

C5649151

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington.

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

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

DUPONT

MODEL 700™ M24

SERIAL NO.
C6649161

ORDER NO.
5716

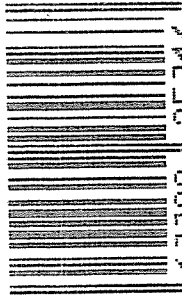
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649161

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6649161

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KJ
600	Proof		6/26/91	KJ
607	Check Headspace		6/26/91	KJ
610	Dis-assemble Gun		6/26/91	KJ
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		7-01	JA
	Apply Coating (Bolt)		8	JA
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	KJ
	C) Inspect Ejector Hole for Chamfer		8/27/91	KJ
	D) Oil Firing Pin Ass'y		8/27/91	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	KJ

op. #	BARBER, M24 0065505 OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	8/28/91	RL		
	G) Safety Off Force	3	3	3	8/28/91	RL		
	H) Trigger Pull Test & Retainability				8/28/91	RL		
	I) Firing Pin Indent	.0235	.0235	.0235	8/28/91	RL		
	J) Assemble Stock				8/28/91	RL		
	K) Assemble Swivel Studs				8-31-91	D/H		
	L) Attach Front and Rear Sight Assemblies				8/28/91	RL		
	M) Iron Sight Alignment				8/28/91	RL		
	N) Detach Front & Rear Sights & place in numbered container				8/28/91	RL		
	O) Attach Scope to Rifle				8/28/91	RL		
	P) Detach & Attach Scope 20 Times				8/28/91	RL		
640	Gallery Target & Test				8/28/91	D/H		
	A) Time				8-29-91	D/H		
	B) Malfunctions				8-29-91	D/H		
	C) Pierced Primers				8-29-91	D/H		
	D) Optical Clarity of Scope				8-29-91	D/H		
645	Inspect for Live Ammo				8-29-91	D/H		
655	Final Inspection							
	A) Headspace				8-31-91	D/H		
	B) Trigger Pull	2.24	2.26	2.27	2.30	2.28	8-29-91	D/H
	C) Function						8-31-91	D/H
660	Pack						9-18-91	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649161

DATE 8/28/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.33	2.50	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.35	2.48	2.26	
PULL #3	2.34	2.41	2.40	2.27	
PULL #4	2.66	2.44	2.44	2.30	
PULL #5	2.56	2.31	2.40	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.34		
PULL #2	3.48	3.36		
PULL #3	3.50	3.41		
PULL #4	3.47	3.39		
PULL #5	3.21	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.59		4.63
PULL #2	4.55	4.45		4.65
PULL #3	4.57	4.53		4.63
PULL #4	4.64	4.20		4.65
PULL #5	4.64	4.57		4.61
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649161
29 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.206693
1 TO 2	.157318
1 TO 3	.120104
1 TO 4	.282113
1 TO 5	.153013



(----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1384
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0786
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .157426
THE AMR FOR THIS RIFLE IS: .9604

25 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/086491B1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 6

3in = 10

HS = 2.519

VS = 1.924

GS = 2.703

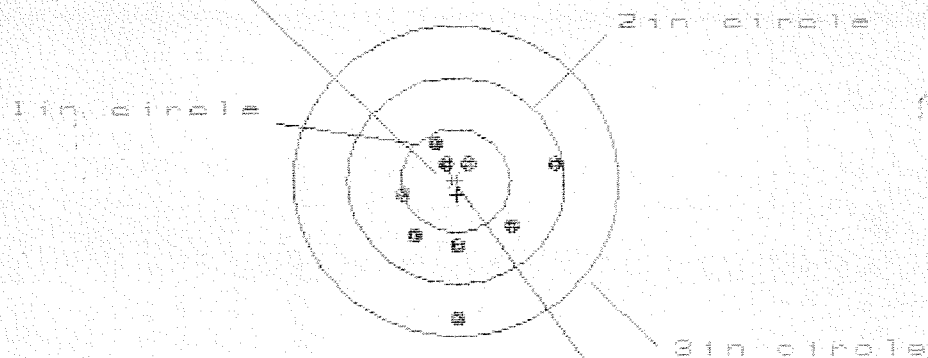
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.306	1.102	.969
MINIMUM X	-1.213	-1.068	-.674
MAXIMUM Y	1.222	1.158	1.201
MINIMUM Y	-.702	-.766	-.723
CENTROID X	-.169	-.314	-.181
CENTROID Y	.119	.183	.140
POA TO CENTROID in.	.207	.364	.229
MIN RADIUS	.943	.479	.553
MEAN RADIUS	.955	.889	.856
MAX RADIUS	1.426	1.247	1.245
HORIZONTAL SPREAD	2.519	2.170	1.643
VERTICAL SPREAD	1.924	1.924	1.924
EXTREME SPREAD	2.703	2.207	2.161
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849161

CENTERFIRE PATTERNS # 2

POR



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 9

HS = 1.485

VS = 3.579

GS = 3.602

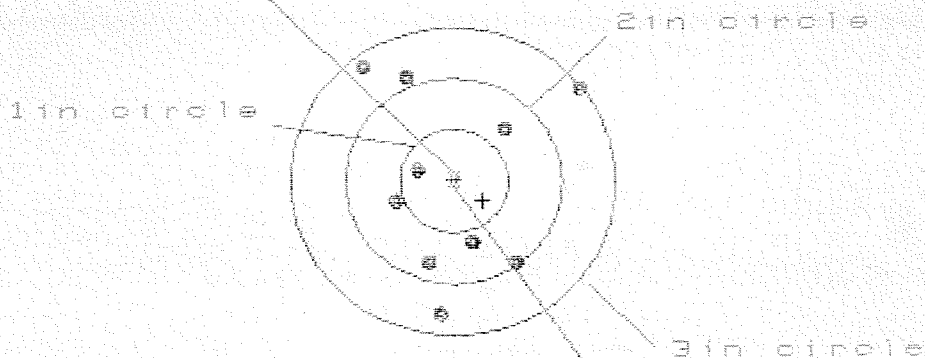
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.955	.913	.911
MINIMUM X	-.530	-.572	-.574
MAXIMUM Y	2.221	.573	.434
MINIMUM Y	-1.358	-1.112	-.543
CENTROID X	-.012	.030	.031
CENTROID Y	.129	-.117	.022
POR TO CENTROID in.	.130	.121	.038
MIN RADIUS	.192	.395	.262
MEAN RADIUS	.784	.619	.536
MAX RADIUS	2.252	1.112	.950
HORIZONTAL SPREAD	1.485	1.485	1.485
VERTICAL SPREAD	3.579	1.685	.977
EXTREME SPREAD	3.602	1.701	1.525
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

29 Aug 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.022

VS = 2.410

GS = 2.579

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.197	.731	.644
MINIMUM X	-.825	-.692	-.446
MAXIMUM Y	1.120	1.221	1.253
MINIMUM Y	-1.290	-1.189	-1.036
CENTROID X	-.268	-.401	-.314
CENTROID Y	.187	.086	-.067
POA TO CENTROID in.	.326	.410	.321
MIN RADIUS	.370	.329	.419
MEAN RADIUS	.923	.834	.744
MAX RADIUS	1.501	1.404	1.297
HORIZONTAL SPREAD	2.022	1.423	1.090
VERTICAL SPREAD	2.410	2.410	2.289
EXTREME SPREAD	2.579	2.501	2.300
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

29 Aug 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.937

VS= 1.804

GS= 2.978

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.081

.875

.714

MINIMUM X

-1.856

-1.283

-1.006

MAXIMUM Y

1.068

1.059

.992

MINIMUM Y

-.737

-.745

-.822

CENTROID X

-.217

-.011

.150

CENTROID Y

-.159

-.150

-.073

POA TO CENTROID in.

.269

.151

.166

MIN RADIUS

.171

.060

.207

MEAN RADIUS

.941

.796

.707

MAX RADIUS

1.857

1.426

1.028

HORIZONTAL SPREAD

2.937

2.158

1.721

VERTICAL SPREAD

1.804

1.804

1.804

EXTREME SPREAD

2.978

2.392

1.814

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

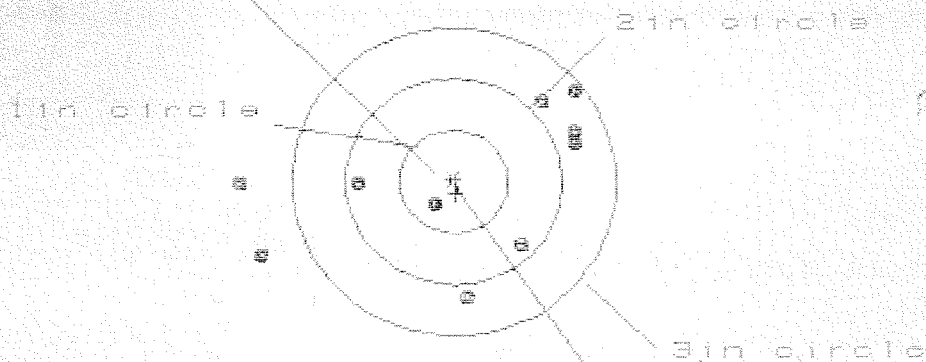
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FILE:/PATTERNING/CENTERFIRE_PATT/C6649161

CENTERFIRE PATTERNS # 5

POR



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 3.071

VS= 2.005

GS= 3.379

CENTROID +

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.132
MINIMUM X	-1.939
MAXIMUM Y	.911
MINIMUM Y	-1.094
CENTROID X	-.016
CENTROID Y	.117
POR TO CENTROID in.	.118
MIN RADIUS	.304
MEAN RADIUS	1.199
MAX RADIUS	1.962
HORIZONTAL SPREAD	3.071
VERTICAL SPREAD	2.005
EXTREME SPREAD	3.379
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8