

06587556

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

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

MODEL 700TM M24

SERIAL NO.
C6587556

ORDER NO.
5716

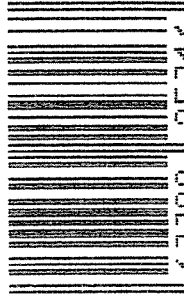
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6587556

UPC



0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587556

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	GS
617	Drill and Tap Sight Holes		11/5/90	KB
618	Polish Barrel <i>KB</i>		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1/4/91	JH

BARBER - M24 0022634								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	4.75	4.75			1/2/91	K+
	G) Safety Off Force	2.50	2.75	2.75				
	H) Trigger Pull Test & Retainability						1/4/91	JH
	I) Firing Pin Indent	.020	.021	.020			1/2/91	K7
	J) Assemble Stock						1/4/91	KA
	K) Assemble Swivel Studs						1-15-91	JH
	L) Attach Front and Rear Sight Assemblies						1/4/91	KA
	M) Iron Sight Alignment						1/4/91	KA
	N) Detach Front & Rear Sights & place in numbered container						1/4/91	KA
	O) Attach Scope to Rifle						1/4/91	KA
	P) Detach & Attach Scope 20 Times						1/4/91	KA
640	Gallery Target & Test						1-14-91	DH
	A) Time						1-14-91	DH
	B) Malfunctions						1-14-91	DH
	C) Pierced Primers						1-14-91	DH
	D) Optical Clarity of Scope						1-14-91	DH
645	Inspect for Live Ammo						1-14-91	DH
655	Final Inspection							
	A) Headspace						1-15-91	JH
	B) Trigger Pull	2.13	2.18	2.16	2.18	2.18	1-15-91	JH
	C) Function						1-15-91	JH
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06587556

DATE 1/4/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.41	2.47	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.47	2.50	2.18	
PULL #3	2.37	2.45	2.48	2.16	
PULL #4	2.45	2.44	2.46	2.18	
PULL #5	2.38	2.41	2.49	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.25		
PULL #2	3.36	3.27		
PULL #3	3.35	3.26		
PULL #4	3.33	3.33		
PULL #5	3.30	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.25		4.26
PULL #2	4.47	4.15		4.32
PULL #3	4.45	4.23		4.22
PULL #4	4.48	4.24		4.20
PULL #5	4.50	4.21		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587556
15 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.155322
1 TO 2	.195438
1 TO 3	.304171
1 TO 4	.303645
1 TO 5	.50315

544 <----POB

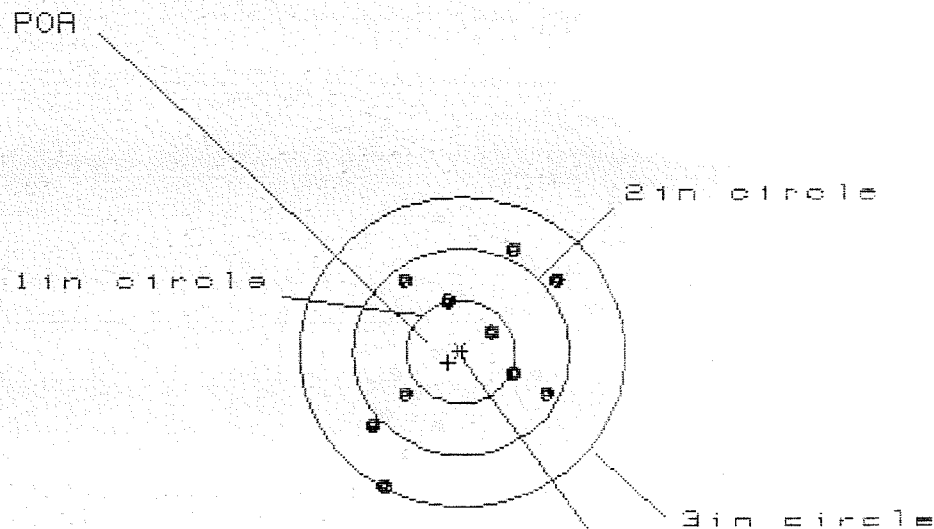
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1276
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0686
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144871

THE AMR FOR THIS RIFLE IS: .7664

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587556

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 10

CENTROID #

HS = 1.707

VS = 2.248

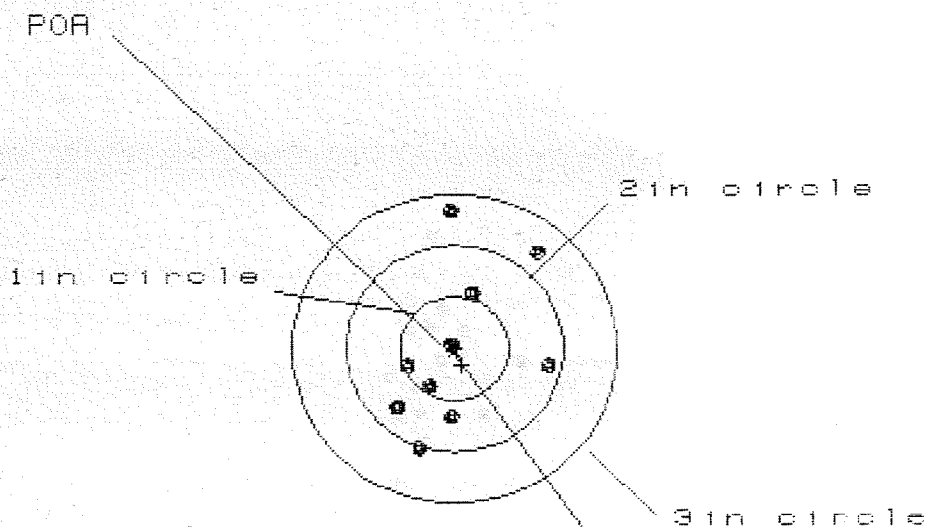
GS = 2.530

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.849	.771	.653
MINIMUM X	-.858	-.936	-.755
MAXIMUM Y	.962	.819	.711
MINIMUM Y	-1.286	-.864	-.659
CENTROID X	.118	.196	.314
CENTROID Y	.101	.244	.352
POA TO CENTROID in.	.155	.313	.471
MIN RADIUS	.305	.173	.090
MEAN RADIUS	.852	.754	.665
MAX RADIUS	1.468	1.274	.972
HORIZONTAL SPREAD	1.707	1.707	1.408
VERTICAL SPREAD	2.248	1.683	1.370
EXTREME SPREAD	2.530	2.211	1.753
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587556

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.352

VS = 2.211

GS = 2.228

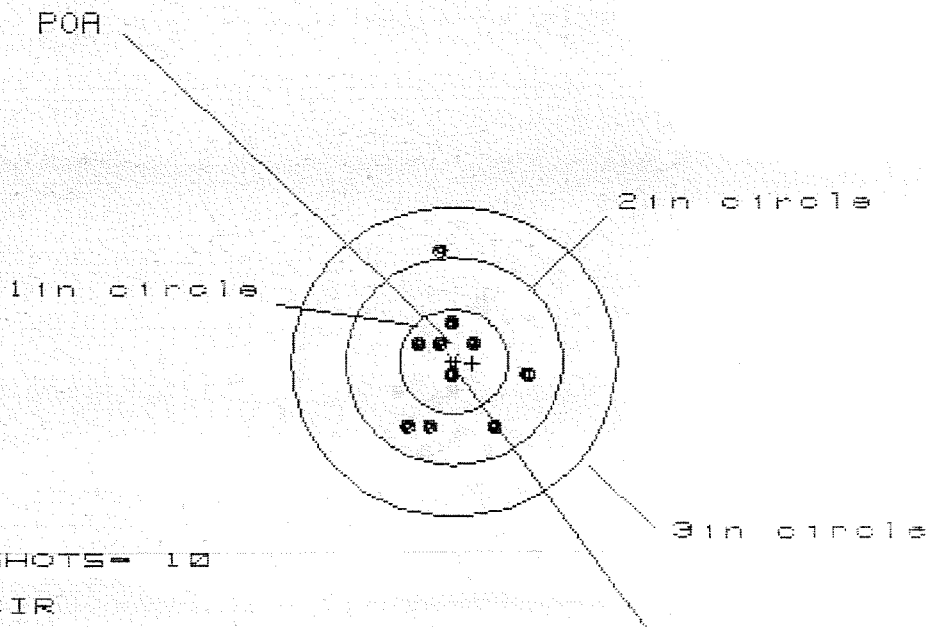
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.818	.811	.908
MINIMUM X	-.534	-.541	-.444
MAXIMUM Y	1.299	1.033	.823
MINIMUM Y	-.912	-.768	-.639
CENTROID X	-.068	-.061	-.158
CENTROID Y	.161	.017	-.112
POA TO CENTROID in.	.175	.063	.194
MIN RADIUS	.070	.204	.217
MEAN RADIUS	.727	.649	.532
MAX RADIUS	1.300	1.294	.919
HORIZONTAL SPREAD	1.352	1.352	1.352
VERTICAL SPREAD	2.211	1.801	1.462
EXTREME SPREAD	2.228	2.121	1.531
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

15 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 9

3in = 10

CENTROID *

HS= 1.126

VS= 1.717

GS= 1.768

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.703	.692	.638
MINIMUM X	-.423	-.434	-.383
MAXIMUM Y	1.098	.458	.401
MINIMUM Y	-.619	-.497	-.554
CENTROID X	-.176	-.165	-.111
CENTROID Y	.023	-.099	-.042
POA TO CENTROID in.	.177	.193	.119
MIN RADIUS	.084	.071	.106
MEAN RADIUS	.508	.450	.420
MAX RADIUS	1.102	.693	.639
HORIZONTAL SPREAD	1.126	1.126	1.021
VERTICAL SPREAD	1.717	.955	.955
EXTREME SPREAD	1.768	1.223	1.066
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

15 Jan 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 7

3 in - 9

HS = 2.3009

VS = 2.157

GS = 2.684

PATTERN # :

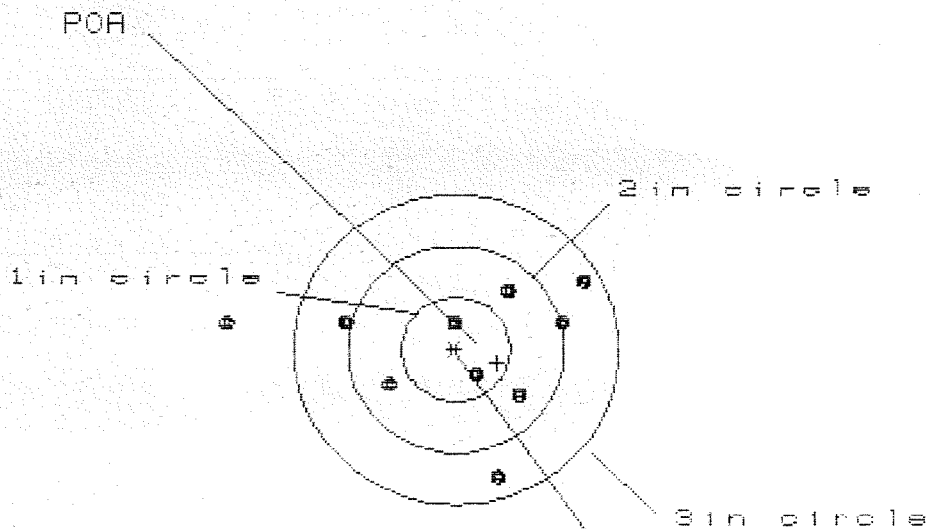
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.792	.623	.607
MINIMUM X	-1.517	-.495	-.417
MAXIMUM Y	.968	1.006	.982
MINIMUM Y	-1.189	-1.151	-1.275
CENTROID X	-.128	.041	-.037
CENTROID Y	-.077	-.115	.009
POA TO CENTROID in.	.149	.122	.038
MIN RADIUS	.169	.244	.281
MEAN RADIUS	.796	.714	.629
MAX RADIUS	1.555	1.171	1.281
HORIZONTAL SPREAD	2.309	1.118	1.024
VERTICAL SPREAD	2.157	2.157	2.157
EXTREME SPREAD	2.684	2.172	2.172
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

15 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.229

VS= 1.864

GS= 3.247

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.149	.918	.831
MINIMUM X	-2.080	-1.286	-1.171
MAXIMUM Y	.631	.663	.723
MINIMUM Y	-1.233	-1.201	-1.118
CENTROID X	-.384	-.153	-.268
CENTROID Y	.135	.103	.020
POA TO CENTROID in.	.407	.184	.268
MIN RADIUS	.256	.223	.122
MEAN RADIUS	.949	.793	.740
MAX RADIUS	2.100	1.314	1.223
HORIZONTAL SPREAD	3.229	2.204	2.002
VERTICAL SPREAD	1.864	1.864	1.841
EXTREME SPREAD	3.247	2.239	2.073
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	