

C6523538

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Sinclair[®]

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

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

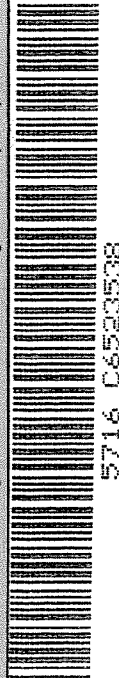
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM M24

SERIAL NO.
06523538

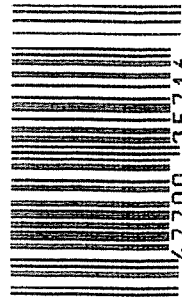
ORDER NO.
5716

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



5716 06523538

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523538

OP. #	OP. NAME	READINGS	DATE	INI
575 & 580	Assemble Action and Stock		10/1/90	KA
600	Proof		10/1/90	KA
607	Check Headspace		10/1/90	KA
610	Dis-assemble Gun		10/1/90	KA
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	GB
617	Drill and Tap Sight Holes		10/4/90	FB
618	Polish Barrel RB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		10/25/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/25/90	KA
	C) Inspect Ejector Hole for Chamfer		10/25/90	KA
	D) Oil Firing Pin Ass'y		10/25/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		10-24-90	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/24/90	WB
	G) Safety Off Force	2	2	2			10/24/90	WB
	H) Trigger Pull Test & Retainability						10-24-90	DH
	I) Firing Pin Indent	.020	.020	.020			10/24/90	WB
	J) Assemble Stock						10/25/90	KJ
	K) Assemble Swivel Studs						13/Nov/90	JSB
	L) Attach Front and Rear Sight Assemblies						10/25/90	KJ
	M) Iron Sight Alignment						10/25/90	KJ
	N) Detach Front & Rear Sights & place in numbered container						10/25/90	KJ
	O) Attach Scope to Rifle						10/25/90	KJ
	P) Detach & Attach Scope 20 Times						10/25/90	KJ
640	Gallery Target & Test						10/26/90	VF
	A) Time						"	VF
	B) Malfunctions						"	VF
	C) Pierced Primers						"	VF
	D) Optical Clarity of Scope						"	VF
645	Inspect for Live Ammo						10/26/90	VF
655	Final Inspection							
	A) Headspace						3/Nov/90	JSB
	B) Trigger Pull	223	228	223	212	223	3/Nov/90	JSB
	C) Function						3/Nov/90	JSB
660	Pack						12/14/90	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523538

DATE 10-24-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.36	2.49	223	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.37	2.60	228	
PULL #3	2.36	2.35	2.63	223	
PULL #4	2.36	2.36	2.53	212	
PULL #5	2.40	2.34	2.62	223	
TOTAL	12.22	11.78	12.87		
AVG.	2.44	2.35	2.57		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.12		
PULL #2	3.11	3.14		
PULL #3	3.15	3.01		
PULL #4	3.07	3.06		
PULL #5	3.09	3.05		
TOTAL	15.59	15.38		
AVG.	3.11	3.07		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.14		4.09
PULL #2	4.10	4.10		4.10
PULL #3	4.11	4.13		4.16
PULL #4	4.23	4.19		4.17
PULL #5	4.19	4.20		4.19
TOTAL	20.91	20.76		20.71
AVG.	4.18	4.15		4.14

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523538
26 Oct 1990

CENTROIDAL DISTANCES

0	TO	1	.13537
1	TO	2	.240875
1	TO	3	.262088
1	TO	4	.156157
1	TO	5	.0904434

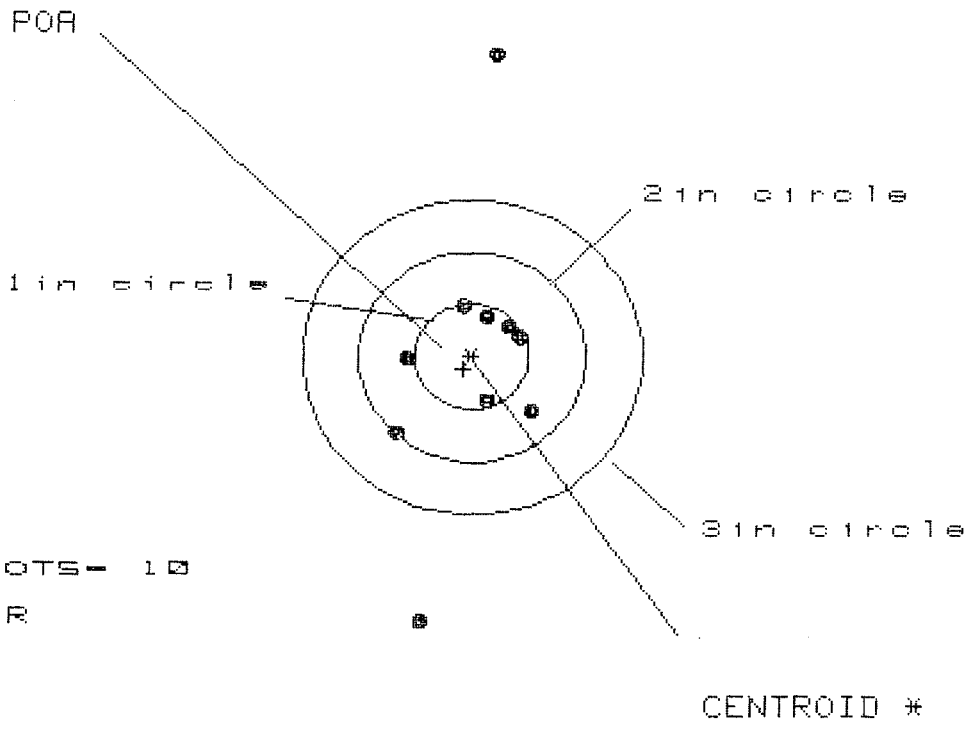
4.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0636
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0046
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0637661
THE AMR FOR THIS RIFLE IS: .931

26 Oct 1998

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CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 5

2in = 7

3in = 8

HS= 1.251

VS= 5.379

GS= 5.420

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.548	.573	.520
MINIMUM X	-.703	-.678	-.731
MAXIMUM Y	2.891	.811	.540
MINIMUM Y	-2.488	-2.167	-.687
CENTROID X	.073	.048	.101
CENTROID Y	.114	-.207	.064
POA TO CENTROID in.	.135	.213	.119
MIN RADIUS	.380	.216	.404
MEAN RADIUS	1.005	.819	.578
MAX RADIUS	2.899	2.207	1.003
HORIZONTAL SPREAD	1.251	1.251	1.251
VERTICAL SPREAD	5.379	2.978	1.227
EXTREME SPREAD	5.420	3.000	1.455
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

26 Oct 1998

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.936

VS = 2.249

GS = 3.024

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.491	1.331	1.008
MINIMUM X	:	-1.445	-1.180	-1.014
MAXIMUM Y	:	1.092	.963	.893
MINIMUM Y	:	-1.157	-1.093	-1.163
CENTROID X	:	.103	.263	.097
CENTROID Y	:	-.125	.004	.074
POA TO CENTROID in.	:	.162	.263	.122
MIN RADIUS	:	.118	.162	.256
MEAN RADIUS	:	1.007	.896	.824
MAX RADIUS	:	1.851	1.444	1.240
HORIZONTAL SPREAD	:	2.936	2.511	2.022
VERTICAL SPREAD	:	2.249	2.056	2.056
EXTREME SPREAD	:	3.024	2.848	2.201
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 3.043

VS= 3.288

GS= 3.635

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.767	.679	.689
MINIMUM X	:	-1.276	-1.080	-.995
MAXIMUM Y	:	1.558	1.366	.839
MINIMUM Y	:	-1.730	-.921	-.751
CENTROID X	:	.204	.008	-.077
CENTROID Y	:	-.113	.079	-.091
POA TO CENTROID in.	:	.233	.080	.119
MIN RADIUS	:	.519	.597	.577
MEAN RADIUS	:	1.077	.909	.812
MAX RADIUS	:	2.473	1.525	1.001
HORIZONTAL SPREAD	:	3.043	1.759	1.684
VERTICAL SPREAD	:	3.288	2.287	1.590
EXTREME SPREAD	:	3.635	2.293	1.886
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

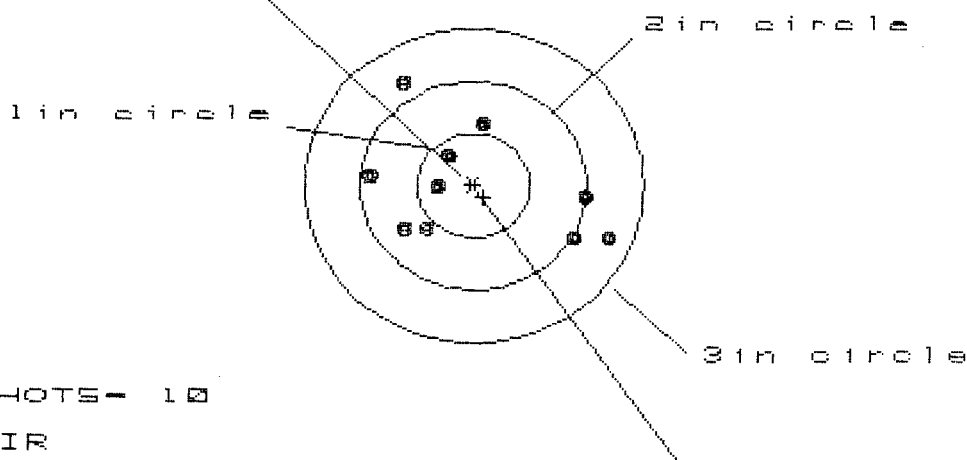
26 Oct 1938

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

CENTROID *

HS= 2.044

VS= 1.481

GS= 2.335

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.170	1.085	1.020
MINIMUM X	:	-.874	-.744	-.808
MAXIMUM Y	:	.985	.932	.621
MINIMUM Y	:	-.496	-.549	-.432
CENTROID X	:	-.083	-.213	-.148
CENTROID Y	:	.107	.160	.043
POA TO CENTROID in.	:	.135	.267	.155
MIN RADIUS	:	.305	.198	.237
MEAN RADIUS	:	.782	.693	.657
MAX RADIUS	:	1.265	1.160	1.051
HORIZONTAL SPREAD	:	2.044	1.829	1.829
VERTICAL SPREAD	:	1.481	1.481	1.053
EXTREME SPREAD	:	2.335	2.137	1.848
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

26 Oct 1998

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.390

VS = 1.833

GS = 3.012

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.342	1.226	1.150
MINIMUM X	-1.048	-.936	-.783
MAXIMUM Y	1.323	.688	.643
MINIMUM Y	-.510	-.364	-.311
CENTROID X	.021	.137	-.016
CENTROID Y	.040	-.106	-.061
POA TO CENTROID in.	.045	.174	.063
MIN RADIUS	.187	.172	.107
MEAN RADIUS	.784	.676	.574
MAX RADIUS	1.687	1.279	1.155
HORIZONTAL SPREAD	2.390	2.162	1.933
VERTICAL SPREAD	1.833	1.052	.954
EXTREME SPREAD	3.012	2.192	1.934
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		