

C6498744

MODEL 700TM M24

Model SWSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington




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

MODEL 700™ M24

SERIAL NO.
C6498744

ORDER NO.
5716

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



5716 C6498744

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498744

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9 90		RW
600	Proof	5 9 90		RW
607	Check Headspace	5 9 90		RW
610	Dis-assemble Gun	5 9 90		RW
612	Magnaflux Barrel Action	5-15-90		KER
	Magnaflux Bolt	5-15-90		KER
615	Rollmark Caliber	5-15-90		GS
617	Drill and Tap Sight Holes		5/17/90	LOS
618	Polish Barrel RB		5/17/90	LOS
620	Apply Coatings (Barrel Action)		5-25-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/90	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			5/29/90	WB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			5/29/90	WB
	H) Trigger Pull Test & Retainability						5/29/90	JL
	I) Firing Pin Indent	.024	.0233	.0235			5/29/90	WB
	J) Assemble Stock						5/30/90	RW
	K) Assemble Swivel Studs						6-6-90	JH
	L) Attach Front and Rear Sight Assemblies						5/30/90	RW
	M) Iron Sight Alignment						5/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/30/90	RW
	O) Attach Scope to Rifle						5/30/90	WB
	P) Detach & Attach Scope 20 Times						5/30/90	WB
640	Gallery Target & Test						5-30-90	AC
	A) Time						5-30-90	AC
	B) Malfunctions						5-30-90	AC
	C) Pierced Primers						5-30-90	AC
	D) Optical Clarity of Scope						5-30-90	AC
645	Inspect for Live Ammo						5-30-90	AC
655	Final Inspection							
	A) Headspace						6-8-90	JH
	B) Trigger Pull	237	214	224	207	212	6-6-90	JH
	C) Function						6-6-90	JH
660	Pack						6-19-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6498744

DATE 5/24/90

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.52	2.35	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.33	2.30	2.14	
PULL #3	2.49	2.43	2.40	2.24	
PULL #4	2.58	2.50	2.31	2.07	
PULL #5	2.54	2.40	2.42	2.12	
TOTAL	12.30	12.18	11.78		
AVG.	2.46	2.436	2.356		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.33		
PULL #2	3.39	3.29		
PULL #3	3.40	3.29		
PULL #4	3.58	3.31		
PULL #5	3.16	3.33		
TOTAL	16.93	16.55		
AVG.	3.386	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.38		4.34
PULL #2	4.26	4.13		4.44
PULL #3	4.21	4.31		4.36
PULL #4	4.09	4.12		4.37
PULL #5	4.32	4.37		4.44
TOTAL	21.03	21.31		21.95
AVG.	4.206	4.262		4.39

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498744
31 May 1990

CENTROIDAL DISTANCES

Ø TO	1	.695794
1 TO	2	.511211
1 TO	3	.418374
1 TO	4	.309982
1 TO	5	.537624

5.1
+2 (----FOR

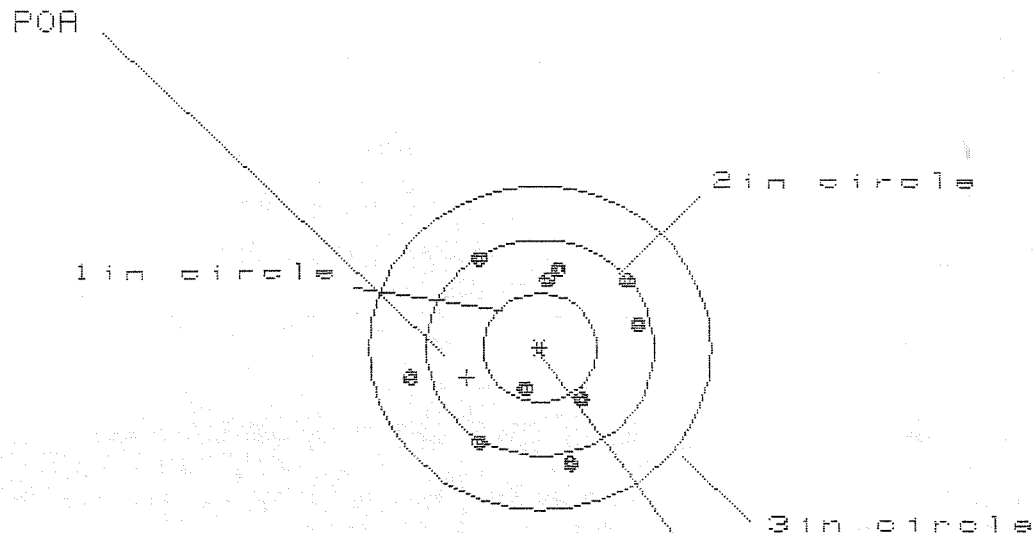
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2606
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .407593
THE AMR FOR THIS RIFLE IS: .8464

31 May 1980

FILE:/PATTERNING/CENTERFIRE_PATT/C8438744

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 2.000

VS= 1.870

GS= 2.111

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.838	.709	.720
MINIMUM X	-1.162	-.695	-.684
MAXIMUM Y	.804	.770	.632
MINIMUM Y	-1.066	-1.100	-.998
CENTROID X	.640	.769	.758
CENTROID Y	.273	.307	.445
POA TO CENTROID in.	.696	.828	.879
MIN RADIUS	.391	.493	.476
MEAN RADIUS	.850	.798	.743
MAX RADIUS	1.202	1.104	1.185
HORIZONTAL SPREAD	2.000	1.404	1.404
VERTICAL SPREAD	1.870	1.870	1.630
EXTREME SPREAD	2.111	2.028	1.933
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

31 May 1998

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CENTERFIRE PATTERNS

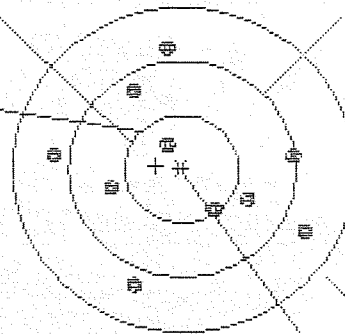
2

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.193

VS= 2.158

GS= 2.314

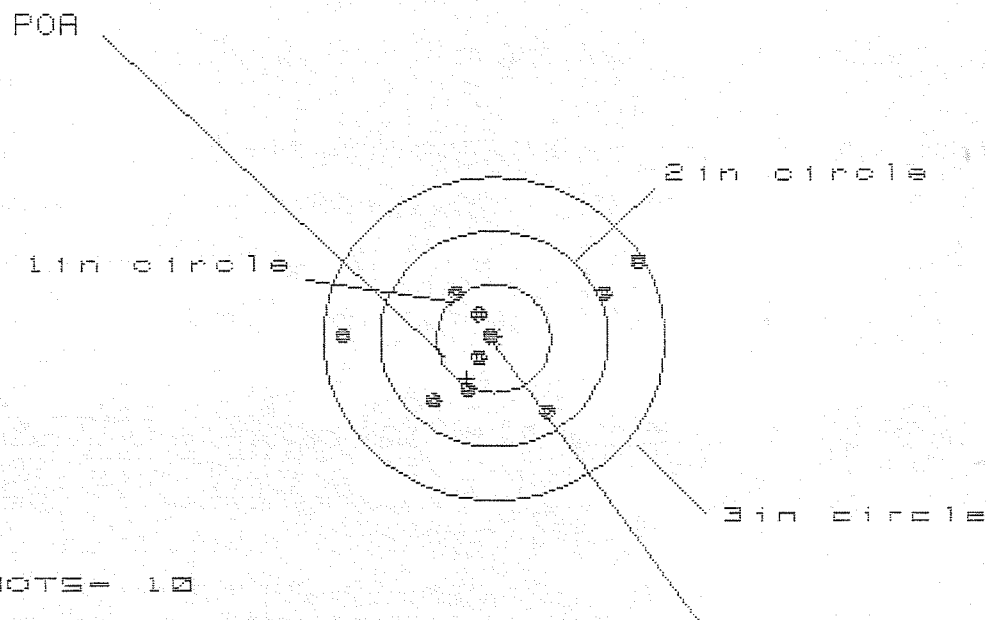
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.113	1.055	1.052
MINIMUM X	:	-1.080	-.956	-.959
MAXIMUM Y	:	1.133	1.069	.840
MINIMUM Y	:	-1.025	-1.089	-.955
CENTROID X	:	.229	.105	.108
CENTROID Y	:	-.031	.033	-.101
POA TO CENTROID in.	:	.231	.110	.148
MIN RADIUS	:	.290	.205	.338
MEAN RADIUS	:	.843	.787	.749
MAX RADIUS	:	1.251	1.140	1.065
HORIZONTAL SPREAD	:	2.193	2.011	2.011
VERTICAL SPREAD	:	2.158	2.158	1.795
EXTREME SPREAD	:	2.314	2.180	2.012
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

31 May 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.600

VS= 1.406

GS= 2.698

CENTROID *

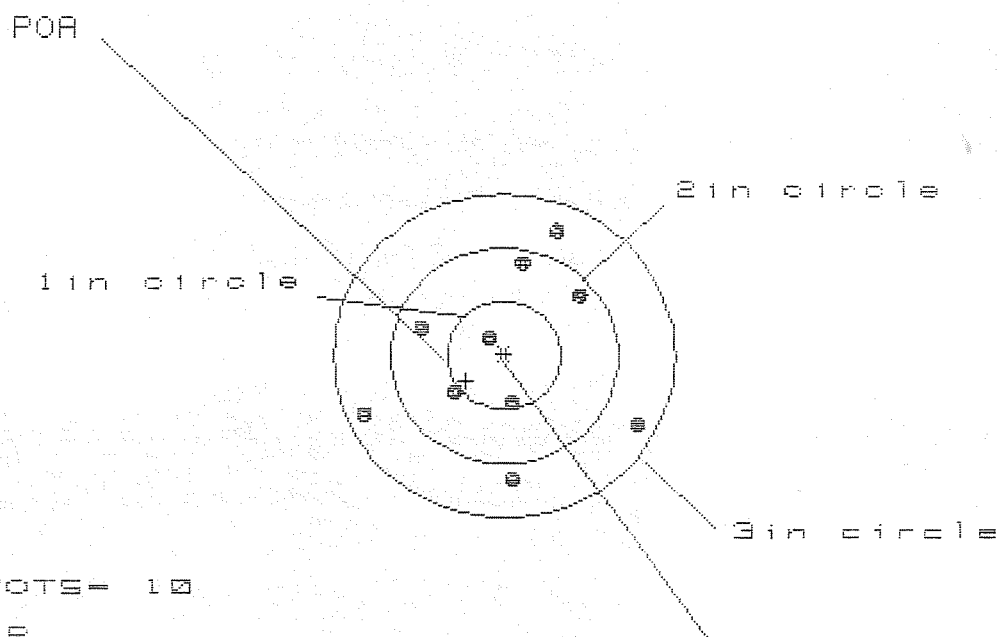
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.247	1.099	.948
MINIMUM X	-1.353	-1.215	-.542
MAXIMUM Y	.756	.525	.540
MINIMUM Y	-.650	-.566	-.551
CENTROID X	.234	.096	.248
CENTROID Y	.374	.290	.275
POA TO CENTROID in.	.441	.305	.370
MIN RADIUS	.004	.127	.100
MEAN RADIUS	.707	.610	.538
MAX RADIUS	1.458	1.221	1.091
HORIZONTAL SPREAD	2.600	2.314	1.490
VERTICAL SPREAD	1.406	1.091	1.091
EXTREME SPREAD	2.698	2.349	1.794
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

31 May 1998

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.343

VS= 2.299

GS= 2.379

CENTROID #

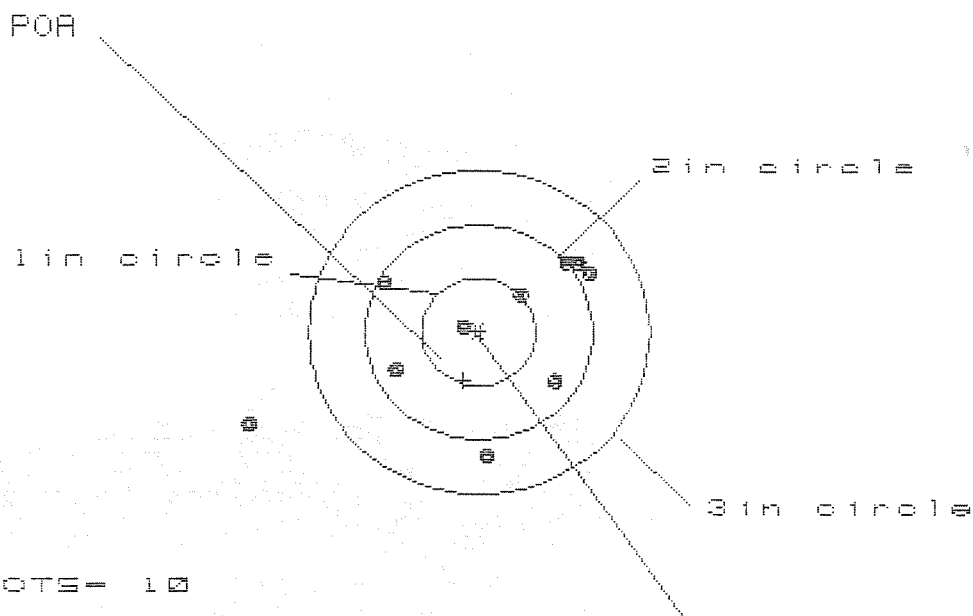
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.147	.770	.637
MINIMUM X	:	-1.196	-1.069	-.785
MAXIMUM Y	:	1.162	1.095	1.025
MINIMUM Y	:	-1.137	-1.204	-1.274
CENTROID X	:	.332	.205	.338
CENTROID Y	:	.238	.305	.375
POA TO CENTROID in.	:	.409	.367	.505
MIN RADIUS	:	.212	.101	.140
MEAN RADIUS	:	.870	.802	.754
MAX RADIUS	:	1.295	1.269	1.276
HORIZONTAL SPREAD	:	2.343	1.839	1.422
VERTICAL SPREAD	:	2.299	2.299	2.299
EXTREME SPREAD	:	2.379	2.379	2.342
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

31 May 1998

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CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.059

VS= 1.791

GS= 3.338

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.978	.747	.722
MINIMUM X	:	-2.081	-1.043	-1.068
MAXIMUM Y	:	.691	.598	.449
MINIMUM Y	:	-1.100	-1.193	-.646
CENTROID X	:	.132	.363	.388
CENTROID Y	:	.449	.542	.691
POA TO CENTROID in.	:	.468	.653	.793
MIN RADIUS	:	.114	.311	.187
MEAN RADIUS	:	.962	.784	.706
MAX RADIUS	:	2.243	1.209	1.104
HORIZONTAL SPREAD	:	3.059	1.790	1.790
VERTICAL SPREAD	:	1.791	1.791	1.095
EXTREME SPREAD	:	3.338	1.929	1.864
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	