

C6636247

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

Remington
MODEL 700TM M24

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

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

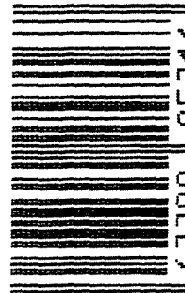
SERIAL NO.
C6636247

ORDER NO.
5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636247

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		Kcd
	Magnaflux Bolt	5 6 91		Kcd
615	Rollmark Caliber	5 6 91		CS
617	Drill and Tap Sight Holes	5 10 91		WB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/30/91	
	Apply Coating (Bolt)		5/30/91	
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-6-91	JK

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-6-91	JH
	G) Safety Off Force	3	3	3			6-6-91	JH
	H) Trigger Pull Test & Retainability						6-6-91	JH
	I) Firing Pin Indent	.022	.0215	.0215			6-6-91	JH
	J) Assemble Stock						6/6/91	RW
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6/6/91	RW
	M) Iron Sight Alignment						6/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/6/91	RW
	O) Attach Scope to Rifle						6/6/91	RW
	P) Detach & Attach Scope 20 Times						6/6/91	RW
640	Gallery Target & Test						6-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-6-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.70	2.79	2.77	2.77	2.76	6-13-91	JH
	C) Function						6-14-91	JH
660	Pack						6-19-91	NF

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636247DATE 6-6-91TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.32	2.40	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.22	2.38	2.79	
PULL #3	2.42	2.25	2.41	2.77	
PULL #4	2.37	2.60	2.38	2.77	
PULL #5	2.38	2.37	2.30	2.76	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.41		
PULL #2	3.39	3.51		
PULL #3	3.50	3.51		
PULL #4	3.37	3.51		
PULL #5	3.50	3.16		
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	4.45		4.16
PULL #2	4.45	4.49		4.53
PULL #3	4.40	4.53		4.59
PULL #4	4.40	4.55		4.59
PULL #5	4.37	4.44		4.61
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636247
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.37392
1 TO	2	.419672
1 TO	3	.145671
1 TO	4	.519477
1 TO	5	.214898

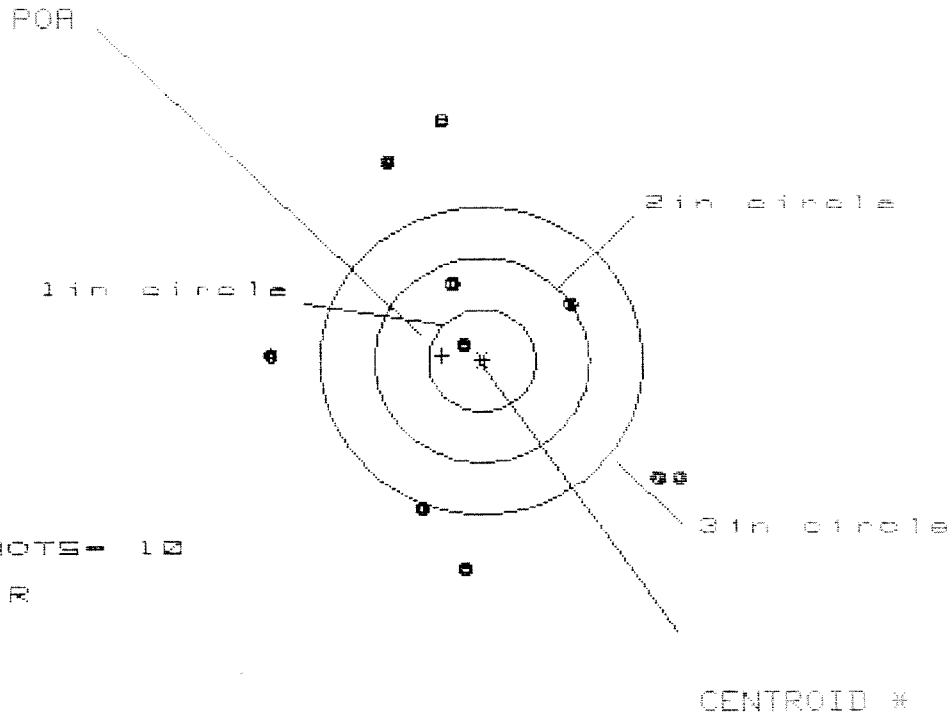
~~fig~~ (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124688
THE AMR FOR THIS RIFLE IS: 1.158

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636247

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 3

HS= 3.814

VS= 4.386

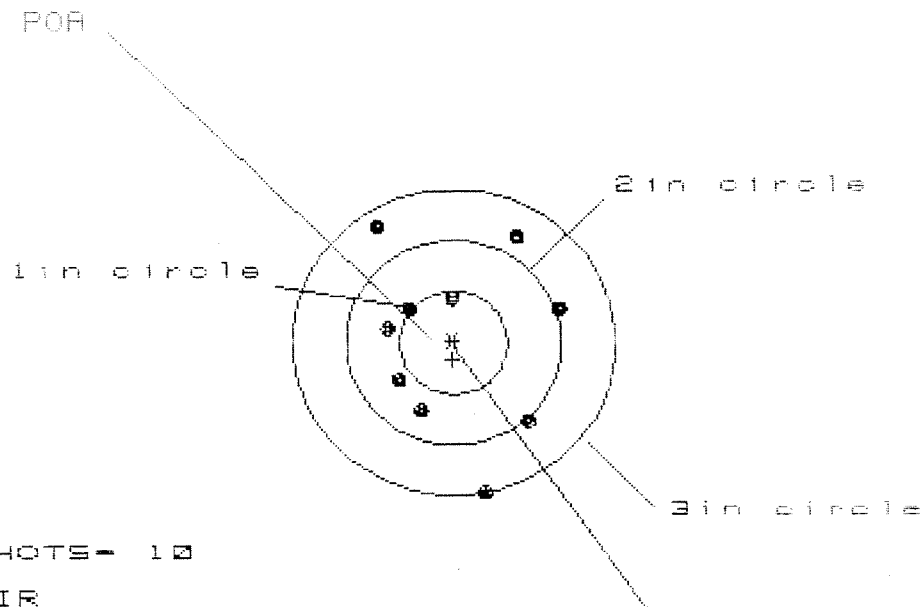
GS= 4.386

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.832	1.794	1.770
MINIMUM X	-1.982	-2.020	-1.796
MAXIMUM Y	2.320	2.212	2.100
MINIMUM Y	-2.066	-1.808	-1.920
CENTROID X	.370	.408	.183
CENTROID Y	-.054	-.312	-.200
POR TO CENTROID in.	.374	.513	.272
MIN RADIUS	.218	.454	.302
MEAN RADIUS	1.629	1.565	1.480
MAX RADIUS	2.344	2.373	2.194
HORIZONTAL SPREAD	3.814	3.814	3.566
VERTICAL SPREAD	4.386	4.020	4.020
EXTREME SPREAD	4.396	4.082	4.075
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	3		

6 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.7008

VS= 2.592

GS= 2.788

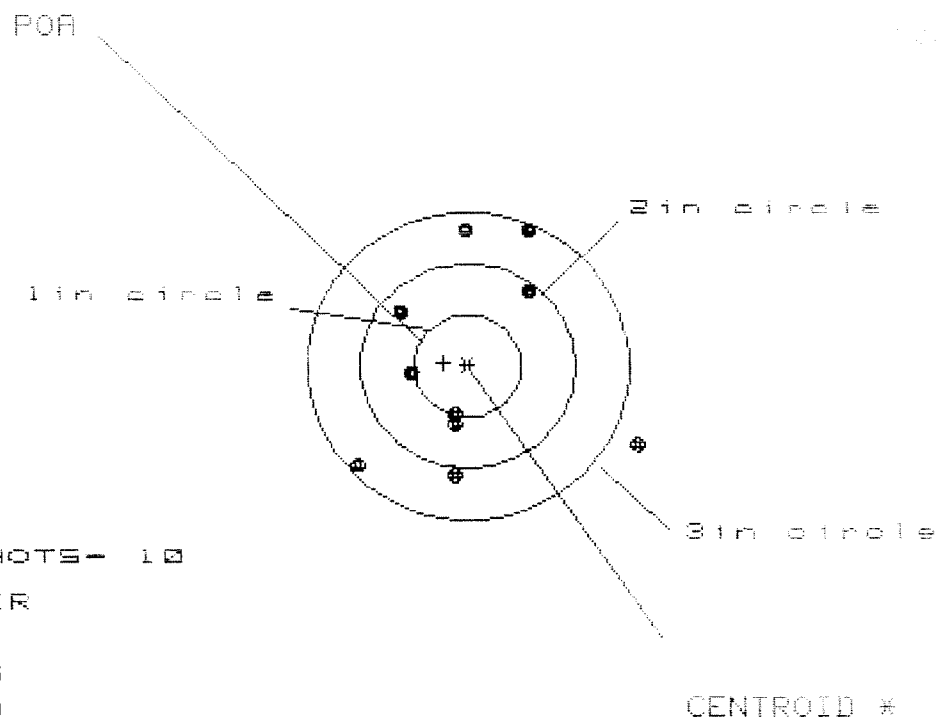
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	1.021	.935
MINIMUM X	:	-.721	-.687	-.624
MAXIMUM Y	:	1.118	.954	.985
MINIMUM Y	:	-1.474	-.914	-.795
CENTROID X	:	.012	-.022	.063
CENTROID Y	:	.165	.329	.210
POA TO CENTROID in.	:	.166	.330	.219
MIN RADIUS	:	.419	.258	.377
MEAN RADIUS	:	.901	.808	.774
MAX RADIUS	:	1.506	1.175	1.108
HORIZONTAL SPREAD	:	1.708	1.708	1.559
VERTICAL SPREAD	:	2.592	1.868	1.780
EXTREME SPREAD	:	2.788	2.327	1.953
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.593

VS= 2.391

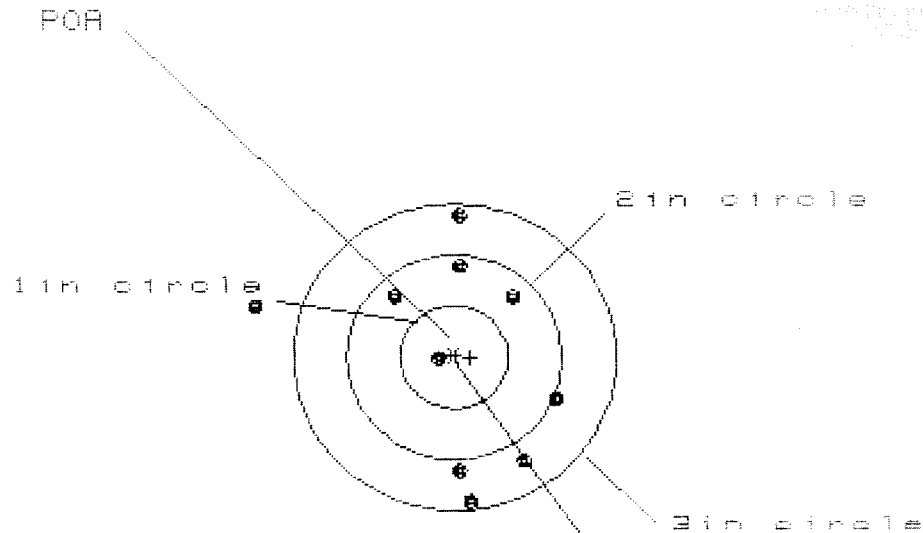
GS= 2.789

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.530
MINIMUM X	-1.063
MAXIMUM Y	1.310
MINIMUM Y	-1.081
CENTROID X	.226
CENTROID Y	-.032
POA TO CENTROID in.	.228
MIN RADIUS	.461
MEAN RADIUS	1.025
MAX RADIUS	1.725
HORIZONTAL SPREAD	2.593
VERTICAL SPREAD	2.391
EXTREME SPREAD	2.789
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

6 Jun 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.795

VS = 2.804

GS = 2.959

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	.773	.760
MINIMUM X	:	-1.820	-.803	-.816
MAXIMUM Y	:	1.407	1.467	1.123
MINIMUM Y	:	-1.397	-1.337	-1.153
CENTROID X	:	-.146	.056	.069
CENTROID Y	:	.006	-.054	-.238
POA TO CENTROID in.	:	.147	.078	.248
MIN RADIUS	:	.135	.326	.388
MEAN RADIUS	:	1.080	.985	.916
MAX RADIUS	:	1.898	1.471	1.183
HORIZONTAL SPREAD	:	2.795	1.576	1.576
VERTICAL SPREAD	:	2.804	2.804	2.276
EXTREME SPREAD	:	2.959	2.806	2.281
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Jun 1981

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 3.230

VS = 3.124

GS = 3.493

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.740	1.574	1.563
MINIMUM X	:	-1.490	-1.183	-1.195
MAXIMUM Y	:	1.827	1.682	1.759
MINIMUM Y	:	-1.297	-1.086	-0.875
CENTROID X	:	.161	.327	.339
CENTROID Y	:	-.104	.041	-.170
POA TO CENTROID in.	:	.192	.329	.379
MIN RADIUS	:	.495	.573	.656
MEAN RADIUS	:	1.157	1.058	.969
MAX RADIUS	:	1.976	1.685	1.563
HORIZONTAL SPREAD	:	3.230	2.757	2.757
VERTICAL SPREAD	:	3.124	2.768	1.634
EXTREME SPREAD	:	3.493	2.840	2.793
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	