

C6649002

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

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

DU PONT

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

MODEL 700TM M24

SERIAL NO.
C6649002

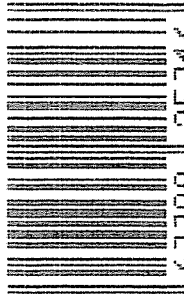
ORDER NO.
5716

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



5716 C6649002

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649002

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	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	Rw
	C) Inspect Ejector Hole for Chamfer		8/29/91	Rw
	D) Oil Firing Pin Ass'y		8/29/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		9-5-91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/5/91	QU
	G) Safety Off Force	4	4	4			9/5/91	QU
	H) Trigger Pull Test & Retainability						9-5-91	QU
	I) Firing Pin Indent	.021	.021	.021			9/5/91	QU
	J) Assemble Stock						9/10/91	RW
	K) Assemble Swivel Studs						9-10-91	R
	L) Attach Front and Rear Sight Assemblies						9/10/91	RW
	M) Iron Sight Alignment						9/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	RW
	O) Attach Scope to Rifle						9/10/91	RW
	P) Detach & Attach Scope 20 Times						9/10/91	RW
640	Gallery Target & Test						9-10-91	D/H
	A) Time						9-10-91	D/H
	B) Malfunctions						9-10-91	D/H
	C) Pierced Primers						9-10-91	D/H
	D) Optical Clarity of Scope						9-10-91	D/H
645	Inspect for Live Ammo						9-10-91	D/H
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	260	257	249	254	249	9-10-91	D/H
	C) Function						9-10-91	AC
660	Pack						9-18-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. 06649002

DATE 9-5-91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.47	2.44	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.40	2.40	2.57	
PULL #3	2.36	2.46	2.50	2.49	
PULL #4	2.39	2.44	2.52	2.54	
PULL #5	2.44	2.43	2.44	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.51		
PULL #2	3.58	3.40		
PULL #3	3.56	3.38		
PULL #4	3.39	3.33		
PULL #5	3.52	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.42		4.40
PULL #2	4.30	4.44		4.34
PULL #3	4.36	4.49		4.26
PULL #4	4.48	4.37		4.37
PULL #5	4.51	4.40		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649002
10 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.19188
1 TO	2	.659042
1 TO	3	.39123
1 TO	4	.395345
1 TO	5	.245231

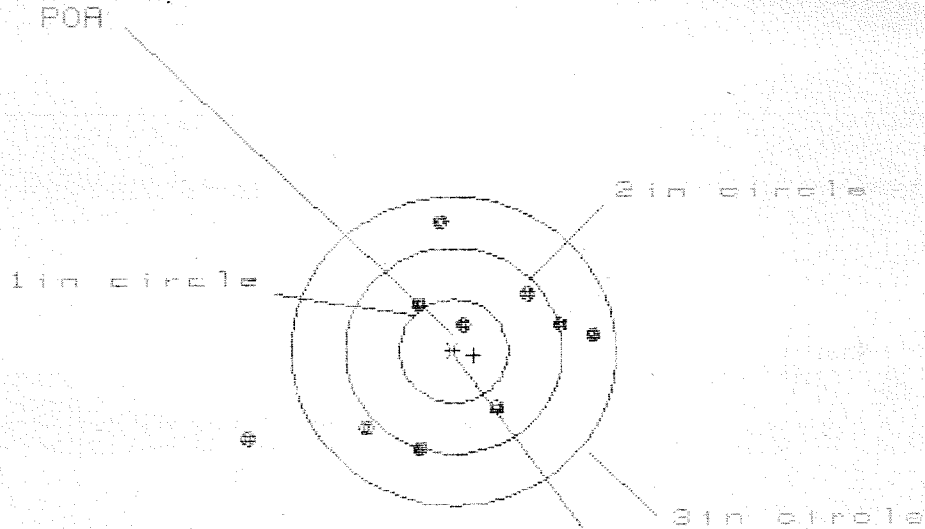
1.0² < ---- POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1459
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0436
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152179
THE AMR FOR THIS RIFLE IS: .9826

10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/006490082

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.241

VS= 2.178

GS= 3.401

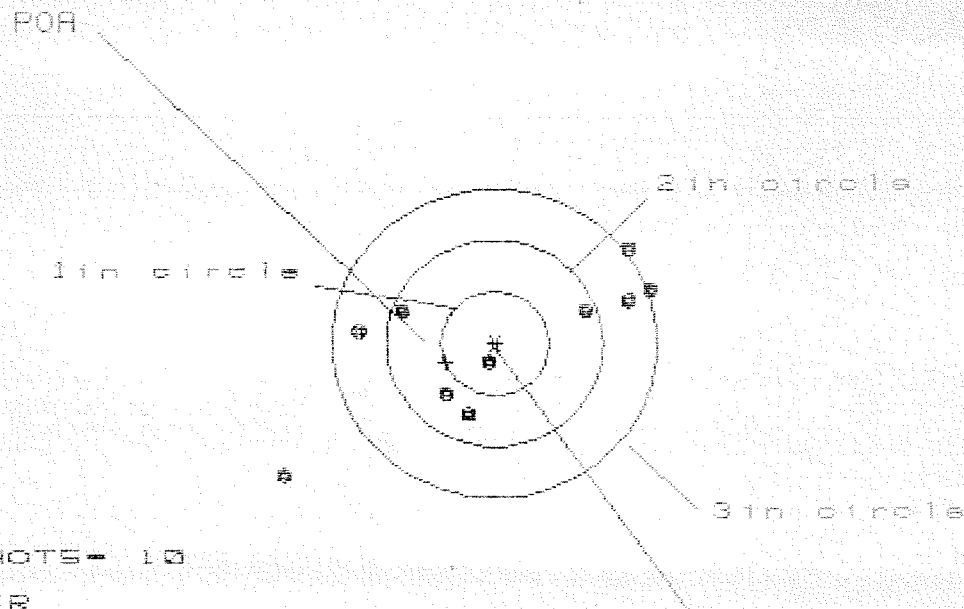
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.288	1.062	.915
MINIMUM X	-1.961	-.989	-.856
MAXIMUM Y	1.268	1.174	1.186
MINIMUM Y	-.918	-1.004	-.992
CENTROID X	-.187	.031	-.102
CENTROID Y	.043	.137	.125
POA TO CENTROID in.	.192	.148	.161
MIN RADIUS	.273	.240	.189
MEAN RADIUS	1.012	.852	.819
MAX RADIUS	2.135	1.382	1.201
HORIZONTAL SPREAD	3.241	2.051	1.771
VERTICAL SPREAD	2.178	2.178	2.178
EXTREME SPREAD	3.401	2.256	2.186
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

18 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 3.320

VS = 2.225

GS = 3.852

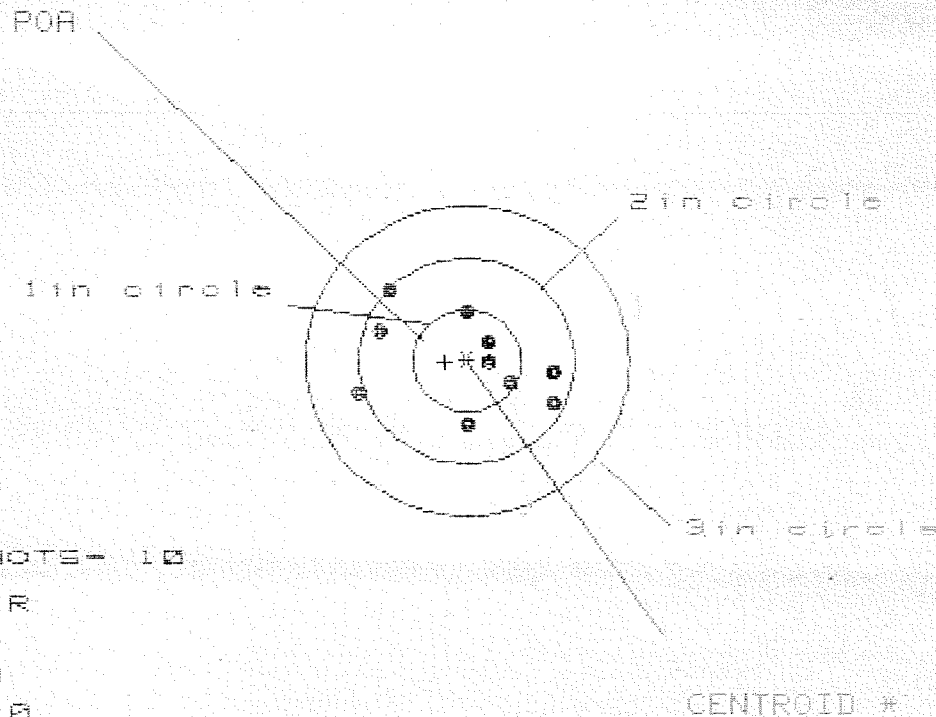
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.413	1.201	1.330
MINIMUM X	:	-1.907	-1.517	-1.308
MAXIMUM Y	:	.899	.752	.501
MINIMUM Y	:	-1.326	-.861	-.767
CENTROID X	:	.457	.669	.540
CENTROID Y	:	.183	.330	.236
POA TO CENTROID in.	:	.492	.746	.590
MIN RADIUS	:	.135	.364	.214
MEAN RADIUS	:	1.135	1.010	.950
MAX RADIUS	:	2.322	1.517	1.421
HORIZONTAL SPREAD	:	3.320	2.718	2.718
VERTICAL SPREAD	:	2.225	1.613	1.268
EXTREME SPREAD	:	3.852	2.746	2.746
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.865

VS= 1.302

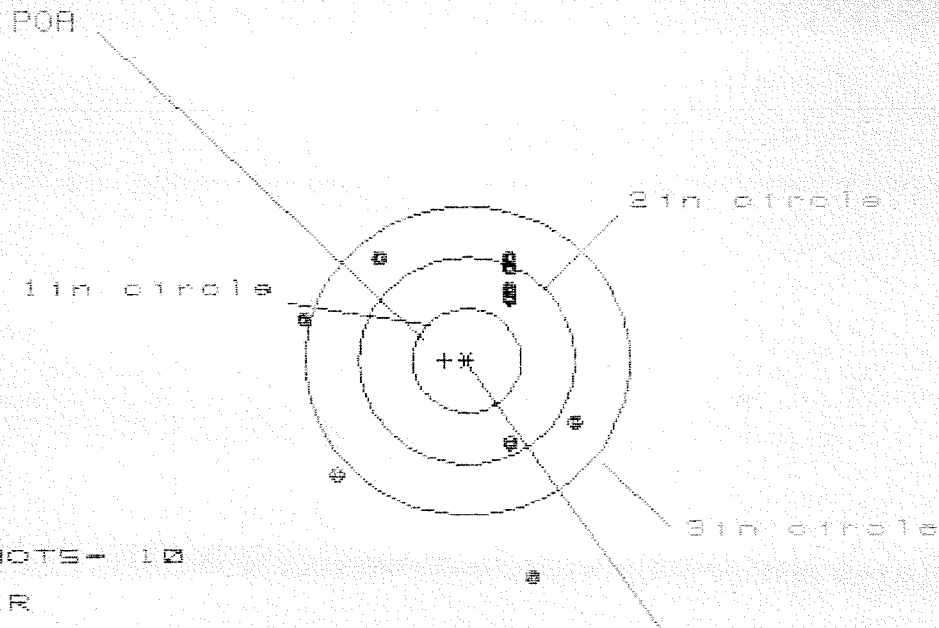
GS= 1.875

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.730	.632
MINIMUM X	-1.022	-1.901	-1.999
MAXIMUM Y	.650	.617	.507
MINIMUM Y	-.652	-.685	-.608
CENTROID X	.203	.316	.414
CENTROID Y	.012	.045	-.032
POA TO CENTROID in.	.203	.319	.415
MIN RADIUS	.228	.113	.076
MEAN RADIUS	.670	.593	.523
MAX RADIUS	1.064	.996	1.067
HORIZONTAL SPREAD	1.865	1.631	1.631
VERTICAL SPREAD	1.302	1.302	1.115
EXTREME SPREAD	1.875	1.843	1.776
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 10		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.487

VS = 3.117

GS = 3.350

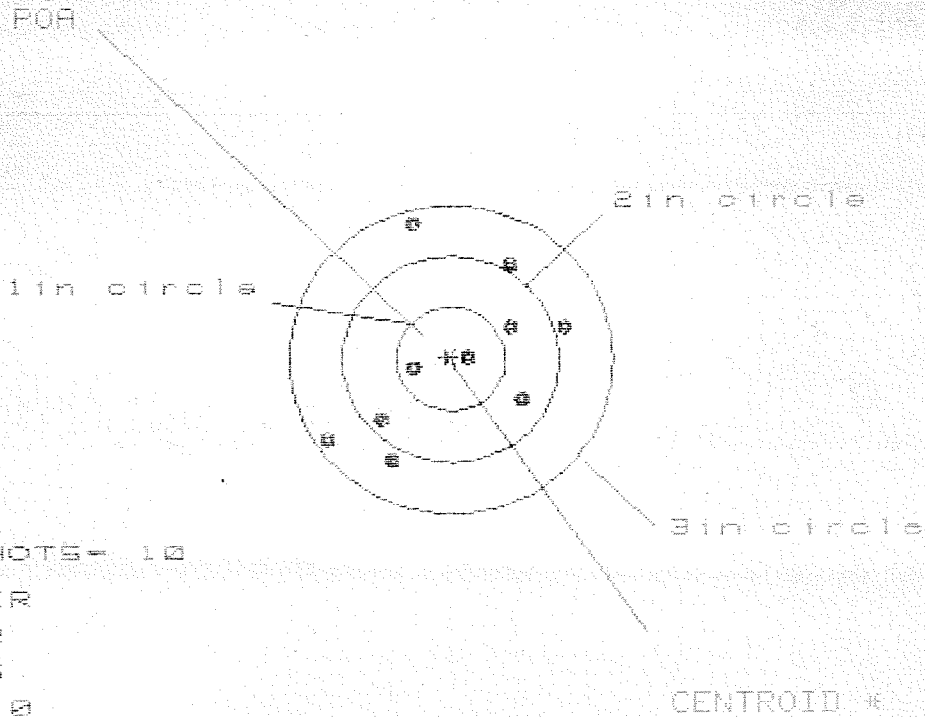
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.950
MINIMUM X	-1.537
MAXIMUM Y	1.034
MINIMUM Y	-2.083
CENTROID X	-.206
CENTROID Y	-.000
POA TO CENTROID in.	.206
MIN RADIUS	.742
MEAN RADIUS	1.217
MAX RADIUS	2.178
HORIZONTAL SPREAD	2.487
VERTICAL SPREAD	3.117
EXTREME SPREAD	3.350
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	7

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.184

VS= 2.317

GS= 2.448

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.061	.937	.880
MINIMUM X	-1.123	-.755	-.812
MAXIMUM Y	1.295	1.209	.984
MINIMUM Y	-1.022	-1.108	-.957
CENTROID X	.050	.174	.231
CENTROID Y	-.020	.066	-.085
POA TO CENTROID in.	.053	.186	.246
MIN RADIUS	.148	.094	.069
MEAN RADIUS	.879	.809	.734
MAX RADIUS	1.363	1.292	1.189
HORIZONTAL SPREAD	2.184	1.692	1.692
VERTICAL SPREAD	2.317	2.317	1.941
EXTREME SPREAD	2.448	2.325	2.207
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 10		