

06523488

MODEL 700TM M24

Model SWSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

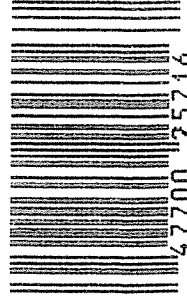
Remington

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6523488
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6523488

LIPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523488

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KE
600	Proof		10/2/90	KE
607	Check Headspace		10/2/90	KE
610	Dis-assemble Gun		10/2/90	KE
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	SL
617	Drill and Tap Sight Holes		10/8/90	FB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10-24-90	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/25/90	WDB
	G) Safety Off Force	2	2	2			10/25/90	WDB
	H) Trigger Pull Test & Retainability						10-24-90	DH
	I) Firing Pin Indent	.0245	.025	.0245			10/25/90	WDB
	J) Assemble Stock						10/26/90	KA
	K) Assemble Swivel Studs						3/10/90	ES
	L) Attach Front and Rear Sight Assemblies						10/26/90	KA
	M) Iron Sight Alignment						10/26/90	KA
	N) Detach Front & Rear Sights & place in numbered container						10/26/90	KA
	O) Attach Scope to Rifle						10/26/90	KA
	P) Detach & Attach Scope 20 Times						10/26/90	KA
640	Gallery Target & Test						10-27-90	KT
	A) Time						10-27-90	KT
	B) Malfunctions						10-27-90	KT
	C) Pierced Primers						10-27-90	KT
	D) Optical Clarity of Scope						10-27-90	KT
645	Inspect for Live Ammo						10-27-90	KT
655	Final Inspection							
	A) Headspace						3/10/90	ES
	B) Trigger Pull	244	243	233	246	239	3/10/90	ES
	C) Function						3/10/90	ES
660	Pack						12/14/90	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523488

DATE 10-24-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.34	2.60	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.38	2.59	2.43	
PULL #3	2.47	2.40	2.64	2.33	
PULL #4	2.46	2.35	2.64	2.46	
PULL #5	2.49	2.30	2.57	2.39	
TOTAL	12.50	11.77	13.04		
AVG.	2.50	2.35	2.60		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.18		
PULL #2	3.02	3.14		
PULL #3	3.12	3.21		
PULL #4	3.05	3.22		
PULL #5	3.08	3.19		
TOTAL	15.32	15.94		
AVG.	3.06	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.04		4.01
PULL #2	4.04	4.07		4.05
PULL #3	4.05	4.10		4.04
PULL #4	4.09	4.09		4.06
PULL #5	4.09	4.08		4.05
TOTAL	20.45	20.38		20.21
AVG.	4.09	4.07		4.04

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523488
27 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.210155
1 TO	2	.152053
1 TO	3	.0600083
1 TO	4	.394077
1 TO	5	.38

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0298
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0609777
THE AMR FOR THIS RIFLE IS: .8014

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523488
27 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.210155
1 TO	2	.152053
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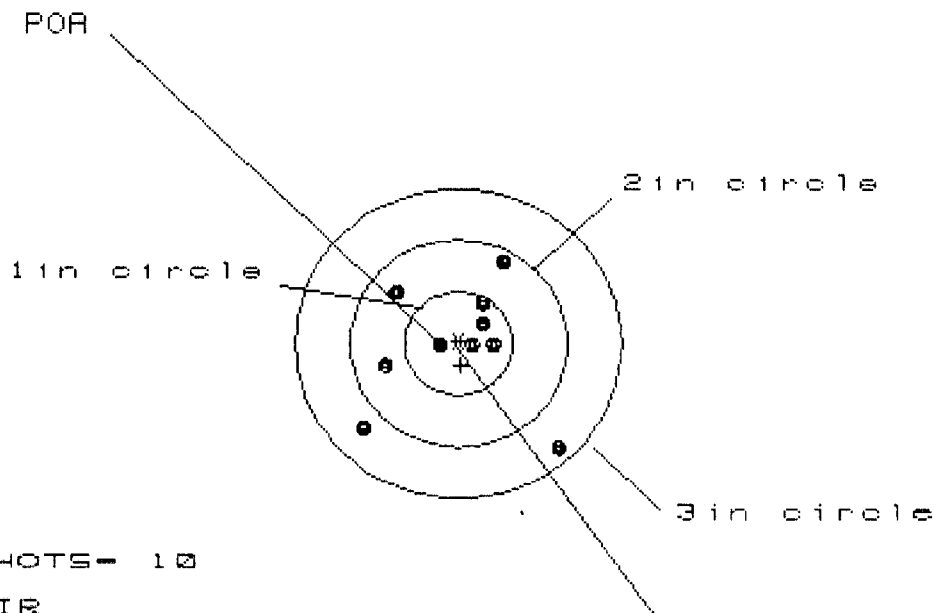
✂ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0298
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27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523488

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.724

VS= 1.860

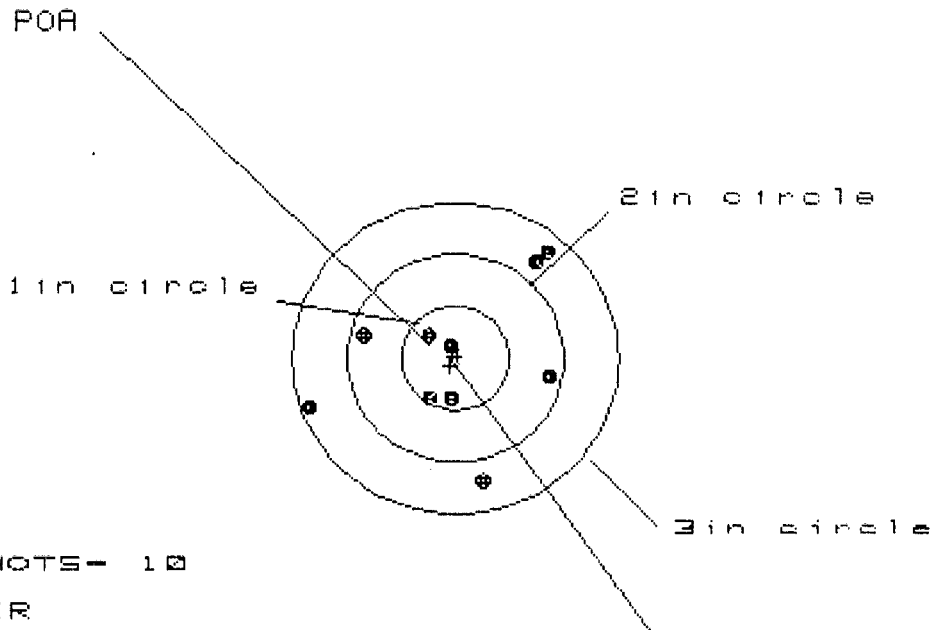
GS= 2.113

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.879	.539	.446
MINIMUM X	-.845	-.748	-.634
MAXIMUM Y	.839	.726	.613
MINIMUM Y	-1.021	-.902	-.390
CENTROID X	-.022	-.119	-.026
CENTROID Y	.209	.322	.435
POA TO CENTROID in.	.210	.344	.436
MIN RADIUS	.148	.129	.187
MEAN RADIUS	.631	.546	.449
MAX RADIUS	1.347	1.172	.758
HORIZONTAL SPREAD	1.724	1.287	1.080
VERTICAL SPREAD	1.860	1.628	1.003
EXTREME SPREAD	2.113	2.075	1.474
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 2.209

VS= 2.134

GS= 2.634

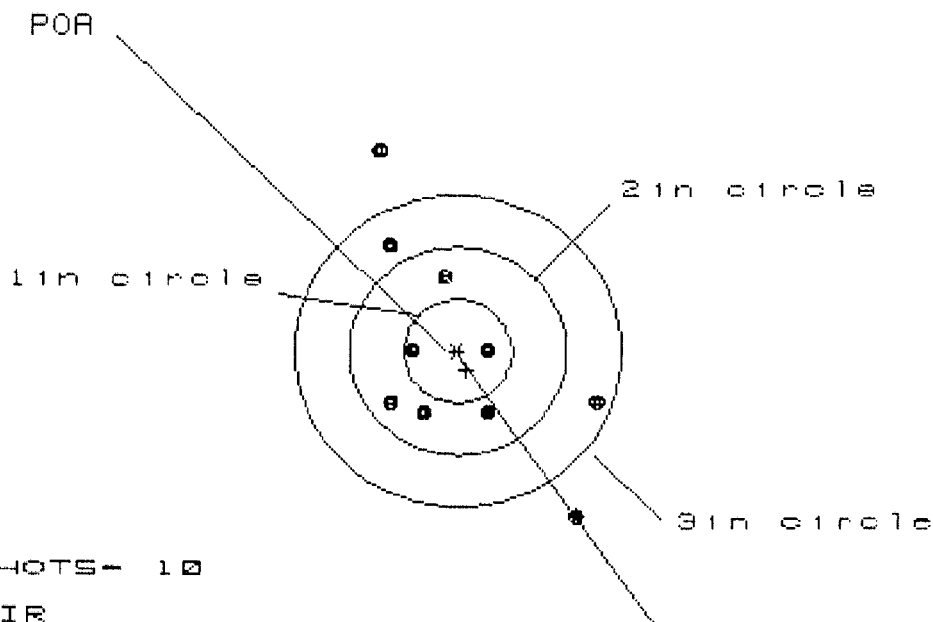
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.888	.741	.790
MINIMUM X	:	-1.321	-.967	-.874
MAXIMUM Y	:	.990	.940	1.030
MINIMUM Y	:	-1.144	-1.194	-1.076
CENTROID X	:	.046	.193	.100
CENTROID Y	:	.073	.123	.005
POA TO CENTROID in.	:	.086	.228	.100
MIN RADIUS	:	.133	.232	.220
MEAN RADIUS	:	.811	.765	.678
MAX RADIUS	:	1.394	1.201	1.219
HORIZONTAL SPREAD	:	2.209	1.708	1.664
VERTICAL SPREAD	:	2.134	2.134	2.106
EXTREME SPREAD	:	2.634	2.219	2.149
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.936

VS= 3.521

GS= 3.931

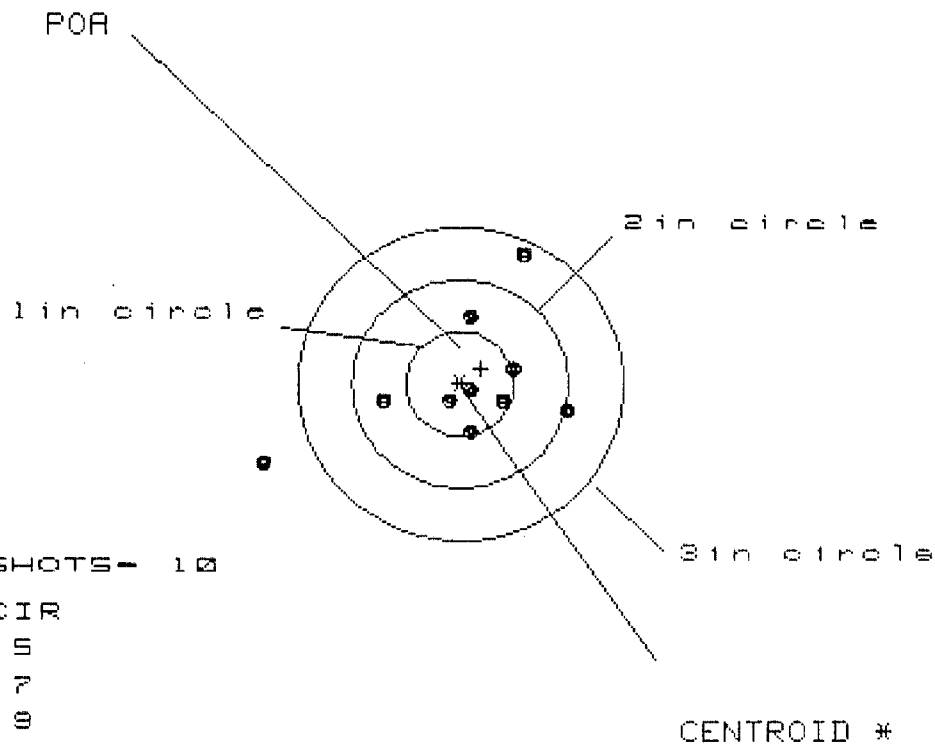
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	1.172	1.295
MINIMUM X	:	-.688	-.724	-.601
MAXIMUM Y	:	1.932	1.246	1.074
MINIMUM Y	:	-1.589	-1.374	-.583
CENTROID X	:	-.077	-.001	-.124
CENTROID Y	:	.185	-.030	.142
POA TO CENTROID in.	:	.200	.030	.188
MIN RADIUS	:	.253	.310	.308
MEAN RADIUS	:	.997	.870	.746
MAX RADIUS	:	2.051	1.690	1.366
HORIZONTAL SPREAD	:	1.936	1.896	1.896
VERTICAL SPREAD	:	3.521	2.620	1.657
EXTREME SPREAD	:	3.931	3.128	2.423
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 9

HS= 2.859

VS= 1.952

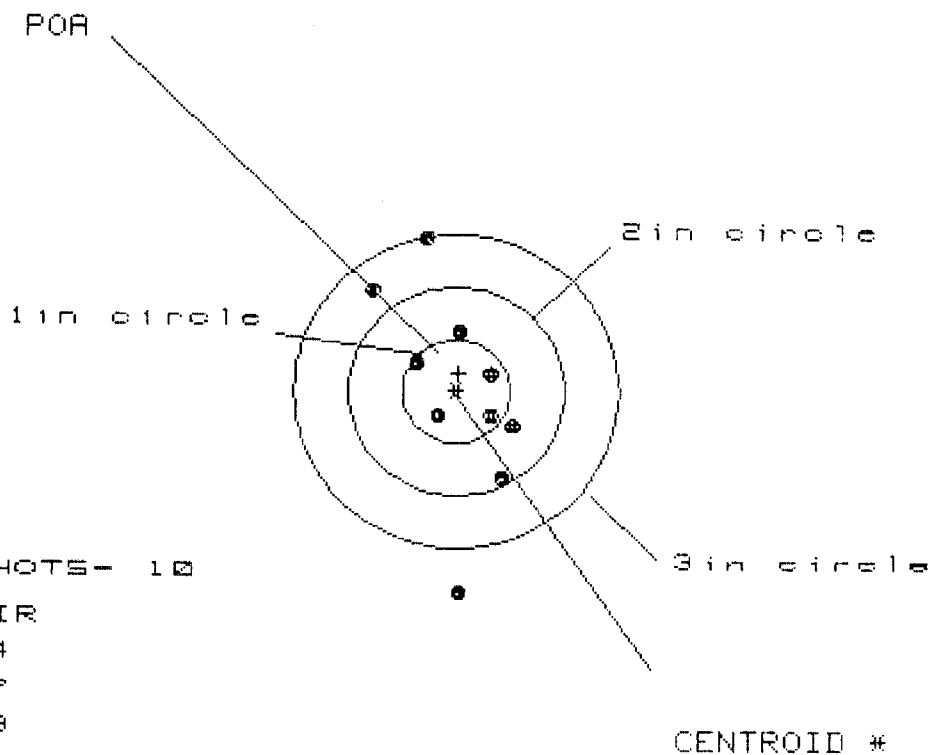
GS= 3.096

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.005	.799	.841
MINIMUM X	:	-1.854	-.885	-.843
MAXIMUM Y	:	1.220	1.139	.751
MINIMUM Y	:	-.732	-.514	-.372
CENTROID X	:	-.191	.015	-.027
CENTROID Y	:	-.147	-.066	-.208
POA TO CENTROID in.	:	.241	.068	.210
MIN RADIUS	:	.108	.223	.105
MEAN RADIUS	:	.745	.595	.486
MAX RADIUS	:	1.994	1.189	.865
HORIZONTAL SPREAD	:	2.859	1.684	1.684
VERTICAL SPREAD	:	1.952	1.653	1.123
EXTREME SPREAD	:	3.096	1.845	1.687
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.329

VS= 3.365

GS= 3.377

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.549	.547	.509
MINIMUM X	-.780	-.782	-.820
MAXIMUM Y	1.450	1.238	.945
MINIMUM Y	-1.915	-1.009	-.855
CENTROID X	-.022	-.020	.018
CENTROID Y	-.171	.041	-.113
POA TO CENTROID in.	.173	.046	.115
MIN RADIUS	.251	.284	.264
MEAN RADIUS	.823	.699	.602
MAX RADIUS	1.915	1.275	1.252
HORIZONTAL SPREAD	1.329	1.329	1.329
VERTICAL SPREAD	3.365	2.247	1.800
EXTREME SPREAD	3.377	2.377	2.192
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	