

C6636138

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

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

MODEL 700TM M24

SERIAL NO. C6636138

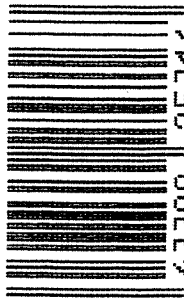
ORDER NO. 5716

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



5716 C6636138

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6634138

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	"
615	Rollmark Caliber		4/10/91	GL
617	Drill and Tap Sight Holes		APR 19 1991	KB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	DB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	GL

op. #	BARBER - M24 0038162	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/24/91	JK
	G) Safety Off Force	4	4	4			5/24/91	JK
	H) Trigger Pull Test & Retainability						5/24/91	JK
	I) Firing Pin Indent	.021	.021	.021			5/24/91	JK
	J) Assemble Stock						5/24/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/24/91	KS
	M) Iron Sight Alignment						5/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	KS
	O) Attach Scope to Rifle						5/24/91	KS
	P) Detach & Attach Scope 20 Times						5/24/91	KS
640	Gallery Target & Test						5-28-91	AC
	A) Time						5-28-91	AC
	B) Malfunctions						5-28-91	AC
	C) Pierced Primers						5-28-91	AC
	D) Optical Clarity of Scope						5-28-91	AC
645	Inspect for Live Ammo						5-28-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.61	2.61	2.62	2.58	2.58	6/1/91	JK
	C) Function						6-1-91	DH
660	Pack						6-20-91	JK

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 66636138

DATE 5-24-91

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.57	2.38	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.59	2.52	2.61	
PULL #3	2.56	2.56	2.43	2.62	
PULL #4	2.50	2.60	2.43	2.58	
PULL #5	2.55	2.36	2.48	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.15		
PULL #2	3.46	3.41		
PULL #3	3.58	3.48		
PULL #4	3.48	3.47		
PULL #5	3.47	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.31		4.26
PULL #2	4.23	4.21		4.29
PULL #3	4.21	4.21		4.27
PULL #4	4.23	4.24		4.18
PULL #5	4.28	4.26		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636138
20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.310736
1 TO	2	.10224
1 TO	3	.300593
1 TO	4	.483828
1 TO	5	.659755

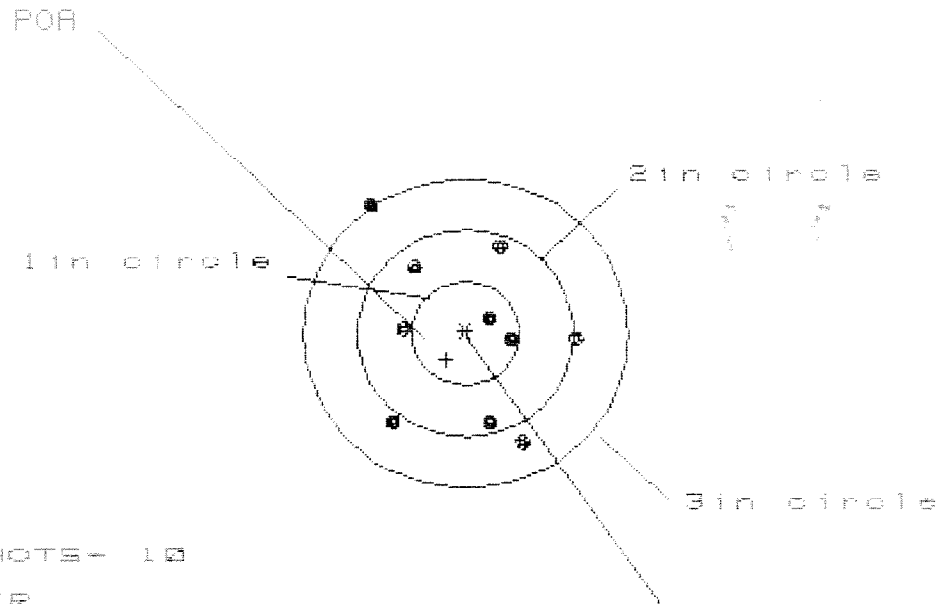
Unit 2 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0224
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0235907
THE AMR FOR THIS RIFLE IS: .8816

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636138

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.897

VS= 2.261

GS= 2.626

CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.038	.943	.991
MINIMUM X	-.859	-.735	-.687
MAXIMUM Y	1.200	.947	.831
MINIMUM Y	-1.061	-.928	-.846
CENTROID X	.179	.275	.227
CENTROID Y	.254	.121	.237
POA TO CENTROID in.	.311	.300	.328
MIN RADIUS	.237	.301	.217
MEAN RADIUS	.858	.781	.739
MAX RADIUS	1.475	1.021	1.074
HORIZONTAL SPREAD	1.897	1.678	1.678
VERTICAL SPREAD	2.261	1.875	1.677
EXTREME SPREAD	2.626	1.996	1.898
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8838138

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.791

VS = 1.710

GS = 2.017

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.918	.917	1.020
MINIMUM X	:	-.873	-.874	-.772
MAXIMUM Y	:	.659	.542	.608
MINIMUM Y	:	-1.051	-.987	-.921
CENTROID X	:	.077	.078	-.025
CENTROID Y	:	.261	.378	.312
POA TO CENTROID in.	:	.272	.386	.313
MIN RADIUS	:	.082	.172	.195
MEAN RADIUS	:	.738	.687	.655
MAX RADIUS	:	1.051	1.113	1.051
HORIZONTAL SPREAD	:	1.791	1.791	1.791
VERTICAL SPREAD	:	1.710	1.529	1.529
EXTREME SPREAD	:	2.017	2.017	1.791
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636138

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

CENTROID #

HS= 2.804

VS= 1.286

GS= 2.952

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.494

.981

.826

MINIMUM X

-1.410

-1.244

-1.256

MAXIMUM Y

.529

.580

.577

MINIMUM Y

-.757

-.706

-.709

CENTROID X

.039

-.127

.028

CENTROID Y

-.012

-.063

-.060

POA TO CENTROID in.

.040

.142

.067

MIN RADIUS

.256

.322

.237

MEAN RADIUS

.818

.740

.647

MAX RADIUS

1.563

1.244

1.257

HORIZONTAL SPREAD

2.904

2.225

2.082

VERTICAL SPREAD

1.286

1.286

1.286

EXTREME SPREAD

2.952

2.305

2.175

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

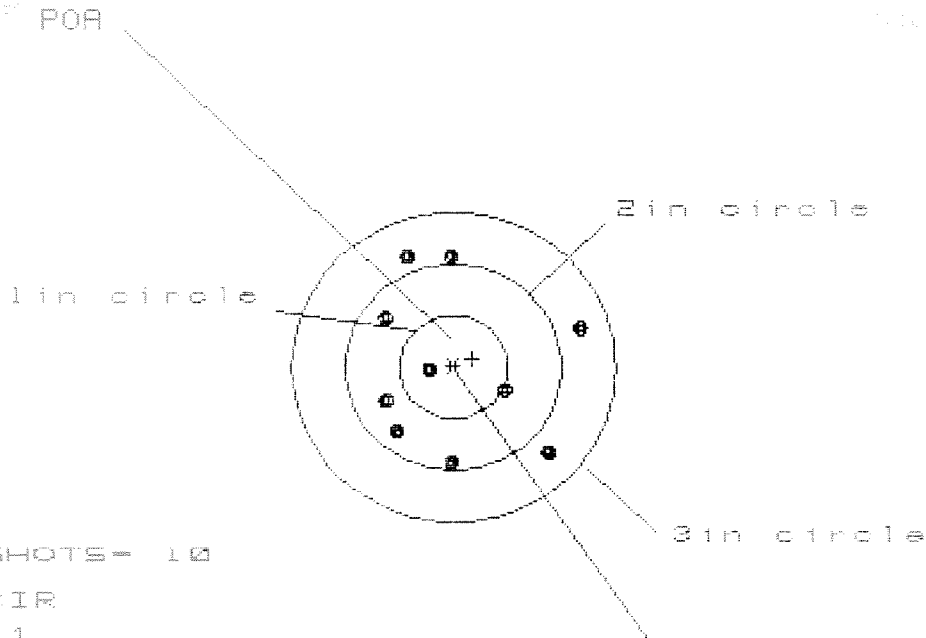
NUMBER IN THREE INCH CIRCLE =

9

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.798

VS= 1.987

GS= 2.251

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.161	1.038	.697
MINIMUM X	-.637	-.508	-.378
MAXIMUM Y	1.075	1.119	1.025
MINIMUM Y	-.912	-.868	-.962
CENTROID X	-.172	-.301	-.431
CENTROID Y	-.079	-.123	-.029
POA TO CENTROID in.	.190	.326	.432
MIN RADIUS	.216	.098	.065
MEAN RADIUS	.856	.786	.708
MAX RADIUS	1.226	1.280	1.043
HORIZONTAL SPREAD	1.798	1.546	1.075
VERTICAL SPREAD	1.987	1.987	1.987
EXTREME SPREAD	2.251	2.251	1.987
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C8635138

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.715

VS= 3.340

GS= 3.830

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.443	1.516	1.373
MINIMUM X	-1.272	-1.199	-1.342
MAXIMUM Y	1.488	1.193	.757
MINIMUM Y	-1.932	-1.082	-.932
CENTROID X	-.160	-.233	-.090
CENTROID Y	-.312	-.097	-.247
POA TO CENTROID in.	.351	.252	.263
MIN RADIUS	.325	.220	.366
MEAN RADIUS	1.138	1.005	.931
MAX RADIUS	2.041	1.652	1.420
HORIZONTAL SPREAD	2.715	2.715	2.715
VERTICAL SPREAD	3.340	2.275	1.689
EXTREME SPREAD	3.830	2.924	2.787
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		