

C6636156

MODEL 700TM M24

Model SWSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

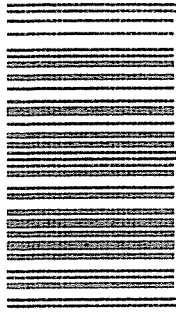
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO. C6636156	ORDER NO. 5716
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LPC



0 47700 25716 7



5716 C6636156

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636156

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof	QUALITY AUDIT	4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action		5 8 9 1	Kcd
	Magnaflux Bolt		5 8 9 1	Kcd
615	Rollmark Caliber		5 8 9 1	GB
617	Drill and Tap Sight Holes		5 15 9 1	LB
618	Polish Barrel		5 15 9 1	WB
620	Apply Coatings (Barrel Action)		5-31-91	
	Apply Coating (Bolt)		5-31-91	
625	Final Assembly A) Clean inside of Bolt Assembly		7/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/17/91	KS
	C) Inspect Ejector Hole for Chamfer		7/17/91	KS
	D) Oil Firing Pin Ass'y		7/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-19-91	

op. #		READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-19-91	JU
	G) Safety Off Force	4	4	4			7-19-91	JU
	H) Trigger Pull Test & Retainability						7-19-91	JU
	I) Firing Pin Indent	.0215	.022	.022			7-19-91	JU
	J) Assemble Stock						7/22/91	KJ
	K) Assemble Swivel Studs						7-26-91	N/H
	L) Attach Front and Rear Sight Assemblies						7/22/91	KJ
	M) Iron Sight Alignment						7/22/91	KJ
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	KJ
	O) Attach Scope to Rifle						7/22/91	KJ
	P) Detach & Attach Scope 20 Times						7/22/91	KJ
640	Gallery Target & Test						7/25/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						7/25/91	KJ
655	Final Inspection							
	A) Headspace						7-26-91	N/H
	B) Trigger Pull	2.35	2.26	2.27	2.35	2.36	7-26-91	JU
	C) Function						7-26-91	N/H
660	Pack						12-20-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6636156DATE 7-19-91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.48	2.38	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.42	2.30	2.26	
PULL #3	2.46	2.50	2.33	2.27	
PULL #4	2.52	2.53	2.44	2.35	
PULL #5	2.42	2.40	2.48	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.36		
PULL #2	3.27	3.40		
PULL #3	3.21	3.20		
PULL #4	3.21	3.38		
PULL #5	3.33	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.23		4.60
PULL #2	4.46	4.20		4.40
PULL #3	4.57	4.25		4.27
PULL #4	4.41	4.56		4.58
PULL #5	4.30	4.57		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636156
25 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.0403113
1 TO	2	.219313
1 TO	3	.286252
1 TO	4	.163518
1 TO	5	.25046

24
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0518
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0518015

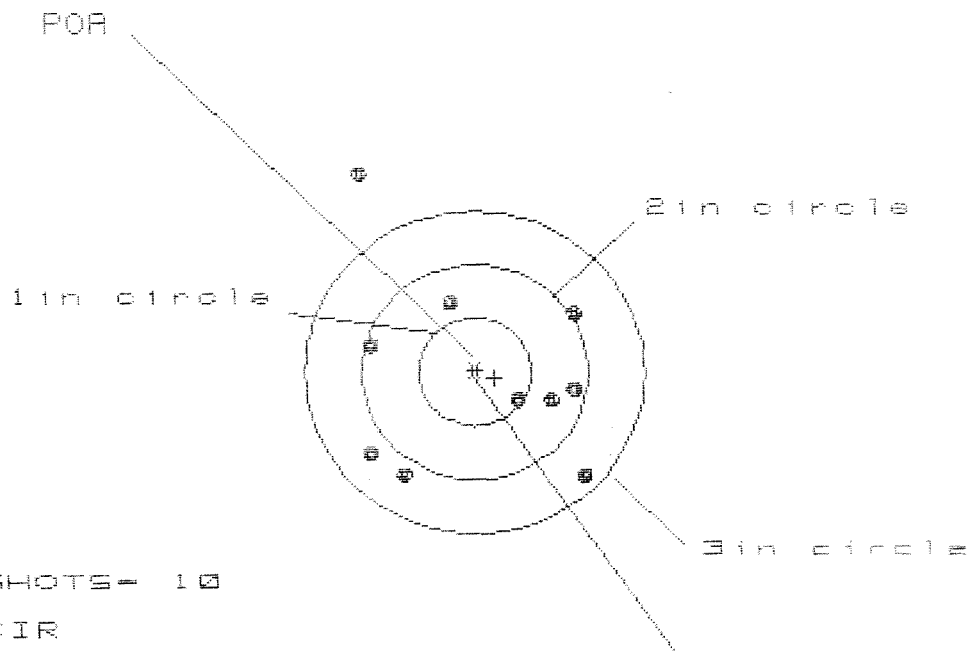
THE AMR FOR THIS RIFLE IS: .894

25 Jul 1991

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CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.030

VS= 2.814

GS= 3.413

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.957	.838	.848
MINIMUM X	:	-1.073	-1.031	-.926
MAXIMUM Y	:	1.823	.891	.801
MINIMUM Y	:	-.991	-.788	-.878
CENTROID X	:	-.175	-.056	-.161
CENTROID Y	:	.054	-.149	-.059
POA TO CENTROID in.	:	.183	.159	.171
MIN RADIUS	:	.468	.290	.411
MEAN RADIUS	:	1.047	.888	.870
MAX RADIUS	:	2.115	1.140	1.098
HORIZONTAL SPREAD	:	2.030	1.869	1.774
VERTICAL SPREAD	:	2.814	1.679	1.679
EXTREME SPREAD	:	3.413	2.193	2.155
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.224

VS = 4.362

GS = 4.387

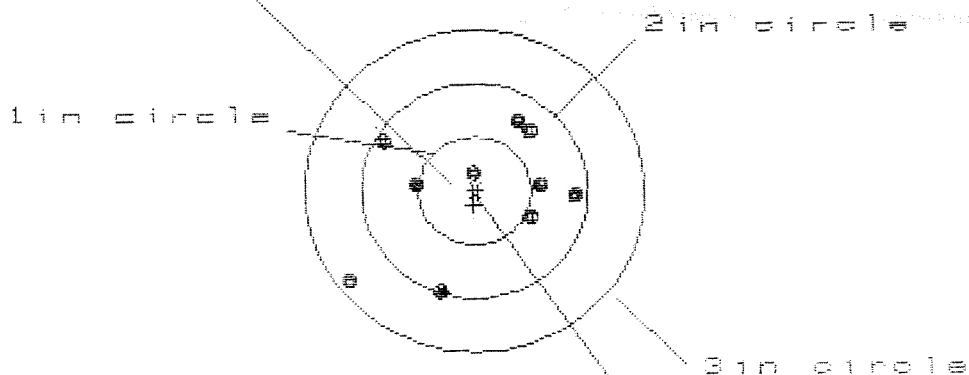
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.932	.702	.773
MINIMUM X	:	-1.292	-1.189	-1.118
MAXIMUM Y	:	1.679	1.381	.614
MINIMUM Y	:	-2.683	-.791	-.619
CENTROID X	:	.016	-.087	-.158
CENTROID Y	:	-.351	-.053	-.225
POA TO CENTROID in.	:	.351	.102	.275
MIN RADIUS	:	.212	.273	.325
MEAN RADIUS	:	.969	.750	.636
MAX RADIUS	:	2.840	1.493	1.126
HORIZONTAL SPREAD	:	2.224	1.891	1.891
VERTICAL SPREAD	:	4.362	2.172	1.233
EXTREME SPREAD	:	4.387	2.311	1.893
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS = 1.920

VS = 1.612

GS = 2.143

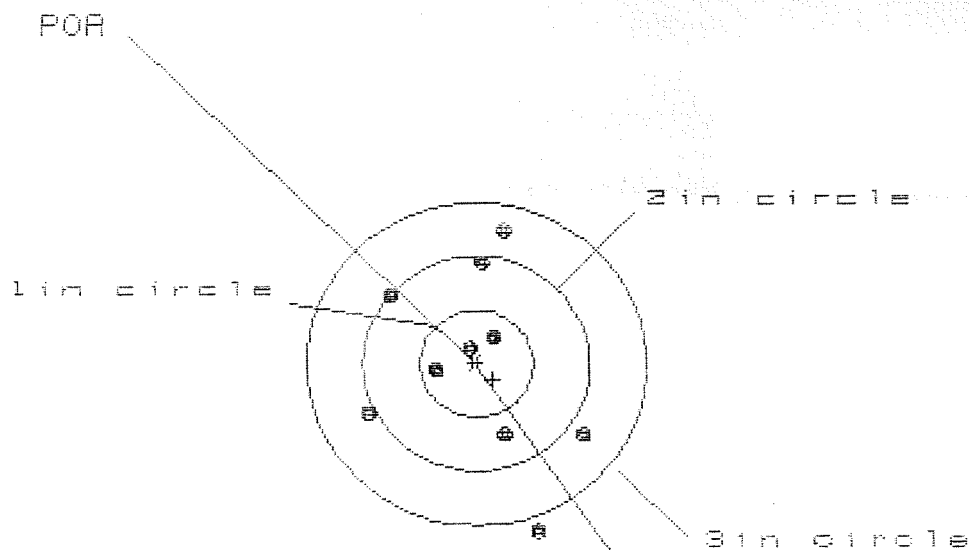
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.851	.733	.680
MINIMUM X	:	-1.069	-.891	-.944
MAXIMUM Y	:	.715	.620	.496
MINIMUM Y	:	-.897	-.992	-.490
CENTROID X	:	.015	.133	.185
CENTROID Y	:	.134	.229	.353
POR TO CENTROID in.	:	.135	.265	.399
MIN RADIUS	:	.221	.216	.234
MEAN RADIUS	:	.745	.649	.578
MAX RADIUS	:	1.368	1.077	.968
HORIZONTAL SPREAD	:	1.920	1.624	1.624
VERTICAL SPREAD	:	1.612	1.612	.986
EXTREME SPREAD	:	2.143	1.753	1.695
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.9008

VS= 2.824

GS= 2.842

CENTROID *

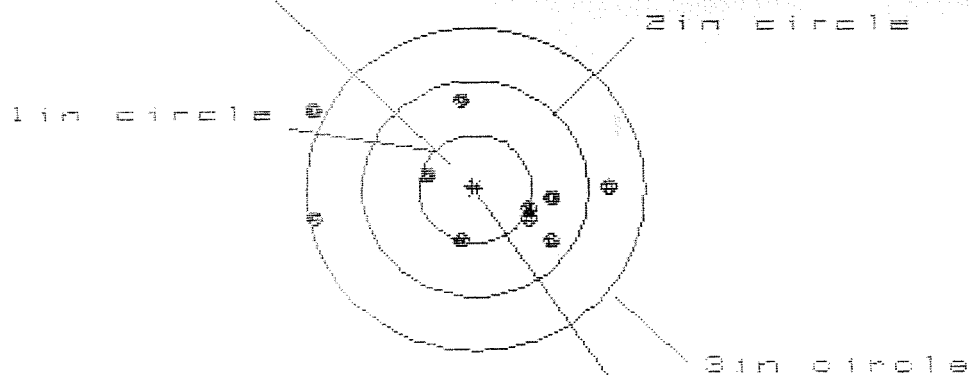
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.945	1.005	1.039
MINIMUM X	:	-.963	-.903	-.869
MAXIMUM Y	:	1.284	1.113	.881
MINIMUM Y	:	-1.540	-.805	-.666
CENTROID X	:	-.143	-.203	-.237
CENTROID Y	:	.154	.325	.186
POA TO CENTROID in.	:	.210	.383	.301
MIN RADIUS	:	.132	.082	.064
MEAN RADIUS	:	.859	.747	.690
MAX RADIUS	:	1.631	1.288	1.234
HORIZONTAL SPREAD	:	1.908	1.908	1.908
VERTICAL SPREAD	:	2.824	1.918	1.547
EXTREME SPREAD	:	2.842	2.184	2.184
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.552

VS = 1.325

GS = 2.611

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.129	.976	.779
MINIMUM X	-1.423	-1.576	-.790
MAXIMUM Y	.851	.929	.911
MINIMUM Y	-.474	-.396	-.414
CENTROID X	.028	.181	.378
CENTROID Y	-.029	-.107	-.089
POA TO CENTROID in.	.040	.210	.388
MIN RADIUS	.453	.328	.145
MEAN RADIUS	.850	.727	.564
MAX RADIUS	1.550	1.583	1.029
HORIZONTAL SPREAD	2.552	2.552	1.569
VERTICAL SPREAD	1.325	1.325	1.325
EXTREME SPREAD	2.611	2.561	1.574
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		