

66636242

MODEL 700TM M24

Model S&S TM

Action

Barrel Length

Capacity

Order No. 5716

*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 H24

SERIAL NO.
C6636242

ORDER NO.
5716

20

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

5716 C6636242

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636242

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	Rw
600	Proof	4 30	91	Rw
607	Check Headspace	4 30	91	Rw
610	Dis-assemble Gun	4 30	91	Rw
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	GL
617	Drill and Tap Sight Holes	5 10	91	LB
618	Polish Barrel	5 10	91	LB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/19/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	Rw
	C) Inspect Ejector Hole for Chamfer		6/19/91	Rw
	D) Oil Firing Pin Ass'y		6/19/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		7-18-91	JA

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-19-91	QU
	G) Safety Off Force	4	4	4			7-19-91	QU
	H) Trigger Pull Test & Retainability						7-18-91	QU
	I) Firing Pin Indent	.0215	.022	.022			7-19-91	QU
	J) Assemble Stock						7/22/91	RW
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/22/91	RW
	M) Iron Sight Alignment						7/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	RW
	O) Attach Scope to Rifle						7/22/91	RW
	P) Detach & Attach Scope 20 Times						7/22/91	RW
640	Gallery Target & Test						7-22-91	D/H
	A) Time						7-22-91	D/H
	B) Malfunctions						7-22-91	D/H
	C) Pierced Primers						7-22-91	D/H
	D) Optical Clarity of Scope						7-22-91	D/H
645	Inspect for Live Ammo						7-22-91	D/H
655	Final Inspection						7-23-91	D/H
	A) Headspace						7-23-91	QU
	B) Trigger Pull	2.51	2.30	2.48	2.57	2.20	7-23-91	QU
	C) Function						7-23-91	D/H
660	Pack						9-18-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636242DATE 7-18-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.34	2.20	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.15	2.34	2.25	2.30	
PULL #3	2.39	2.24	2.36	2.48	
PULL #4	2.55	2.34	2.30	2.57	
PULL #5	2.60	2.23	2.36	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.54		
PULL #2	3.47	3.47		
PULL #3	3.41	3.46		
PULL #4	3.56	3.53		
PULL #5	3.54	3.59		
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	4.49		4.54
PULL #2	4.55	4.57		4.59
PULL #3	4.54	4.59		4.54
PULL #4	4.53	4.60		4.60
PULL #5	4.33	4.25		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636242
23 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.196367
1 TO	2	.2114
1 TO	3	.0800562
1 TO	4	.340243
1 TO	5	.338534

54 <----FOR

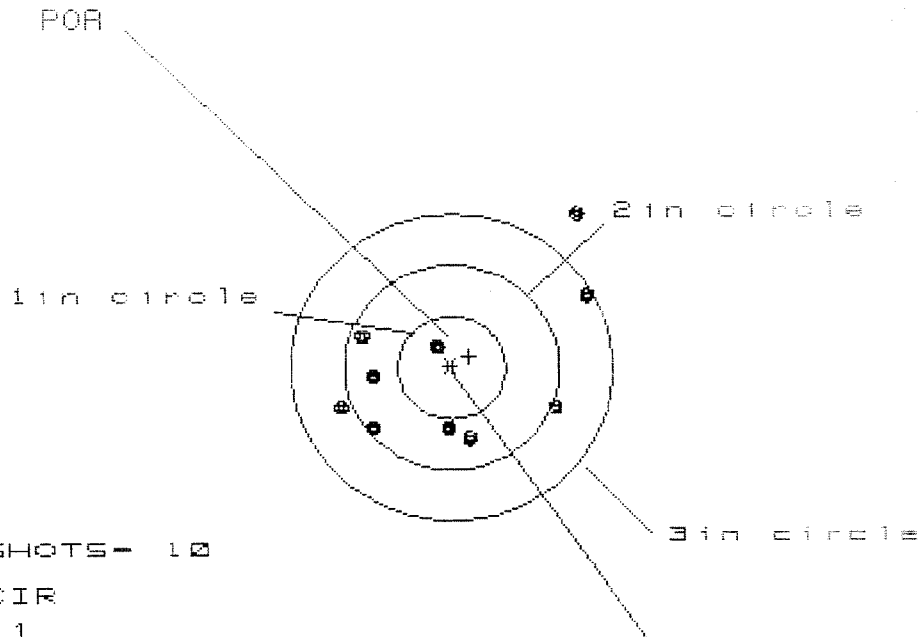
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0104
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0241537

THE AMR FOR THIS RIFLE IS: 1.034

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635242

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.310

VS= 2.173

GS= 2.848

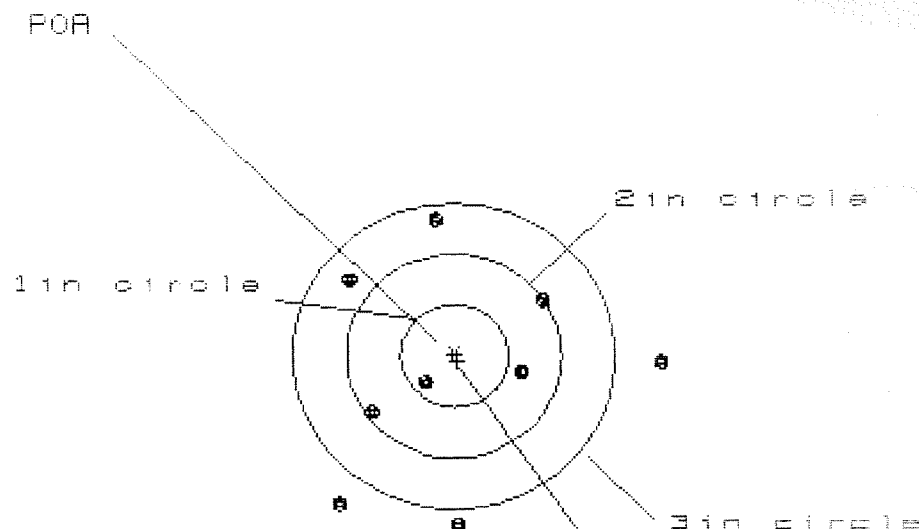
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.296	1.426	1.251
MINIMUM X	:	-1.014	-.884	-.705
MAXIMUM Y	:	1.458	.851	.589
MINIMUM Y	:	-.715	-.553	-.447
CENTROID X	:	-.164	-.294	-.473
CENTROID Y	:	-.108	-.270	-.376
POA TO CENTROID in.	:	.196	.399	.604
MIN RADIUS	:	.280	.384	.357
MEAN RADIUS	:	.961	.812	.665
MAX RADIUS	:	1.874	1.661	1.262
HORIZONTAL SPREAD	:	2.310	2.310	1.956
VERTICAL SPREAD	:	2.173	1.484	1.836
EXTREME SPREAD	:	2.848	2.537	1.957
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636242

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.960

VS= 2.998

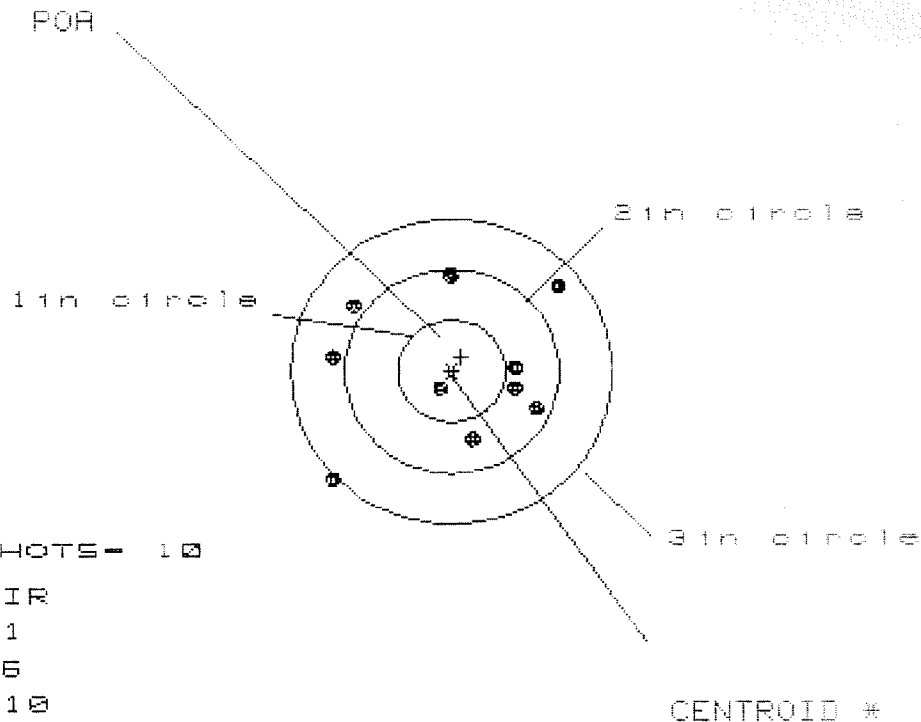
GS= 3.248

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.932
MINIMUM X	-1.028
MAXIMUM Y	1.383
MINIMUM Y	-1.615
CENTROID X	-.027
CENTROID Y	.053
POA TO CENTROID in.	.060
MIN RADIUS	.361
MEAN RADIUS	1.214
MAX RADIUS	1.935
HORIZONTAL SPREAD	2.960
VERTICAL SPREAD	2.998
EXTREME SPREAD	3.248
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	7

23 Jul 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6636242

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.138

VS= 1.936

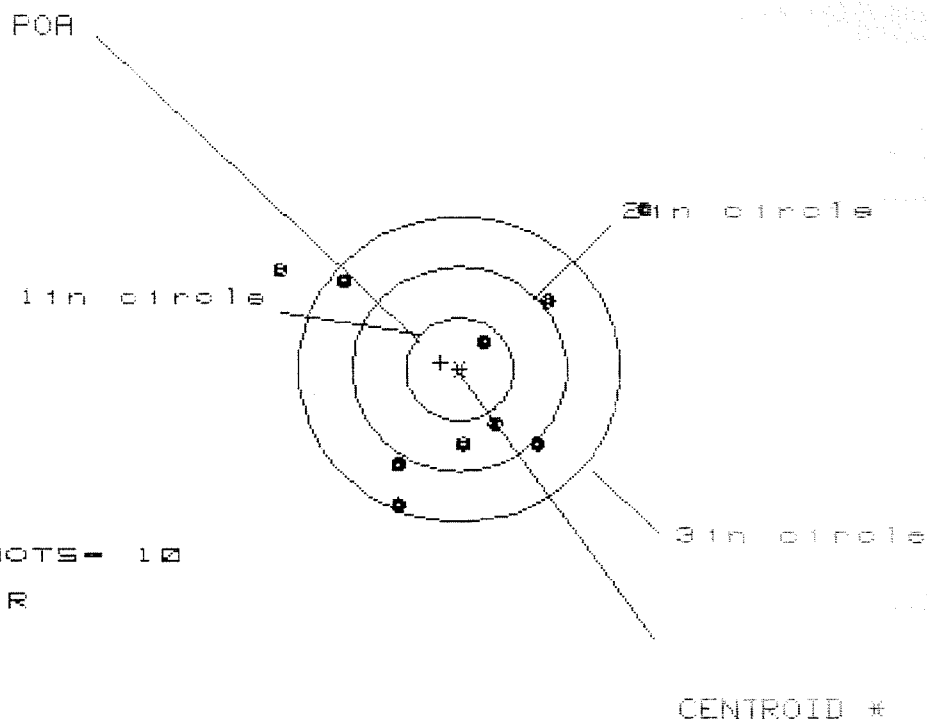
GS= 2.813

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.029	.910	.740
MINIMUM X	:	-1.109	-1.228	-1.114
MAXIMUM Y	:	.888	.772	.860
MINIMUM Y	:	-1.048	-.818	-.730
CENTROID X	:	-.089	.030	-.084
CENTROID Y	:	-.136	-.020	-.108
POA TO CENTROID in.	:	.162	.036	.137
MIN RADIUS	:	.224	.384	.251
MEAN RADIUS	:	.892	.816	.765
MAX RADIUS	:	1.497	1.228	1.120
HORIZONTAL SPREAD	:	2.138	2.138	1.854
VERTICAL SPREAD	:	1.936	1.590	1.590
EXTREME SPREAD	:	2.813	2.244	1.909
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636242

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 3.411

VS= 2.907

GS= 3.767

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.775	1.069	.889
MINIMUM X	:	-1.636	-1.438	-1.097
MAXIMUM Y	:	1.557	1.156	1.158
MINIMUM Y	:	-1.350	-1.177	-1.033
CENTROID X	:	.174	-.024	.156
CENTROID Y	:	-.069	-.242	-.386
POA TO CENTROID in.	:	.187	.243	.417
MIN RADIUS	:	.329	.590	.391
MEAN RADIUS	:	1.209	1.068	.909
MAX RADIUS	:	2.361	1.845	1.595
HORIZONTAL SPREAD	:	3.411	2.507	1.986
VERTICAL SPREAD	:	2.907	2.333	2.191
EXTREME SPREAD	:	3.767	2.937	2.514
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636242

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.378

VS = 2.128

GS = 2.571

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.365	1.343	.918
MINIMUM X	:	-1.013	-1.035	-.867
MAXIMUM Y	:	1.496	1.323	1.275
MINIMUM Y	:	-.632	-.465	-.513
CENTROID X	:	.054	.076	-.092
CENTROID Y	:	.151	-.016	.032
POR TO CENTROID in.	:	.160	.077	.097
MIN RADIUS	:	.348	.332	.297
MEAN RADIUS	:	.895	.800	.715
MAX RADIUS	:	1.509	1.396	1.289
HORIZONTAL SPREAD	:	2.378	2.378	1.785
VERTICAL SPREAD	:	2.128	1.788	1.788
EXTREME SPREAD	:	2.571	2.378	1.986
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	