

C6587547

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



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

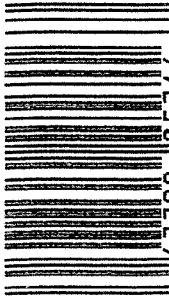
MODEL 700TM H24

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

SERIAL NO. C6587547	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.

UPC



0 47700 25716 7



5716 C6587547

OK
Test

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587547

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KA
600	Proof		10/22/90	KA
607	Check Headspace		10/22/90	KA
610	Dis-assemble Gun		10/22/90	KA
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes		10/29/90	FB
618	Polish Barrel <i>RoB</i>		10/30/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/28/90	JA

op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	4	4	4	11/29/90	WB	
	G) Safety Off Force	2 1/2	2 3/4	2 1/2	11/29/90	WB	
	H) Trigger Pull Test & Retainability				11-29-90	HL	
	I) Firing Pin Indent	.0205	.0215	.021	11/29/90	WB	
	J) Assemble Stock				11/30/90	KS	
	K) Assemble Swivel Studs				12-4-90	JS	
	L) Attach Front and Rear Sight Assemblies				11/30/90	KS	
	M) Iron Sight Alignment				11/30/90	KS	
	N) Detach Front & Rear Sights & place in numbered container				11/30/90	KS	
	O) Attach Scope to Rifle				11/30/90	KS	
	P) Detach & Attach Scope 20 Times				11/30/90	KS	
640	Gallery Target & Test				12/1/90	NF	
	A) Time				"	NF	
	B) Malfunctions				"	NF	
	C) Pierced Primers				"	NF	
	D) Optical Clarity of Scope				"	NF	
645	Inspect for Live Ammo				12/1/90	NF	
655	Final Inspection						
	A) Headspace				12-4-90	JS	
	B) Trigger Pull	270	269	268	271 273	12-4-90	JS
	C) Function				12-4-90	JS	
660	Pack				12-18-90	DH	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6587547
DATE 11/28/90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.26	2.33	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.32	2.30	2.69	
PULL #3	2.26	2.30	2.31	2.68	
PULL #4	2.24	2.31	2.30	2.71	
PULL #5	2.24	2.29	2.31	2.73	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.31		
PULL #2	3.10	3.36		
PULL #3	3.23	3.34		
PULL #4	3.11	3.37		
PULL #5	3.27	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	- RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.43		4.35
PULL #2	4.41	4.38		4.39
PULL #3	4.28	4.39		4.39
PULL #4	4.37	4.46		4.22
PULL #5	4.41	4.36		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587547
1 Dec 1998

CENTROIDAL DISTANCES

0 TO	1	.344859
1 TO	2	.293886
1 TO	3	.289415
1 TO	4	.897287
1 TO	5	.345326

1g
3g
+ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0516
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0668
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0844085

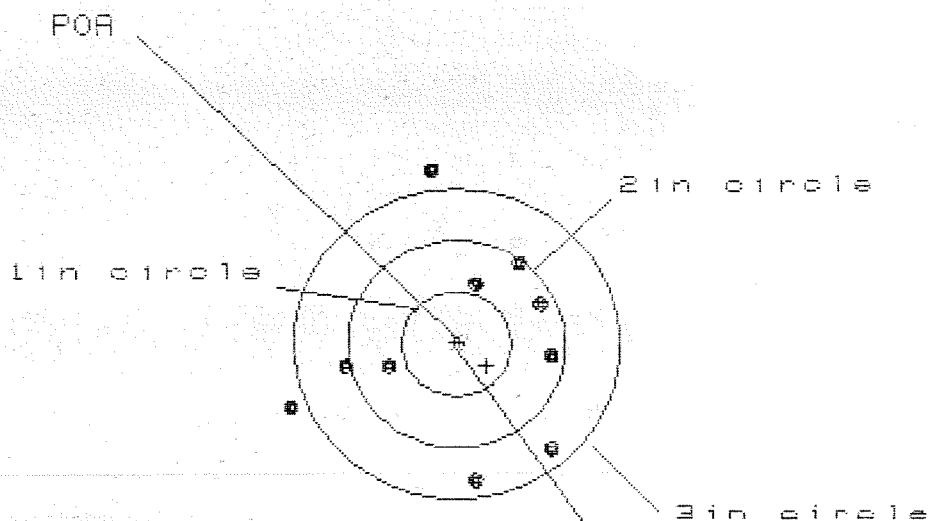
THE AMR FOR THIS RIFLE IS: .8714

1 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08587547

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.450

VS= 2.920

GS= 2.943

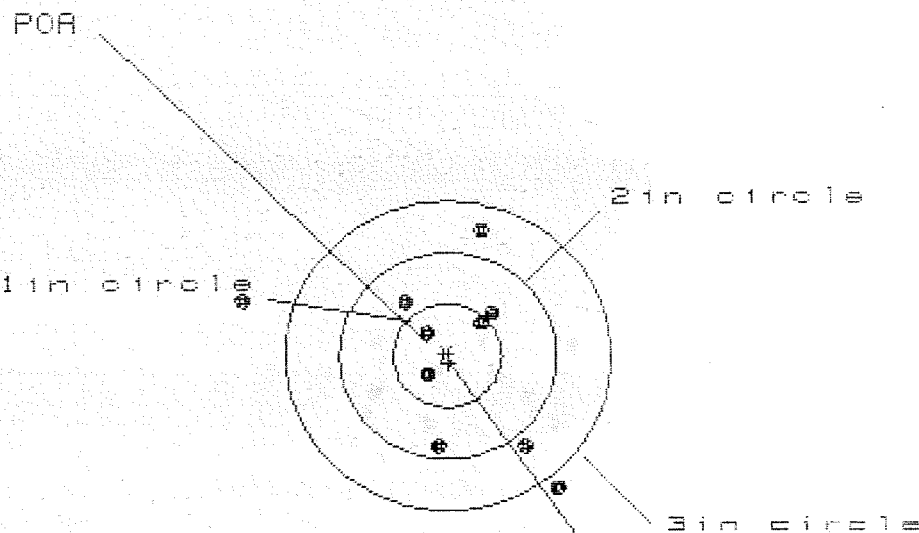
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.716	.666
MINIMUM X	-1.561	-1.187	-1.237
MAXIMUM Y	1.639	1.574	.883
MINIMUM Y	-1.281	-1.346	-1.149
CENTROID X	-.272	-.099	-.049
CENTROID Y	.212	.277	.080
POA TO CENTROID in.	.345	.294	.094
MIN RADIUS	.627	.567	.600
MEAN RADIUS	1.092	1.002	.923
MAX RADIUS	1.667	1.624	1.241
HORIZONTAL SPREAD	2.450	1.903	1.903
VERTICAL SPREAD	2.920	2.920	2.032
EXTREME SPREAD	2.943	2.943	2.082
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

1 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587547

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.845

VS= 2.450

GS= 3.353

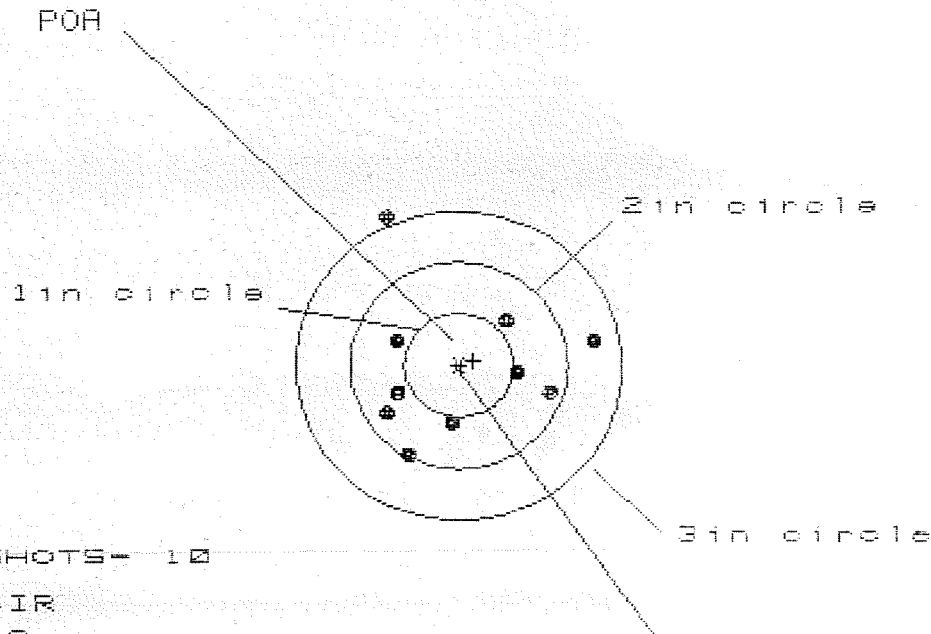
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.990	.784	.602
MINIMUM X	:	-1.855	-.574	-.476
MAXIMUM Y	:	1.177	1.232	1.080
MINIMUM Y	:	-1.273	-1.218	-.969
CENTROID X	:	-.012	.194	.096
CENTROID Y	:	.075	.020	.172
POA TO CENTROID in.	:	.076	.195	.197
MIN RADIUS	:	.262	.404	.294
MEAN RADIUS	:	.893	.789	.662
MAX RADIUS	:	1.922	1.448	1.140
HORIZONTAL SPREAD	:	2.845	1.358	1.078
VERTICAL SPREAD	:	2.450	2.450	2.049
EXTREME SPREAD	:	3.353	2.534	2.082
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

1 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08507547

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 9

HS= 1.908

VS= 2.305

GS= 2.310

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.231	1.159	.886
MINIMUM X	:	-.677	-.749	-.605
MAXIMUM Y	:	1.485	.624	.675
MINIMUM Y	:	-.820	-.655	-.604
CENTROID X	:	-.137	-.065	-.209
CENTROID Y	:	-.044	-.209	-.260
POA TO CENTROID in.	:	.144	.219	.334
MIN RADIUS	:	.506	.415	.333
MEAN RADIUS	:	.845	.737	.652
MAX RADIUS	:	1.622	1.229	.887
HORIZONTAL SPREAD	:	1.908	1.908	1.491
VERTICAL SPREAD	:	2.305	1.279	1.279
EXTREME SPREAD	:	2.310	2.044	1.599
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587547

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.422

VS= 1.629

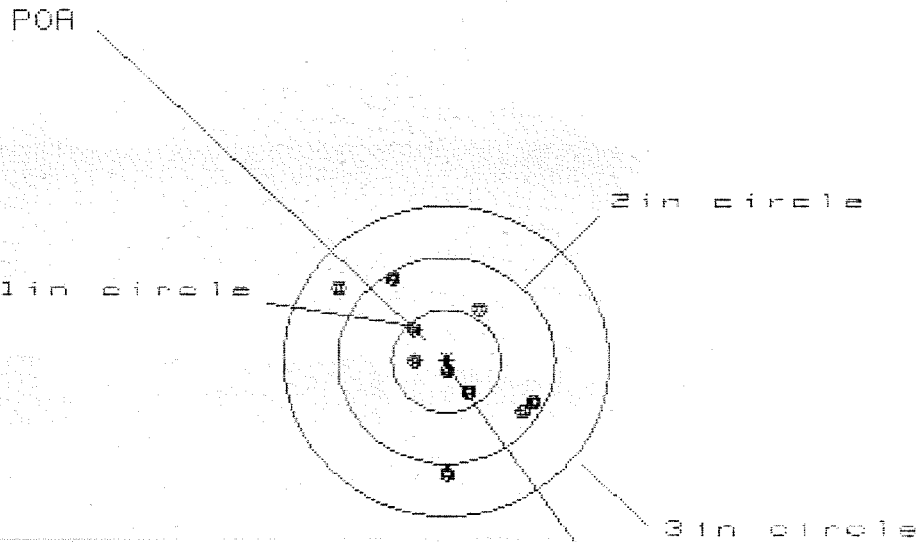
GS= 2.523

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.461	1.259	.695
MINIMUM X	:	-.961	-.799	-.641
MAXIMUM Y	:	.932	.896	.897
MINIMUM Y	:	-.697	-.733	-.732
CENTROID X	:	.168	.006	-.152
CENTROID Y	:	-.570	-.534	-.535
POA TO CENTROID in.	:	.594	.534	.556
MIN RADIUS	:	.202	.054	.123
MEAN RADIUS	:	.846	.745	.670
MAX RADIUS	:	1.496	1.259	.953
HORIZONTAL SPREAD	:	2.422	2.050	1.336
VERTICAL SPREAD	:	1.629	1.629	1.629
EXTREME SPREAD	:	2.523	2.006	1.825
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

1 Dec 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.762

VS= 1.931

GS= 2.041

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.796	.688	.688
MINIMUM X	:	-.966	-.588	-.588
MAXIMUM Y	:	.826	.900	.771
MINIMUM Y	:	-1.105	-1.031	-.518
CENTROID X	:	-.005	.103	.111
CENTROID Y	:	-.007	-.081	.048
POA TO CENTROID in.	:	.008	.131	.121
MIN RADIUS	:	.121	.090	.194
MEAN RADIUS	:	.681	.616	.570
MAX RADIUS	:	1.172	1.070	.969
HORIZONTAL SPREAD	:	1.762	1.268	1.268
VERTICAL SPREAD	:	1.931	1.931	1.289
EXTREME SPREAD	:	2.041	1.999	1.747
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	