13-90	AC
	C) Pierced Primers				11-13-90	AC
	D) Optical Clarity of Scope				11-13-90	AC
645	Inspect for Live Ammo				11-13-90	AC
655	Final Inspection					
	A) Headspace				11/19/90	JS
	B) Trigger Pull	286	288	286	11/19/90	JS
	C) Function				11/19/90	JS
660	Pack				12-17-90	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6587524
DATE 12/20/90
TESTER QZ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	274	257	254	286	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	278	258	268	288	
PULL #3	279	253	271	286	
PULL #4	280	262	263	279	
PULL #5	279	261	262	298	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	297	287		
PULL #2	302	278		
PULL #3	300	304		
PULL #4	300	298		
PULL #5	304	294		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	413	409		416
PULL #2	408	397		422
PULL #3	408	409		414
PULL #4	411	407		407
PULL #5	405	412		418
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587524
13 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.350657
1 TO	2	.822002
1 TO	3	.66464
1 TO	4	.100568
1 TO	5	.341211

3⁴ 2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2122
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0872
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .229418
THE AMR FOR THIS RIFLE IS: .9962

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587524

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 3.050

VS= 2.619

GS= 3.386

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.026	.520	.514
MINIMUM X	-1.024	-.799	-.805
MAXIMUM Y	1.339	1.444	.883
MINIMUM Y	-1.280	-1.175	-.994
CENTROID X	.296	.071	.077
CENTROID Y	.188	.083	-.098
POA TO CENTROID in.	.350	.109	.124
MIN RADIUS	.233	.031	.160
MEAN RADIUS	.907	.702	.619
MAX RADIUS	2.236	1.445	1.055
HORIZONTAL SPREAD	3.050	1.319	1.319
VERTICAL SPREAD	2.619	2.619	1.877
EXTREME SPREAD	3.386	2.651	1.877
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

13 Nov 1988

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.193

VS= 2.817

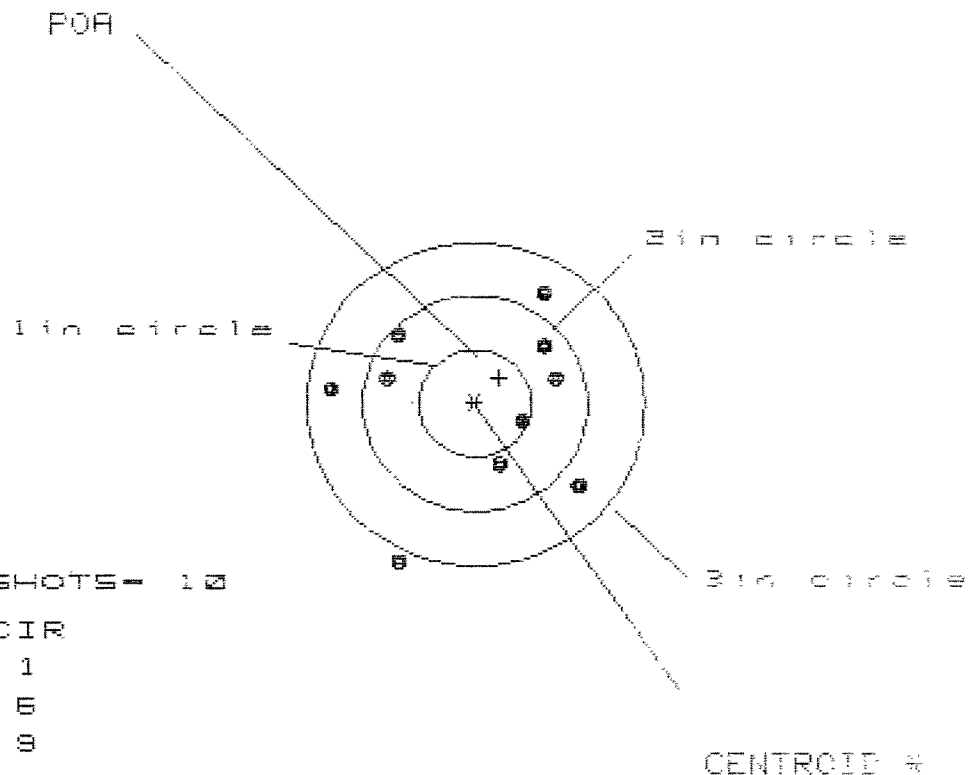
GS= 3.125

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.160	1.070	1.127
MINIMUM X	:	-1.033	-1.123	-1.066
MAXIMUM Y	:	1.368	1.381	1.219
MINIMUM Y	:	-1.449	-1.297	-1.108
CENTROID X	:	.658	.748	.691
CENTROID Y	:	-.550	-.702	-.540
POA TO CENTROID in.	:	.858	1.026	.877
MIN RADIUS	:	.705	.602	.575
MEAN RADIUS	:	1.145	1.086	1.039
MAX RADIUS	:	1.589	1.401	1.442
HORIZONTAL SPREAD	:	2.193	2.193	2.190
VERTICAL SPREAD	:	2.817	2.678	2.327
EXTREME SPREAD	:	3.125	2.765	2.488
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

13 May 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.199

VS= 2.451

GS= 2.776

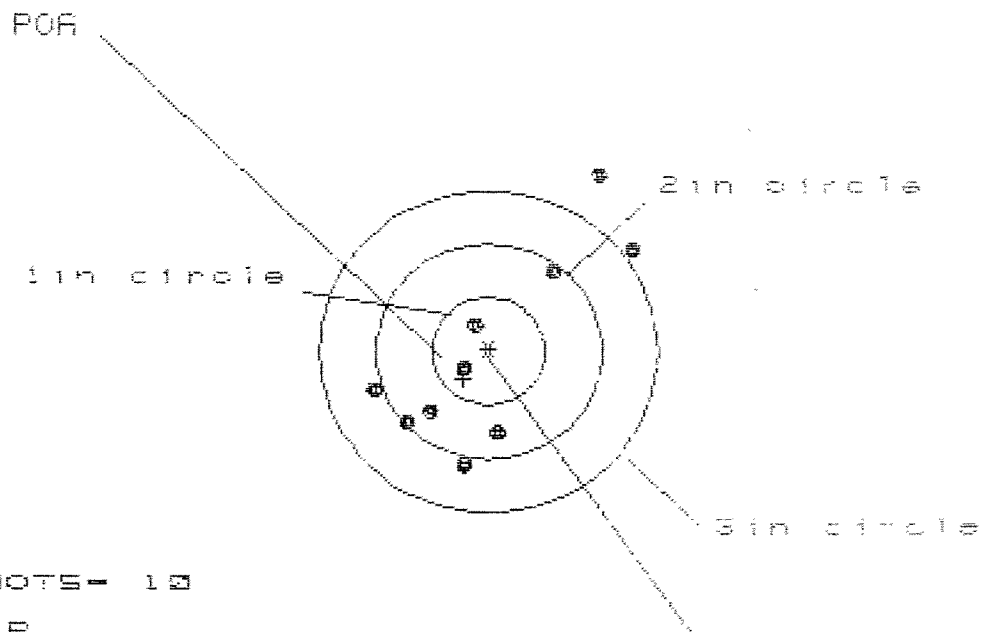
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.932	.854	.685
MINIMUM X	:	-1.267	-1.345	-1.042
MAXIMUM Y	:	1.031	.873	.873
MINIMUM Y	:	-1.420	-.873	-.873
CENTROID X	:	-.215	-.137	.031
CENTROID Y	:	-.237	-.079	-.079
POA TO CENTROID in.	:	.320	.158	.085
MIN RADIUS	:	.455	.473	.369
MEAN RADIUS	:	.970	.883	.791
MAX RADIUS	:	1.586	1.345	1.110
HORIZONTAL SPREAD	:	2.199	2.199	1.728
VERTICAL SPREAD	:	2.451	1.746	1.746
EXTREME SPREAD	:	2.776	2.364	2.148
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

13 Nov 1990

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.281

VS= 2.721

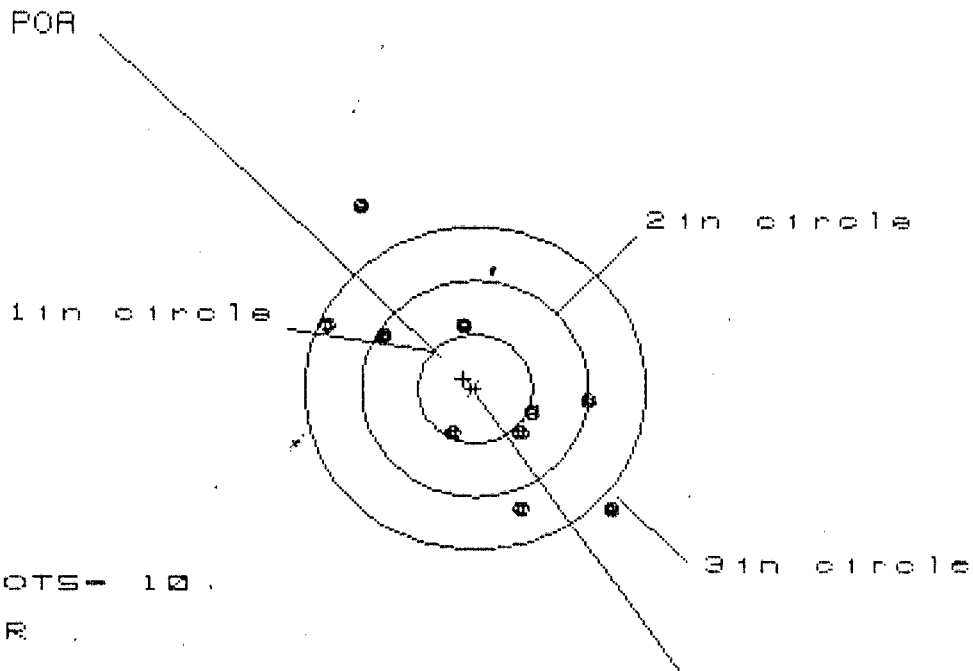
GS= 2.941

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.242	1.347	.846
MINIMUM X	:	-1.039	-.934	-.766
MAXIMUM Y	:	1.624	1.125	1.039
MINIMUM Y	:	-1.097	-.917	-.775
CENTROID X	:	.221	.116	-.052
CENTROID Y	:	.255	.075	-.066
POA TO CENTROID in.	:	.337	.138	.094
MIN RADIUS	:	.232	.148	.180
MEAN RADIUS	:	.953	.797	.629
MAX RADIUS	:	1.878	1.755	1.340
HORIZONTAL SPREAD	:	2.281	2.281	1.612
VEPTICAL SPREAD	:	2.721	2.042	1.815
EXTREME SPREAD	:	2.941	2.621	1.962
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10 .

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.445

VS= 2.754

GS= 3.482

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.081	.989
MINIMUM X	:	-1.259	-1.364	-1.229
MAXIMUM Y	:	1.684	.747	.637
MINIMUM Y	:	-1.070	-.883	-.993
CENTROID X	:	.101	.206	.071
CENTROID Y	:	-.092	-.279	-.169
POA TO CENTROID in.	:	.136	.347	.183
MIN RADIUS	:	.451	.363	.370
MEAN RADIUS	:	1.006	.864	.810
MAX RADIUS	:	1.934	1.555	1.384
HORIZONTAL SPREAD	:	2.445	2.445	2.218
VERTICAL SPREAD	:	2.754	1.630	1.630
EXTREME SPREAD	:	3.482	2.936	2.323
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	