

C6225145

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

Model 700™ H24

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.
D6225145

ORDER NO.
5716

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225145

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	PFL.
	Magnaflux Bolt		9-14-88	PFL.
615	Rollmark Caliber		9-15-88	GS.
617	Drill & Tap Sight Holes		10/24	FB
618	Polish Barrel		10/24	WST
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		1/11/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/11/89	RW
	C) Inspect Ejector Hole for Chamfer		1/11/89	RW

OVER

OP.#	READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y	1/11/89	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake	9 Jan 89	JS
	F) Safety on Force	5 5 5 11 Jan 89	JS
	G) Safety off Force	3 3 3 11 Jan 89	JS
	H) Trigger Pull Test & Retainability	9 Jan 89	JS
	I) Firing Pin Indent	.022 .022 .022 11 Jan 89	JS
	J) Assemble Stock	1/11/89	RW
	K) Attach Front & Rear Sight Assemblies	1/11/89	RW
	L) Iron Sight Alignment	1/11/89	RW
	M) Detach Front & Rear Sights & place in numbered container	1/11/89	RW
	N) Attach Scope to Rifle	16 Jan 89	JS
	O) Detach & Attach Scope 20 times	16 Jan 89	JS
640	Gallery Target & Test	70 L 80 L 1-19-89	K
	A) Optical Clarity of Scope	OK 1-19-89	AC
645	Inspect for Live Ammo	NONE 1-19-89	AC
655	Final Inspection		
	A) Headspace	27 Jan 89	JS
	B) Trigger Pull	2.50 2.28 2.32 2.32 2.32	JS
	C) Function	27 Jan 89	JS
	D) Assemble Swivel Studs	27 Jan 89	JS
660	Pack	23 Jan 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225195

DATE 4/4/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.32	2.12	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.11	2.56	
PULL #3	2.29	2.16	2.58	
PULL #4	2.32	2.16	2.47	
PULL #5	2.30	2.20	2.50	
TOTAL	11.57	10.75	12.68	
AVG.	2.31	2.15	2.53	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.37	3.35	
PULL #2	3.39	3.38	
PULL #3	3.37	3.38	
PULL #4	3.41	3.40	
PULL #5	3.41	3.37	
TOTAL	16.95	16.88	
AVG.	3.39	3.37	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.37		
PULL #2	4.30	4.15		
PULL #3	4.33	4.41		
PULL #4	4.38	4.41		
PULL #5	4.39	4.39		
TOTAL	21.76	21.73		
AVG.	4.35	4.34		

Jan 20, 1989

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225145

CENTROIDAL DISTANCES

0 TO	1	.359089
1 TO	2	.233805
1 TO	3	.277651
1 TO	4	.721011
1 TO	5	.406203

 $\bar{x}$ $\bar{y}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0596
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0777956
THE AMR FOR THIS RIFLE IS: 1.026

28 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225145

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 1.645

VS= 2.740

CS= 3.055

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.070	.495	.475
MINIMUM X	:	-.575	-.456	-.476
MAXIMUM Y	:	1.297	1.136	.702
MINIMUM Y	:	-1.443	-1.485	-1.343
CENTROID X	:	.103	-.016	.004
CENTROID Y	:	-.344	-.183	-.325
POA TO CENTROID in.	:	.359	.184	.326
MIN RADIUS	:	.140	.019	.089
MEAN RADIUS	:	.717	.553	.480
MAX RADIUS	:	1.797	1.486	1.343
HORIZONTAL SPREAD	:	1.645	.951	.951
VERTICAL SPREAD	:	2.740	2.621	2.044
EXTREME SPREAD	:	3.055	2.631	2.089
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.135

VS= 2.470

GS= 3.148

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	1.641	1.455
MINIMUM X	:	-1.607	-1.494	-.640
MAXIMUM Y	:	1.486	1.035	1.071
MINIMUM Y	:	-.984	-.819	-.783
CENTROID X	:	-.078	-.191	-.005
CENTROID Y	:	-.196	-.361	-.397
POA TO CENTROID in.	:	.211	.408	.397
MIN RADIUS	:	.213	.149	.286
MEAN RADIUS	:	.991	.851	.792
MAX RADIUS	:	1.802	1.641	1.455
HORIZONTAL SPREAD	:	3.135	3.135	2.095
VERTICAL SPREAD	:	2.470	1.854	1.854
EXTREME SPREAD	:	3.148	3.148	2.152
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 5

HS= 3.436

VS= 2.907

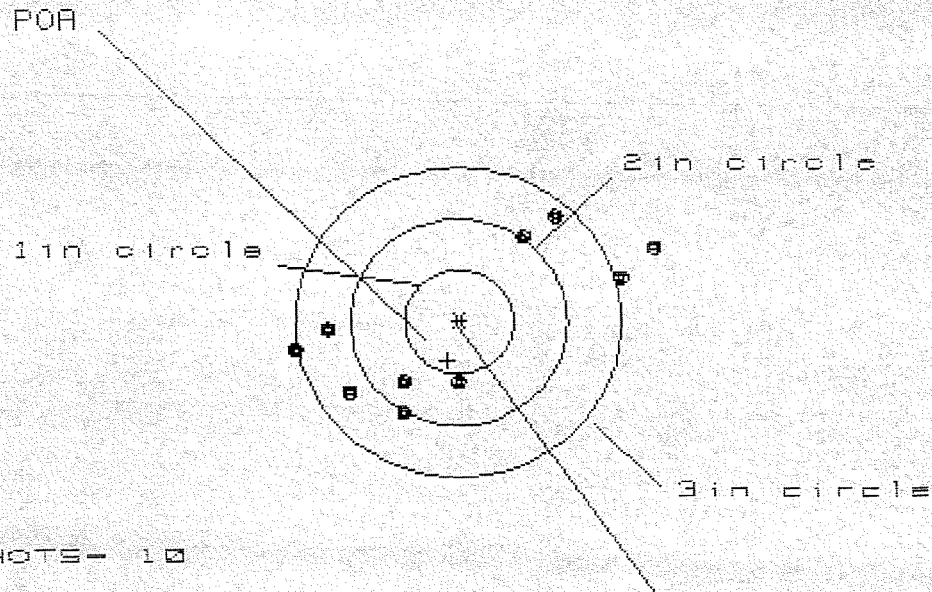
GS= 3.510

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.778	1.607	1.628
MINIMUM X	-1.658	-1.829	-1.628
MAXIMUM Y	1.734	1.603	1.537
MINIMUM Y	-1.173	-1.097	-1.163
CENTROID X	.260	.431	.230
CENTROID Y	-.115	.016	.082
POA TO CENTROID in.	.284	.431	.244
MIN RADIUS	.598	.523	.545
MEAN RADIUS	1.368	1.294	1.233
MAX RADIUS	1.936	1.871	1.693
HORIZONTAL SPREAD	3.436	3.436	2.656
VERTICAL SPREAD	2.907	2.700	2.700
EXTREME SPREAD	3.510	3.439	2.999
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		5	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 3.362

VS= 1.915

GS= 3.506

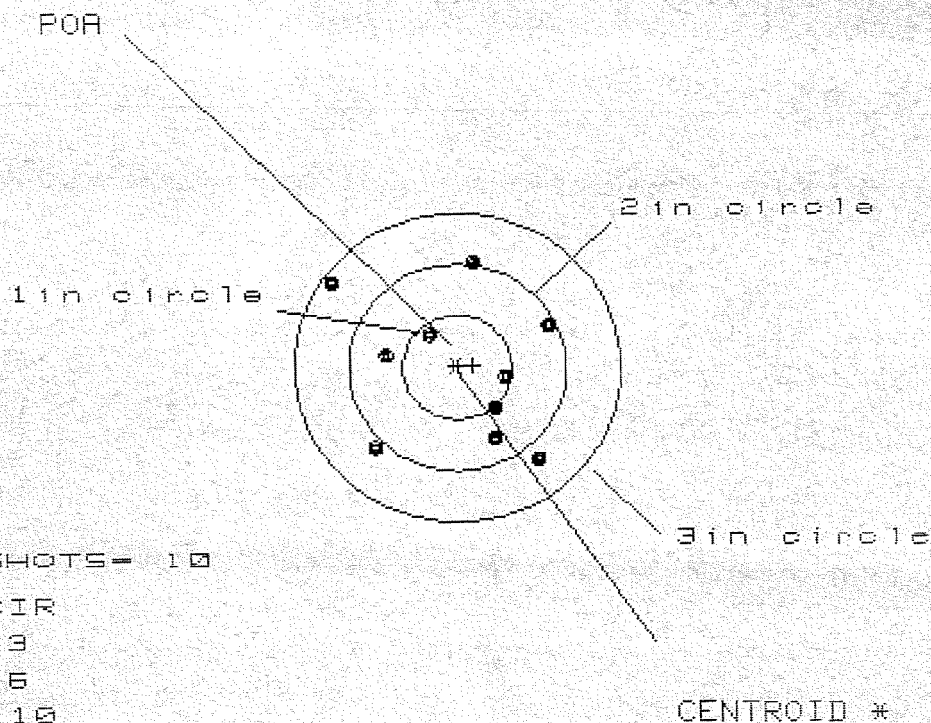
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.836	1.671	1.506
MINIMUM X	:	-1.526	-1.322	-1.141
MAXIMUM Y	:	1.055	1.133	1.106
MINIMUM Y	:	-.860	-.782	-.809
CENTROID X	:	.107	-.097	.068
CENTROID Y	:	.377	.299	.326
POA TO CENTROID in.	:	.392	.314	.333
MIN RADIUS	:	.588	.536	.536
MEAN RADIUS	:	1.220	1.090	1.073
MAX RADIUS	:	1.965	1.756	1.590
HORIZONTAL SPREAD	:	3.362	2.993	2.647
VERTICAL SPREAD	:	1.915	1.915	1.915
EXTREME SPREAD	:	3.506	3.087	2.728
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS = 1.933

VS = 1.871

GS = 2.518

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.808	.683	.760
MINIMUM X	-1.125	-.914	-.837
MAXIMUM Y	1.003	1.094	.997
MINIMUM Y	-.868	-.777	-.824
CENTROID X	-.142	-.017	-.094
CENTROID Y	-.020	-.111	-.014
POA TO CENTROID in.	.143	.113	.095
MIN RADIUS	.407	.320	.403
MEAN RADIUS	.832	.747	.719
MAX RADIUS	1.393	1.168	1.174
HORIZONTAL SPREAD	1.933	1.597	1.597
VERTICAL SPREAD	1.871	1.871	1.821
EXTREME SPREAD	2.518	2.042	2.042
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	