

05649083

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

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.

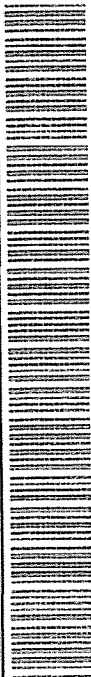
MODEL 700TM M24

SERIAL NO.
C6649083

ORDER NO.
5716

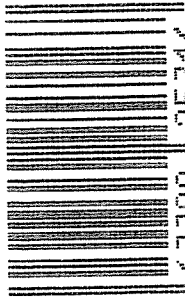
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.



5716 C6649083

LPC



0 47700 25716 7

MOD. _____ GA. _____ GUN # 9083
CAL. _____ # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
<i>K</i>	1st	<i>Trigger Creeps</i>	<i>KS</i>
	<i>9/3/91</i>		
	2nd	<i>Repairs AC (creep)</i>	<i>KS</i>
	<i>9/9/91</i>		
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649083

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	DB
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KL
	C) Inspect Ejector Hole for Chamfer		8/29/91	KL
	D) Oil Firing Pin Ass'y		8/29/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/91	KL

op. #	BARBER M24 0031456	READINGS			DATE	INITIALS
625 cont.	F) Safety On Force	6	6	6	8-31-91	DH
	G) Safety Off Force	3	3	2 1/2	8-31-91	DH
	H) Trigger Pull Test & Retainability				8/31/91	JK
	I) Firing Pin Indent	.021	.020	.022	8-31-91	DH
	J) Assemble Stock				8/31/91	JK
	K) Assemble Swivel Studs				9-10-91	DH
	L) Attach Front and Rear Sight Assemblies				8/31/91	JK
	M) Iron Sight Alignment				8/31/91	JK
	N) Detach Front & Rear Sights & place in numbered container				8/31/91	JK
	O) Attach Scope to Rifle				8/31/91	JK
	P) Detach & Attach Scope 20 Times				8/31/91	JK
640	Gallery Target & Test				9/3/91	KT
	A) Time					KT
	B) Malfunctions					KT
	C) Pierced Primers					KT
	D) Optical Clarity of Scope					KT
645	Inspect for Live Ammo				9/3/91	KT
655	Final Inspection					
	A) Headspace				9-10-91	DH
	B) Trigger Pull	264	259	269	9/10/91	JK
	C) Function				9-10-91	DH
660	Pack				9-18-91	JK

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649083

DATE 8/31/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.40	2.44	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.46	2.46	2.59	
PULL #3	2.61	2.49	2.43	2.69	
PULL #4	2.30	2.34	2.50	2.64	
PULL #5	2.52	2.45	2.48	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.52		
PULL #2	3.27	3.40		
PULL #3	3.28	3.59		
PULL #4	3.60	3.39		
PULL #5	3.61	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.14		4.44
PULL #2	4.52	4.54		4.56
PULL #3	4.44	4.47		4.57
PULL #4	4.44	4.51		4.57
PULL #5	4.51	4.52		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649083
4 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.115447
1 TO	2	.106
1 TO	3	.571908
1 TO	4	.457161
1 TO	5	.359124

3.4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0642
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.145
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1595
THE AVERAGE FOR THIS RIFLE IS: 1.024

1 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649083

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 3.261

VS = 2.731

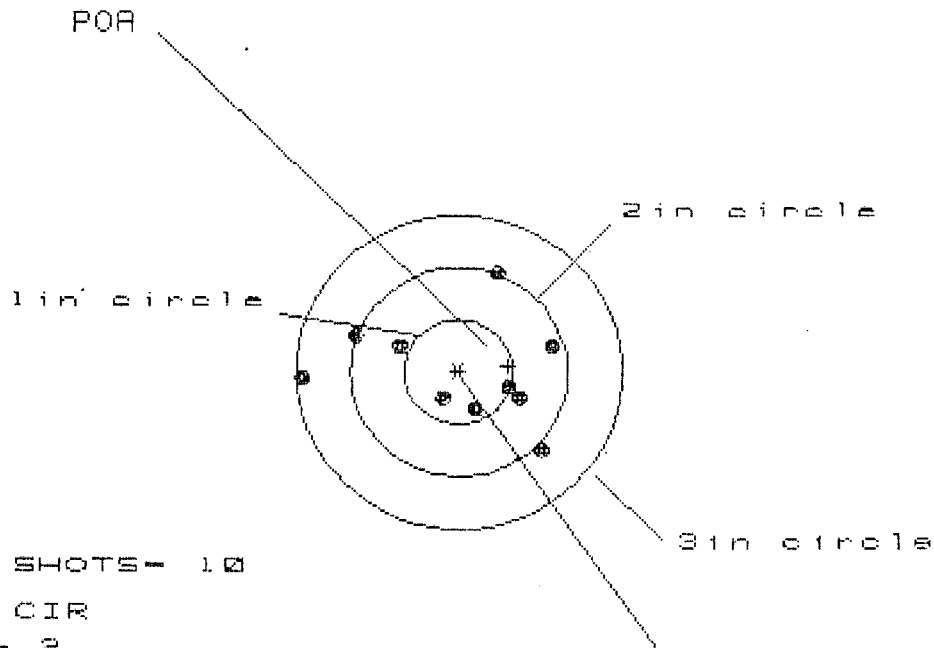
GS = 3.639

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.494	.953	.940
MINIMUM X	-.767	-.490	-.503
MAXIMUM Y	1.499	1.417	1.207
MINIMUM Y	-1.232	-1.314	-1.137
CENTROID X	.422	.145	.158
CENTROID Y	-.308	-.226	-.403
POA TO CENTROID in.	.522	.268	.433
MIN RADIUS	.298	.090	.167
MEAN RADIUS	1.065	.834	.739
MAX RADIUS	2.600	1.421	1.530
HORIZONTAL SPREAD	3.261	1.443	1.443
VERTICAL SPREAD	2.731	2.731	2.344
EXTREME SPREAD	3.639	2.758	2.753
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649083

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.200

VS = 1.605

GS = 2.300

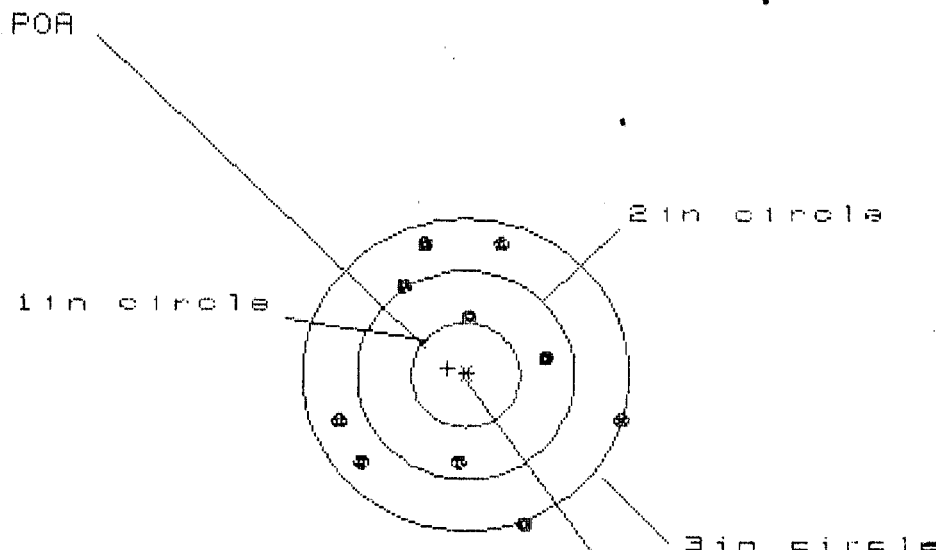
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.882	.725	.582
MINIMUM X	-1.411	-1.144	-.804
MAXIMUM Y	.908	.906	.946
MINIMUM Y	-.697	-.699	-.659
CENTROID X	-.454	-.297	-.154
CENTROID Y	-.054	-.052	-.092
POA TO CENTROID in.	.457	.302	.179
MIN RADIUS	.337	.362	.217
MEAN RADIUS	.775	.682	.589
MAX RADIUS	1.411	1.187	.946
HORIZONTAL SPREAD	2.293	1.869	1.386
VERTICAL SPREAD	1.605	1.605	1.605
EXTREME SPREAD	2.308	2.015	1.661
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649083

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

IS= 2.608

VS= 2.744

GS= 2.828

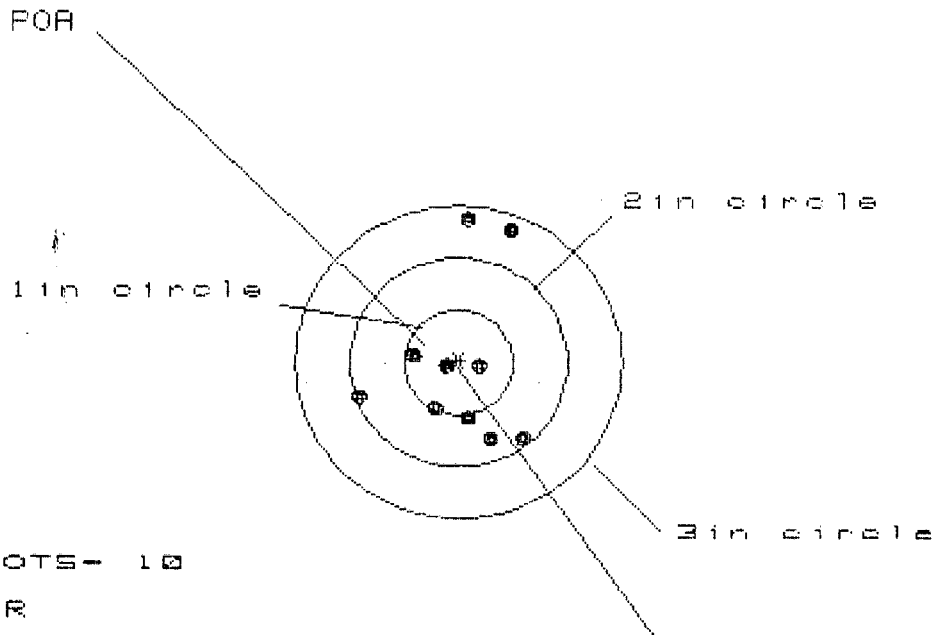
CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.470	1.529	.956
MINIMUM X	-1.138	-1.079	-.888
MAXIMUM Y	1.274	1.110	1.036
MINIMUM Y	-1.470	-1.027	-1.101
CENTROID X	.168	.109	-.082
CENTROID Y	-.062	.102	.176
POA TO CENTROID in.	.179	.149	.194
MIN RADIUS	.525	.366	.382
MEAN RADIUS	1.130	1.055	.966
MAX RADIUS	1.564	1.640	1.323
HORIZONTAL SPREAD	2.608	2.608	1.844
VERTICAL SPREAD	2.744	2.137	2.137
EXTREME SPREAD	2.828	2.608	2.526
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649083

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.438

VS= 2.102

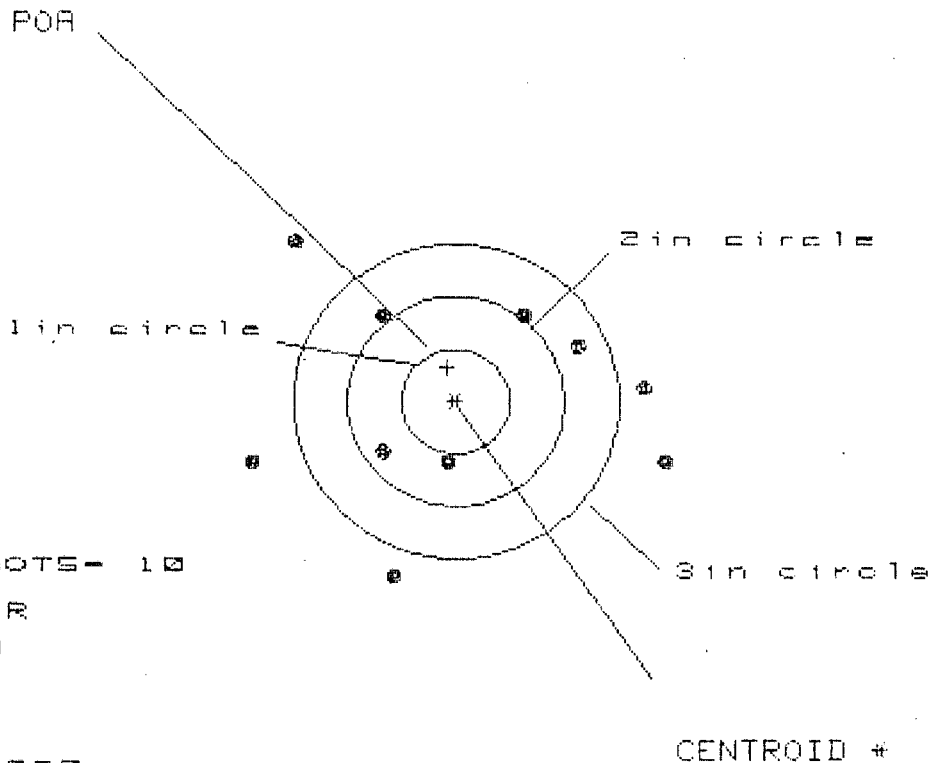
GS= 2.162

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.553	.559	.624
MINIMUM X	-.885	-.879	-.814
MAXIMUM Y	1.393	1.404	.437
MINIMUM Y	-.709	-.554	-.378
CENTROID X	.112	.106	.041
CENTROID Y	.028	-.126	-.302
POA TO CENTROID in.	.115	.165	.305
MIN RADIUS	.121	.157	.176
MEAN RADIUS	.706	.595	.459
MAX RADIUS	1.394	1.498	.816
HORIZONTAL SPREAD	1.438	1.438	1.438
VERTICAL SPREAD	2.102	1.958	.815
EXTREME SPREAD	2.162	2.073	1.501
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

3 Sep 1981

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 5

HS= 3.860

VS= 3.193

GS= 4.065

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.956	1.790	1.810
MINIMUM X	-1.904	-2.070	-1.847
MAXIMUM Y	1.567	1.003	.953
MINIMUM Y	-1.626	-1.452	-1.502
CENTROID X	.073	.239	.016
CENTROID Y	-.329	-.503	-.453
POA TO CENTROID in.	.337	.557	.453
MIN RADIUS	.526	.405	.401
MEAN RADIUS	1.444	1.348	1.267
MAX RADIUS	2.169	2.116	1.909
HORIZONTAL SPREAD	3.860	3.860	3.657
VERTICAL SPREAD	3.193	2.455	2.455
EXTREME SPREAD	4.065	3.860	3.723
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		