

C6587599

MODEL 700TH M24

Model **SWS** TH

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.

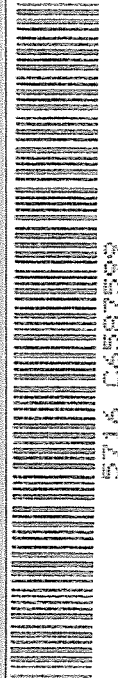
DUPONT

MODEL 700™ M24

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

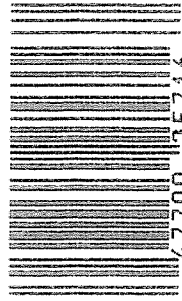
SERIAL NO. C6587599

ORDER NO. 5716



5716 C6587599

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

NEW BBLGUN SERIAL # C 6587599

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	GL
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/30/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/30/90	KS
	C) Inspect Ejector Hole for Chamfer		11/30/90	K
	D) Oil Firing Pin Ass'y		11/30/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/90	DL

op. #	OP. NAME BARBER - M24 0023486	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2	12/4/90	WB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	12/4/90	WB		
	H) Trigger Pull Test & Retainability				12-3-90	JL		
	I) Firing Pin Indent	.023	.023	.023	12/4/90	WB		
	J) Assemble Stock				12/8/90	KS		
	K) Assemble Swivel Studs				12-12-90	JS		
	L) Attach Front and Rear Sight Assemblies				12/8/90	KS		
	M) Iron Sight Alignment				12/8/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				12/8/90	KS		
	O) Attach Scope to Rifle				12/8/90	KS		
	P) Detach & Attach Scope 20 Times				12/8/90	KS		
640	Gallery Target & Test				12/10/90	KJ		
	A) Time				"	KJ		
	B) Malfunctions				"	KJ		
	C) Pierced Primers				"	KJ		
	D) Optical Clarity of Scope				"	KJ		
645	Inspect for Live Ammo				12/10/90	JS		
655	Final Inspection							
	A) Headspace				12-12-90	JS		
	B) Trigger Pull	273	277	282	275	278	12-12-90	JS
	C) Function						12-12-90	JS
660	Pack						12/14/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 66587599

DATE 12-3-90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.37	2.34	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.49	2.40	2.77	
PULL #3	2.37	2.41	2.36	2.82	
PULL #4	2.35	2.36	2.42	2.75	
PULL #5	2.39	2.37	2.42	2.78	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.25		
PULL #2	3.25	3.27		
PULL #3	3.24	3.32		
PULL #4	3.23	3.29		
PULL #5	3.10	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.44		4.45
PULL #2	4.27	4.21		4.47
PULL #3	4.46	4.36		4.42
PULL #4	4.43	4.39		4.46
PULL #5	4.46	4.42		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587599
11 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.116709
1 TO	2	.0728972
1 TO	3	.195164
1 TO	4	.127577
1 TO	5	.11673

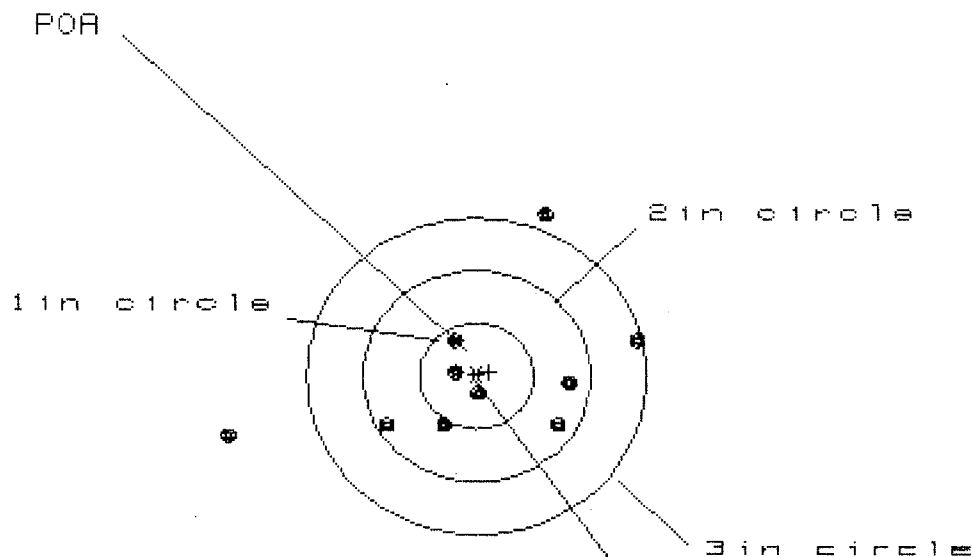
⚡ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0736
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0828309
THE AMR FOR THIS RIFLE IS: 1.126

11 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06507593

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 3.536

VS= 2.096

GS= 3.640

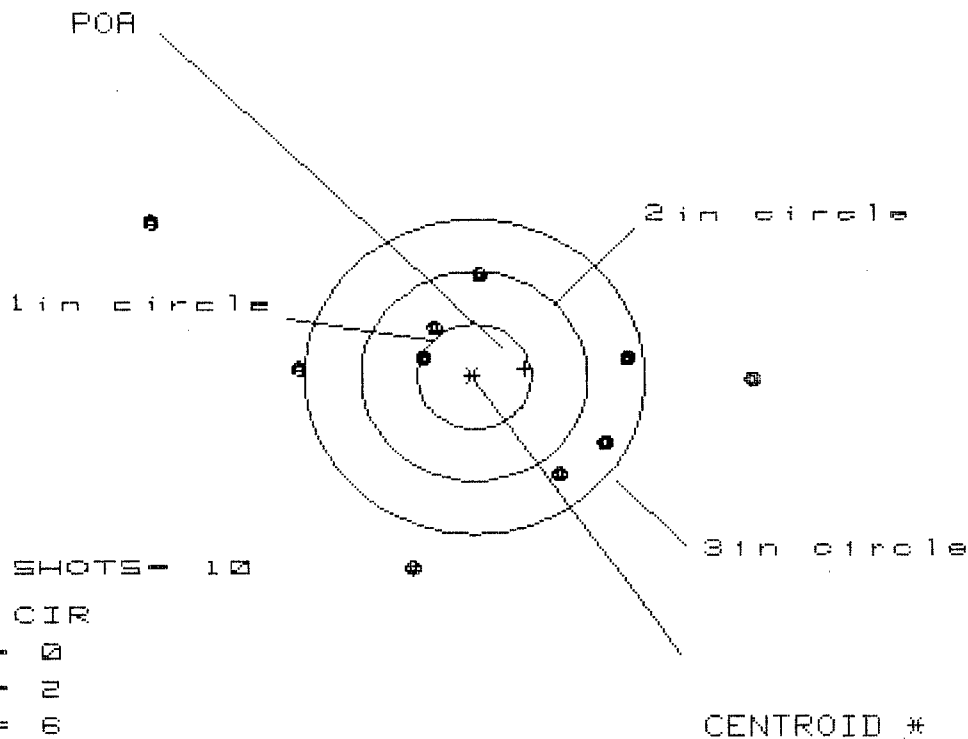
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.390	1.152	1.195
MINIMUM X	:	-2.146	-1.014	-.971
MAXIMUM Y	:	1.524	1.460	.463
MINIMUM Y	:	-.572	-.547	-.365
CENTROID X	:	-.110	.128	.085
CENTROID Y	:	-.039	.025	-.158
POA TO CENTROID in.	:	.117	.131	.179
MIN RADIUS	:	.180	.305	.158
MEAN RADIUS	:	.914	.787	.660
MAX RADIUS	:	2.221	1.500	1.263
HORIZONTAL SPREAD	:	3.536	2.166	2.166
VERTICAL SPREAD	:	2.096	2.007	.827
EXTREME SPREAD	:	3.640	2.396	2.289
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587599

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 6

HS= 5.276

VS= 3.229

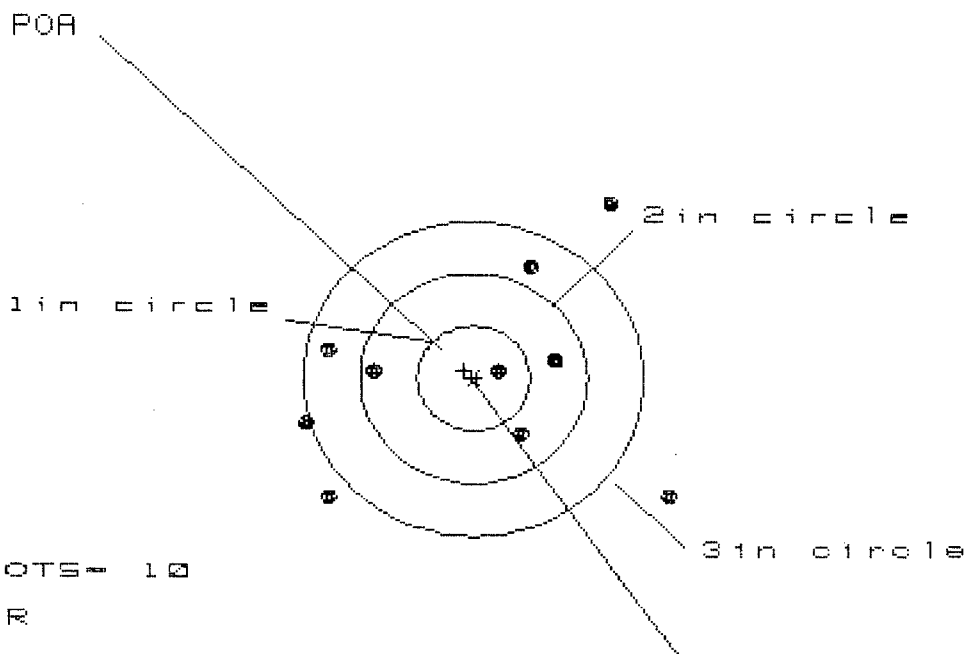
GS= 5.470

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.420	2.103	1.332
MINIMUM X	:	-2.856	-1.841	-1.578
MAXIMUM Y	:	1.423	1.176	1.193
MINIMUM Y	:	-1.806	-1.648	-1.631
CENTROID X	:	-.450	-.133	-.396
CENTROID Y	:	-.072	-.230	-.247
POA TO CENTROID in.	:	.456	.266	.467
MIN RADIUS	:	.525	.872	.659
MEAN RADIUS	:	1.510	1.314	1.198
MAX RADIUS	:	3.190	2.107	1.743
HORIZONTAL SPREAD	:	5.276	3.944	2.910
VERTICAL SPREAD	:	3.229	2.824	2.824
EXTREME SPREAD	:	5.470	3.946	2.910
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587599

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 3.213

VS= 2.828

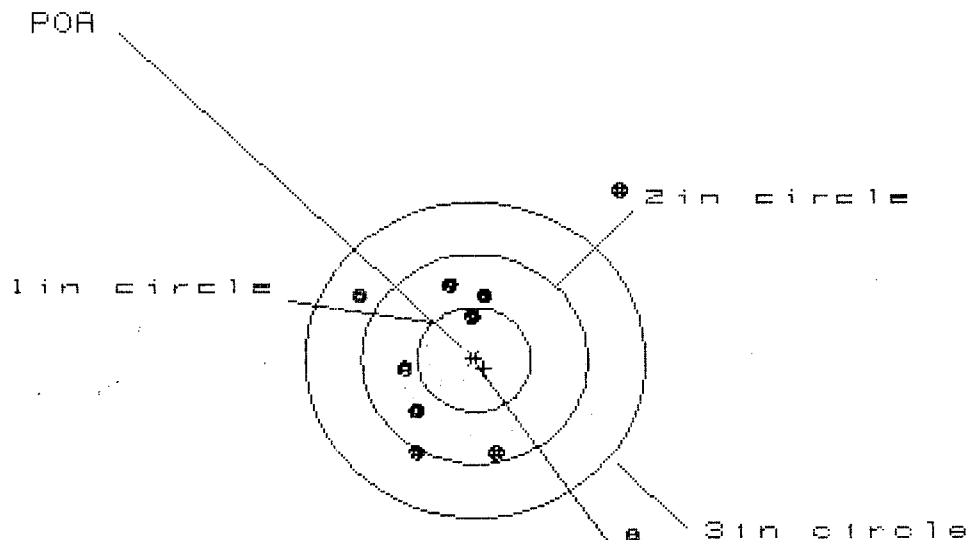
GS= 3.749

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.734	1.418	1.057
MINIMUM X	:	-1.479	-1.287	-1.109
MAXIMUM Y	:	1.668	1.539	1.144
MINIMUM Y	:	-1.160	-1.276	-1.084
CENTROID X	:	.082	-.110	-.288
CENTROID Y	:	-.074	.055	-.137
POA TO CENTROID in.	:	.110	.123	.319
MIN RADIUS	:	.242	.430	.500
MEAN RADIUS	:	1.240	1.148	1.015
MAX RADIUS	:	2.086	2.093	1.453
HORIZONTAL SPREAD	:	3.213	2.705	2.166
VERTICAL SPREAD	:	2.828	2.815	2.228
EXTREME SPREAD	:	3.749	3.749	2.849
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587599

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.319

VS = 3.264

GS = 3.287

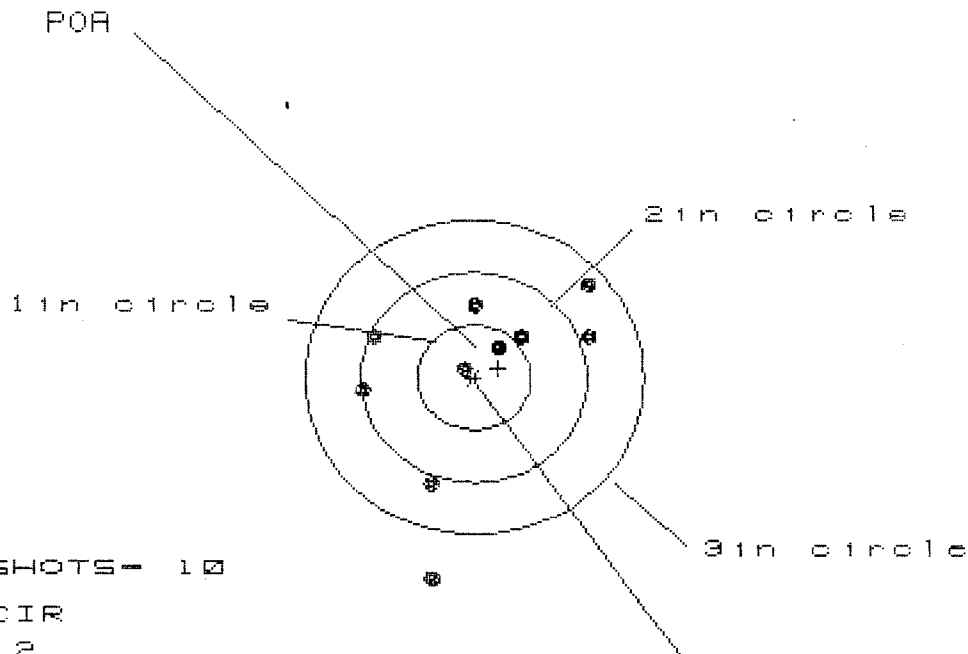
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.340	1.438	.546
MINIMUM X	-.979	-.830	-.651
MAXIMUM Y	1.584	1.397	.676
MINIMUM Y	-1.680	-1.062	-.887
CENTROID X	-.080	-.229	-.408
CENTROID Y	.085	.272	.097
POA TO CENTROID in.	.117	.355	.420
MIN RADIUS	.416	.279	.331
MEAN RADIUS	1.044	.869	.708
MAX RADIUS	2.149	2.005	1.042
HORIZONTAL SPREAD	2.319	2.268	1.197
VERTICAL SPREAD	3.264	2.459	1.563
EXTREME SPREAD	3.287	3.053	1.938
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587593

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.020

VS= 2.859

GS= 3.204

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.036
MINIMUM X	-.984
MAXIMUM Y	.911
MINIMUM Y	-1.948
CENTROID X	-.215
CENTROID Y	-.090
POA TO CENTROID in.	.233
MIN RADIUS	.123
MEAN RADIUS	.923
MAX RADIUS	1.991
HORIZONTAL SPREAD	2.020
VERTICAL SPREAD	2.859
EXTREME SPREAD	3.204
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9