

C6649007

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

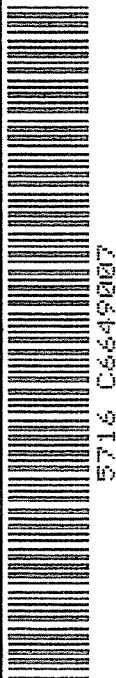
Capacity

Order No. **5716**

* Includes 1 in chamber.

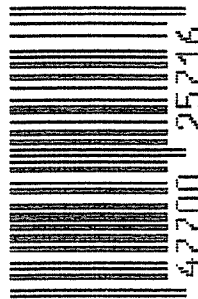
Remington

Remington MODEL 700 TM M24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		VERY IMPORTANT! Instruction Book enclosed to assure safe use of this firearm.
SERIAL NO. 06649007		ORDER NO. 5716



5716 06649007

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649007

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-28-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/91	GR

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	8	8			8-29-91	DH
	G) Safety Off Force	4	4	3 1/2			8-29-91	DH
	H) Trigger Pull Test & Retainability						8/29/91	JU
	I) Firing Pin Indent	.021	.021	.020			8-29-91	DH
	J) Assemble Stock						8/30/91	RW
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/30/91	RW
	M) Iron Sight Alignment						8/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/30/91	RW
	O) Attach Scope to Rifle						8/30/91	RW
	P) Detach & Attach Scope 20 Times						8/30/91	RW
640	Gallery Target & Test						8/30/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/30/91	KS
655	Final Inspection							
	A) Headspace						8-31-91	DH
	B) Trigger Pull	2.41	2.41	2.53	2.57	2.54	8-31-91	DH
	C) Function						8-31-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649007

DATE 8/29/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.27	2.25	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.23	2.28	2.41	
PULL #3	2.24	2.27	2.30	2.53	
PULL #4	2.28	2.31	2.36	2.57	
PULL #5	2.23	2.20	2.31	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.42		
PULL #2	3.54	3.39		
PULL #3	3.56	3.46		
PULL #4	3.45	3.48		
PULL #5	3.49	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.38		4.29
PULL #2	4.33	4.33		4.33
PULL #3	4.31	4.21		4.35
PULL #4	4.40	4.29		4.31
PULL #5	4.39	4.27		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649007
30 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.328093
1 TO 2	.505974
1 TO 3	.286276
1 TO 4	.421385
1 TO 5	.565032

$\frac{132}{45}$ <----POA

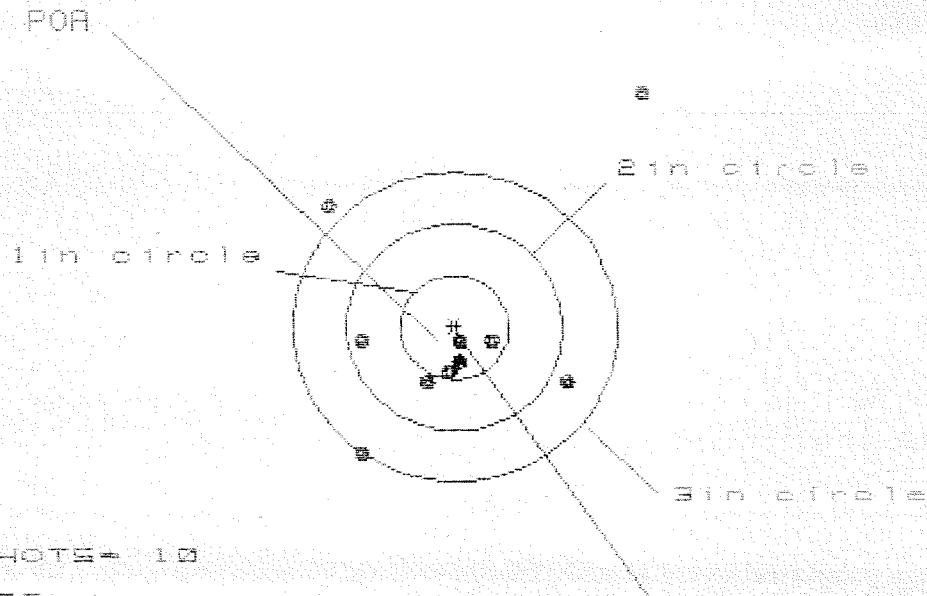
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .093
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0704
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116641

THE AMR FOR THIS RIFLE IS: .0756

30 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649007

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 7

HS = 2.878

VS = 3.532

GS = 4.387

CENTROID #

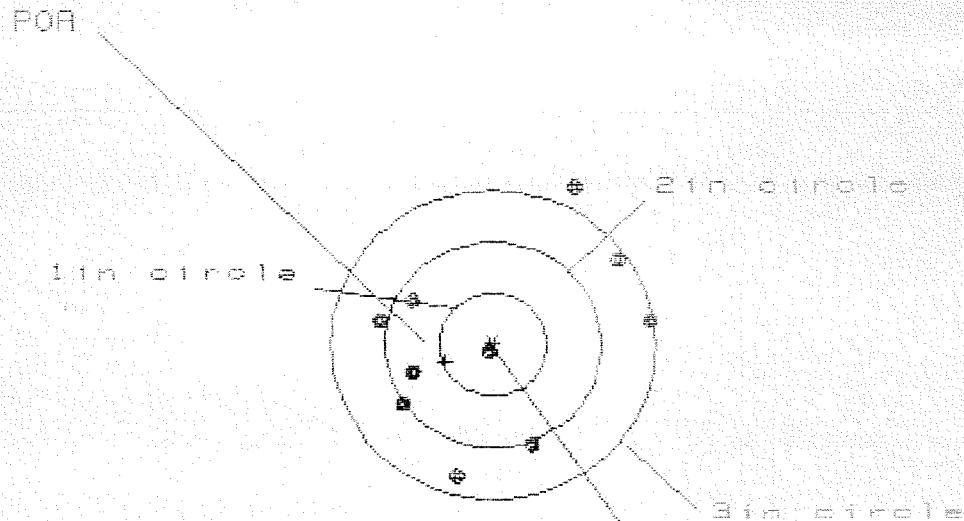
PATTERN # : 1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.713	1.264	1.142
MINIMUM X	-1.165	-.975	-.821
MAXIMUM Y	2.292	1.384	.334
MINIMUM Y	-1.240	-.985	-.813
CENTROID X	-.037	-.227	-.105
CENTROID Y	.326	.071	-.102
POA TO CENTROID in.	.328	.238	.146
MIN RADIUS	.118	.197	.059
MEAN RADIUS	.988	.717	.551
MAX RADIUS	2.861	1.693	1.155
HORIZONTAL SPREAD	2.878	2.239	1.963
VERTICAL SPREAD	3.532	2.369	1.146
EXTREME SPREAD	4.387	2.764	2.101
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

30 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.511

VS= 2.863

GS= 3.067

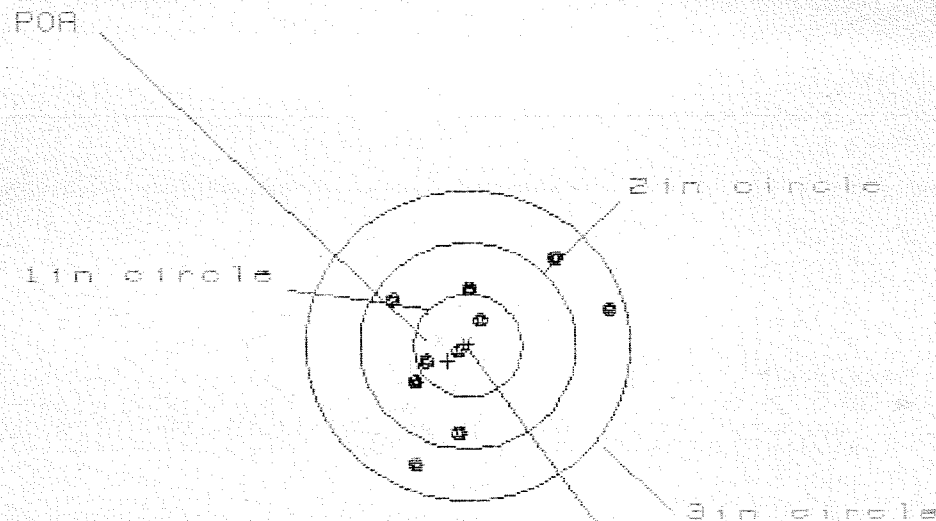
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.467	1.552	1.480
MINIMUM X	:	-1.044	-.959	-.765
MAXIMUM Y	:	1.548	1.000	1.058
MINIMUM Y	:	-1.315	-1.144	-1.094
CENTROID X	:	.444	.359	.165
CENTROID Y	:	.169	-.002	-.052
POA TO CENTROID in.	:	.475	.359	.173
MIN RADIUS	:	.072	.121	.207
MEAN RADIUS	:	1.091	.990	.876
MAX RADIUS	:	1.723	1.634	1.819
HORIZONTAL SPREAD	:	2.511	2.511	2.245
VERTICAL SPREAD	:	2.863	2.152	2.152
EXTREME SPREAD	:	3.067	2.848	2.648
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.031

VS= 1.994

GS= 2.355

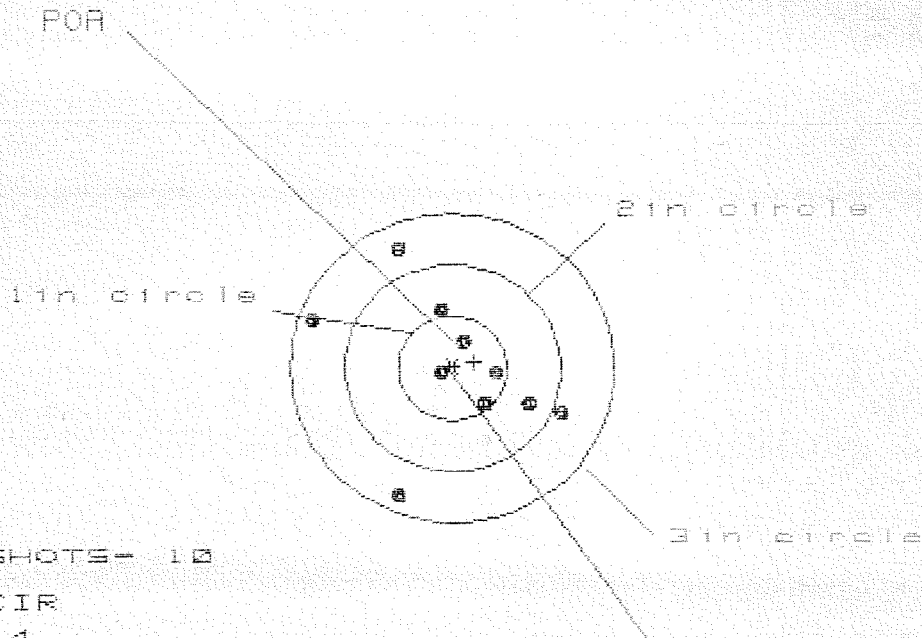
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.332	.915	.873
MINIMUM X	-.699	-.551	-.593
MAXIMUM Y	.851	.891	.753
MINIMUM Y	-1.143	-1.103	-.919
CENTROID X	.188	.040	.082
CENTROID Y	.149	.109	.247
POA TO CENTROID in.	.240	.117	.261
MIN RADIUS	.062	.093	.114
MEAN RADIUS	.729	.636	.565
MAX RADIUS	1.380	1.277	1.153
HORIZONTAL SPREAD	2.031	1.466	1.466
VERTICAL SPREAD	1.994	1.994	1.672
EXTREME SPREAD	2.355	2.352	1.871
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 2.233

VS= 2.405

GS= 2.414

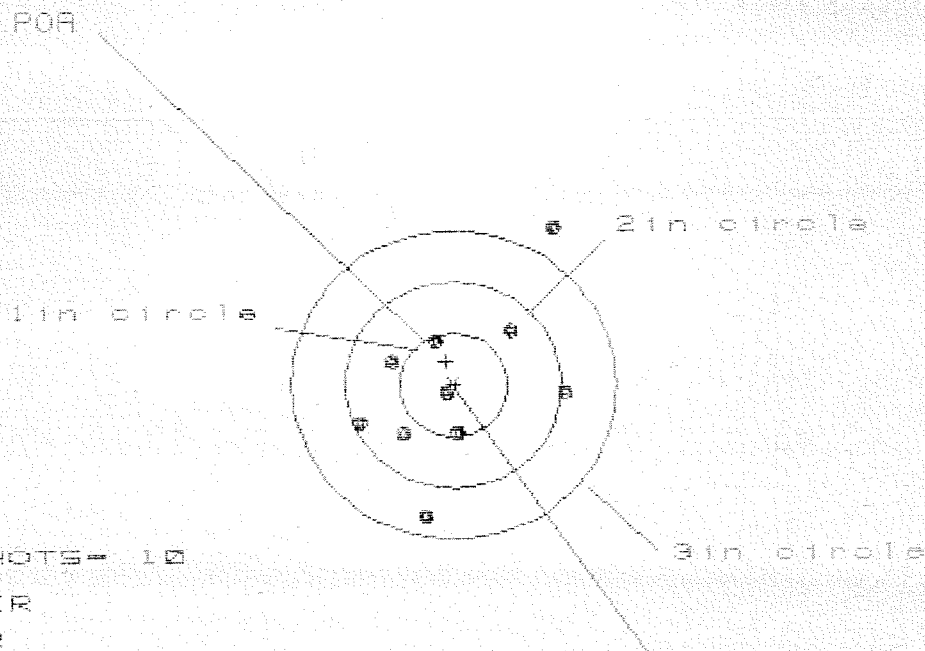
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.962	.821	.737
MINIMUM X	-1.271	-.668	-.693
MAXIMUM Y	1.200	1.254	1.110
MINIMUM Y	-1.205	-1.151	-.521
CENTROID X	-.199	-.058	.026
CENTROID Y	-.063	-.117	.027
POA TO CENTROID IN.	.209	.130	.037
MIN RADIUS	.134	.273	.198
MEAN RADIUS	.763	.677	.586
MAX RADIUS	1.360	1.394	1.308
HORIZONTAL SPREAD	2.233	1.489	1.430
VERTICAL SPREAD	2.405	2.405	1.631
EXTREME SPREAD	2.414	2.406	2.169
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.829

VS= 2.733

CS= 2.979

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.985	1.086	1.065
MINIMUM X	-.844	-.743	-.765
MAXIMUM Y	1.506	.665	.532
MINIMUM Y	-1.227	-1.059	-.477
CENTROID X	.069	-.032	-.011
CENTROID Y	-.229	-.396	-.263
POA TO CENTROID in.	.239	.397	.264
MIN RADIUS	.107	.140	.025
MEAN RADIUS	.807	.679	.613
MAX RADIUS	1.761	1.089	1.066
HORIZONTAL SPREAD	1.829	1.829	1.829
VERTICAL SPREAD	2.733	1.724	1.009
EXTREME SPREAD	2.979	1.898	1.852
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		