

C6349136

MODEL 700TM M24

Model SWSTM

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

Remington[®]


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

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

MODEL 700 TM N24	SERIAL NO. C6349136
	ORDER NO. 5716

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

01



5716 C6349136



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349136

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	Rw
600	Proof	3 31	90	Rw
607	Check Headspace	3 31	90	Rw
610	Dis-assemble Gun	3 31	90	Rw
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		SL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	Rw
	C) Inspect Ejector Hole for Chamfer		4/18/90	Rw
	D) Oil Firing Pin Ass'y		4/18/90	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		4/30/90	SL

BARBER - M24 0108531		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			4/30/90	90
	G) Safety Off Force	3	3	3			4/30/90	90
	H) Trigger Pull Test & Retainability						4/30/90	90
	I) Firing Pin Indent	.0215	.0215	.0215			4/30/90	90
	J) Assemble Stock						5/4/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						5/4/90	RW
	M) Iron Sight Alignment						5/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/4/90	RW
	O) Attach Scope to Rifle						5/4/90	90
	P) Detach & Attach Scope 20 Times						5/4/90	90
640	Gallery Target & Test						5-7-90	DH
	A) Time						5-7-90	DH
	B) Malfunctions						5-7-90	DH
	C) Pierced Primers						5-7-90	DH
	D) Optical Clarity of Scope						5-7-90	DH
645	Inspect for Live Ammo						5-7-90	DH
655	Final Inspection						5/8/90	WB
	A) Headspace							
	B) Trigger Pull	2.33	2.33	2.38	2.34	2.28	5/7/90	WB
	C) Function						5/8/90	WB
660	Pack						6-20-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06349136

DATE 4/30/90

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.55	2.58	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.52	2.47	2.33	
PULL #3	2.44	2.46	2.44	2.38	
PULL #4	2.45	2.50	2.52	2.34	
PULL #5	2.49	2.41	2.56	2.28	
TOTAL	12.26	12.44	12.57		
AVG.	2.452	2.488	2.504		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.27		
PULL #2	3.57	3.33		
PULL #3	3.54	3.47		
PULL #4	3.52	3.15		
PULL #5	3.55	3.41		
TOTAL	17.75	16.63		
AVG.	3.55	3.326		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.43		4.49
PULL #2	4.22	4.38		4.51
PULL #3	4.25	4.55		4.48
PULL #4	4.26	4.43		4.44
PULL #5	4.36	4.20		4.54
TOTAL	21.62	21.99		22.46
AVG.	4.324	4.398		4.492

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349136
7 May 1990

CENTROIDAL DISTANCES

0 TO	1	.204384
1 TO	2	.466357
1 TO	3	.18544
1 TO	4	.868079
1 TO	5	.167672

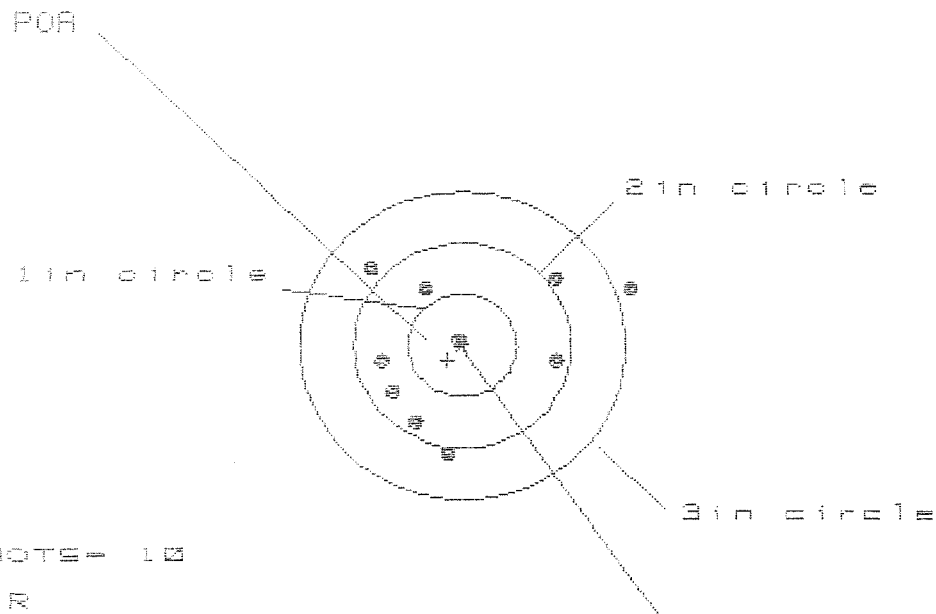
27¹⁸ 9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2958
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1522
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .33266
THE AMR FOR THIS RIFLE IS: .8314

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349136

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.425

VS= 1.809

GS= 2.430

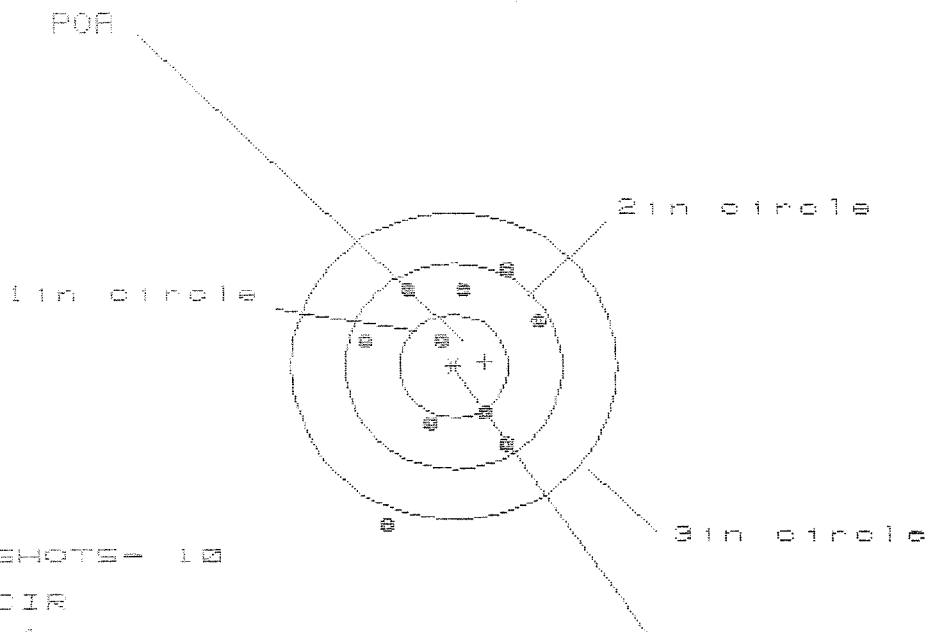
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.541	1.059	.970
MINIMUM X	-.884	-.713	-.648
MAXIMUM Y	.718	.780	.856
MINIMUM Y	-1.091	-1.029	-.931
CENTROID X	.142	-.029	.060
CENTROID Y	.147	.085	-.013
POA TO CENTROID in.	.205	.089	.062
MIN RADIUS	.034	.175	.197
MEAN RADIUS	.896	.793	.762
MAX RADIUS	1.640	1.261	1.256
HORIZONTAL SPREAD	2.425	1.772	1.618
VERTICAL SPREAD	1.809	1.809	1.787
EXTREME SPREAD	2.430	2.049	2.049
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06345136

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HSI = 1.610

VS = 2.498

GS = 2.736

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.829

.763

.820

MINIMUM X

:

-.781

-.847

-.790

MAXIMUM Y

:

.903

.725

.704

MINIMUM Y

:

-1.595

-.922

-.831

CENTROID X

:

-.283

-.217

-.274

CENTROID Y

:

-.045

.133

.042

POA TO CENTROID in.:

.287

.254

.277

MIN RADIUS

:

.243

.183

.178

MEAN RADIUS

:

.845

.729

.706

MAX RADIUS

:

1.703

1.806

.949

HORIZONTAL SPREAD :

1.610

1.610

1.610

VERTICAL SPREAD :

2.498

1.647

1.535

EXTREME SPREAD :

2.736

1.742

1.742

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

8

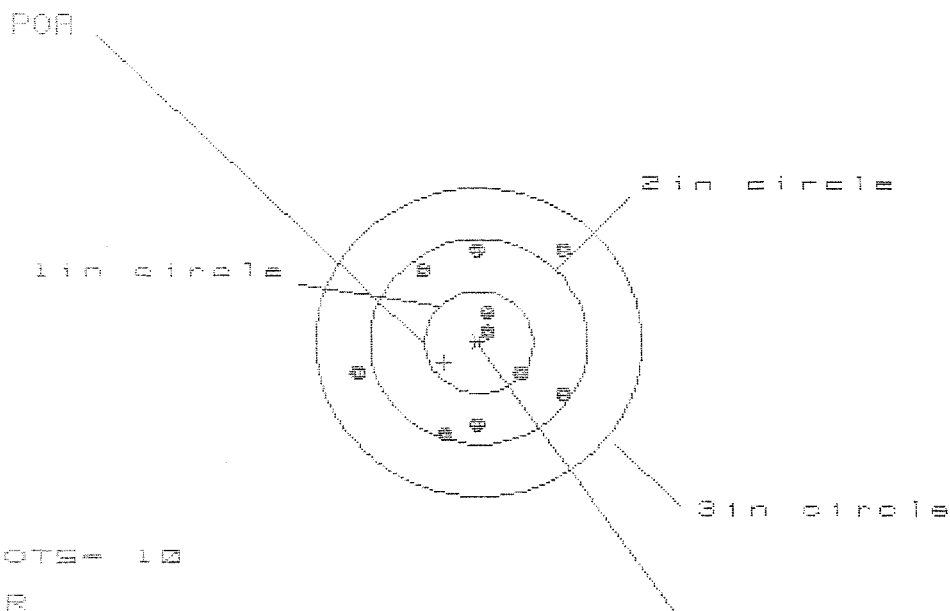
NUMBER IN THREE INCH CIRCLE =

9

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349136

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HSE = 1.879

VSE = 1.881

GSE = 2.270

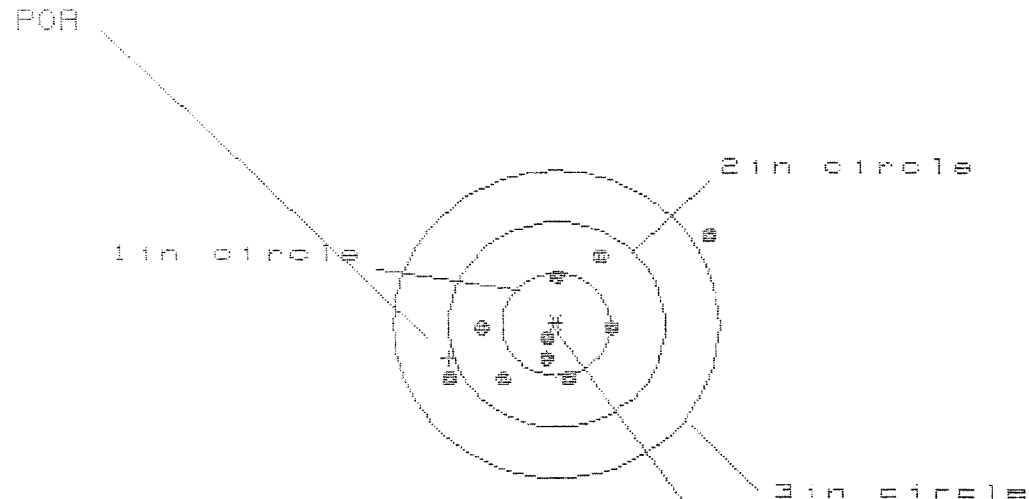
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.780	.866	.739
MINIMUM X	-1.099	-1.013	-.563
MAXIMUM Y	.945	.983	.953
MINIMUM Y	-.936	-.831	-.861
CENTROID X	.320	.234	.361
CENTROID Y	.199	.094	.124
POA TO CENTROID in.	.377	.253	.382
MIN RADIUS	.080	.215	.143
MEAN RADIUS	.781	.744	.682
MAX RADIUS	1.219	1.041	.973
HORIZONTAL SPREAD	1.879	1.879	1.302
VERTICAL SPREAD	1.881	1.814	1.814
EXTREME SPREAD	2.270	1.887	1.852
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349136

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 2.408

VS = 1.388

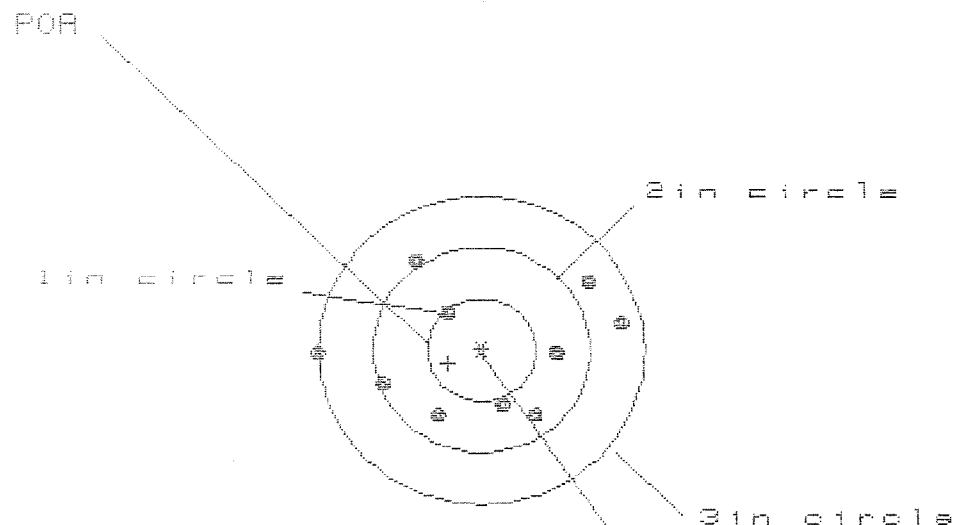
GS = 2.775

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.416	.632	.528
MINIMUM X	-.993	-.836	-.683
MAXIMUM Y	.851	.781	.727
MINIMUM Y	-.537	-.443	-.497
CENTROID X	.991	.834	.938
CENTROID Y	.328	.234	.288
POA TO CENTROID in.	1.044	.866	.982
MIN RADIUS	.160	.101	.105
MEAN RADIUS	.704	.571	.522
MAX RADIUS	1.652	.947	.845
HORIZONTAL SPREAD	2.409	1.468	1.211
VERTICAL SPREAD	1.388	1.224	1.224
EXTREME SPREAD	2.775	1.831	1.509
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349136

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HE = 2.812

VS = 1.507

GS = 2.828

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.321	1.155	.942
MINIMUM X	-1.491	-1.039	-.895
MAXIMUM Y	.831	.832	.872
MINIMUM Y	-.676	-.675	-.635
CENTROID X	.309	.475	.331
CENTROID Y	.132	.131	.091
POA TO CENTROID in.	.336	.493	.343
MIN RADIUS	.480	.487	.525
MEAN RADIUS	.931	.858	.804
MAX RADIUS	1.491	1.198	1.203
HORIZONTAL SPREAD	2.812	2.194	1.837
VERTICAL SPREAD	1.507	1.507	1.507
EXTREME SPREAD	2.828	2.287	2.109
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		