

C6636054

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

*Still
Smear.*

Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

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

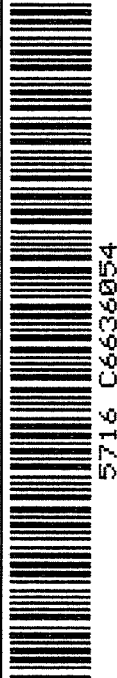
MODEL 700™ H24

SERIAL NO.
C6636054

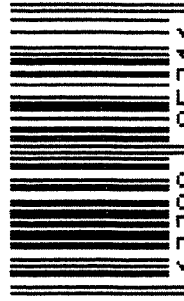
ORDER NO.
5716

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

20



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636054

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		CS
618	Polish Barrel	5 15 9 1		CS
620	Apply Coatings (Barrel Action)		5-31-91	CS
	Apply Coating (Bolt)			CS
625	Final Assembly		6-6-91	CS
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	CS
	C) Inspect Ejector Hole for Chamfer		6-6-91	CS
	D) Oil Firing Pin Ass'y		6-6-91	CS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	CS

op. #	BARBER - M24 0037159	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-7-91	JK
	G) Safety Off Force	4	4	4			6-7-91	JK
	H) Trigger Pull Test & Retainability						6-7-91	JK
	I) Firing Pin Indent	1021	1020	1022			6-7-91	Q
	J) Assemble Stock						6-7-91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6-7-91	KS
	M) Iron Sight Alignment						6-7-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-7-91	KS
	O) Attach Scope to Rifle						6-7-91	KS
	P) Detach & Attach Scope 20 Times						6-7-91	KS
640	Gallery Target & Test						6-10-91	DH
	A) Time						6-10-91	DH
	B) Malfunctions						6-10-91	DH
	C) Pierced Primers						6-10-91	DH
	D) Optical Clarity of Scope						6-10-91	DH
645	Inspect for Live Ammo						6-10-91	DH
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.25	2.30	2.17	2.15	2.15	2-13-91	JK
	C) Function						6-13-91	A
660	Pack						6-20-91	N

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

SERIAL NO. 6636054DATE 6-7-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.39	2.38	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.26	2.31	2.30	
PULL #3	2.39	2.39	2.42	2.17	
PULL #4	2.35	2.34	2.35	2.15	
PULL #5	2.30	2.27	2.20	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.43		
PULL #2	3.52	3.62		
PULL #3	3.60	3.65		
PULL #4	3.63	3.60		
PULL #5	3.61	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.38		4.41
PULL #2	4.57	4.44		4.44
PULL #3	4.53	4.38		4.57
PULL #4	4.28	4.40		4.60
PULL #5	4.37	4.35		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636054
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.354189
1 TO	2	.0883233
1 TO	3	.469915
1 TO	4	.410191
1 TO	5	.514666

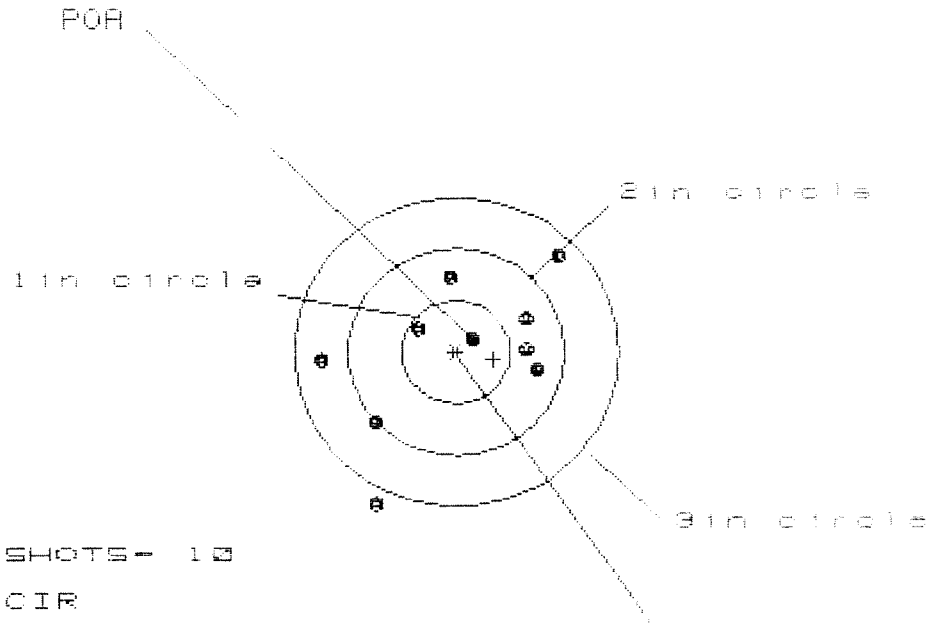
3 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.118
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0834
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144498
THE AMR FOR THIS RIFLE IS: .8478

18 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06638054

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.169

VS= 2.377

GS= 2.888

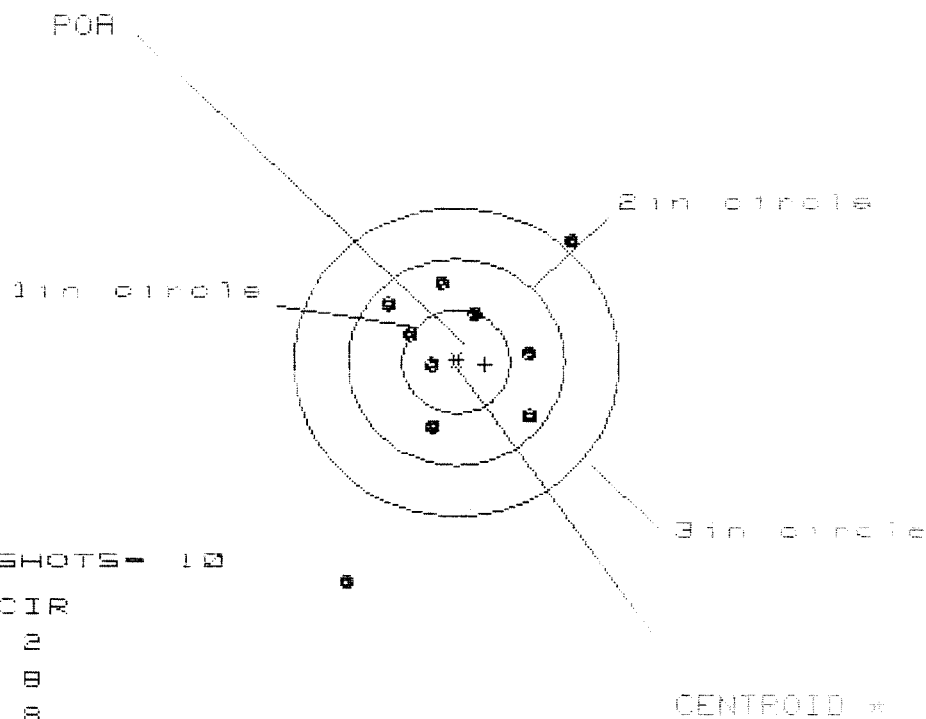
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.814	.791
MINIMUM X	-1.272	-1.355	-1.253
MAXIMUM Y	.912	.750	.679
MINIMUM Y	-1.465	-1.788	-1.695
CENTROID X	-.347	-.264	-.366
CENTROID Y	.071	.233	.140
POA TO CENTROID in.	.354	.353	.392
MIN RADIUS	.219	.117	.211
MEAN RADIUS	.866	.740	.709
MAX RADIUS	1.643	1.382	1.266
HORIZONTAL SPREAD	2.169	2.169	2.044
VERTICAL SPREAD	2.377	1.538	1.374
EXTREME SPREAD	2.888	2.398	2.044
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

10 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS = 2.083

VS = 3.317

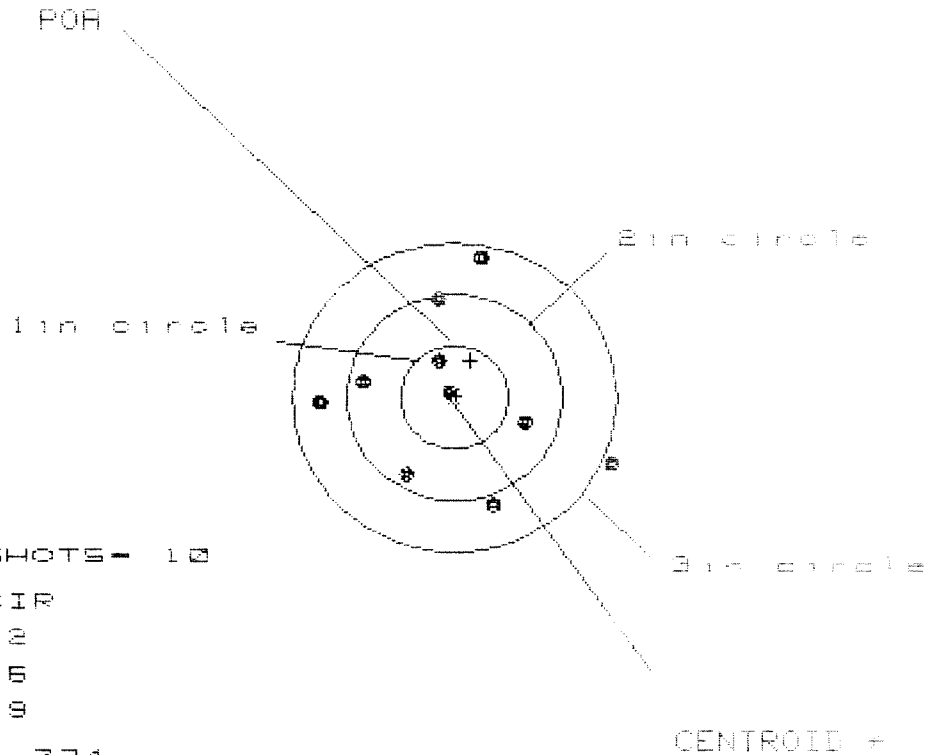
GS = 3.917

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.039	.923	.712
MINIMUM X	-1.044	-.701	-.586
MAXIMUM Y	1.210	.976	.626
MINIMUM Y	-2.107	-.859	-.737
CENTROID X	-.271	-.155	-.270
CENTROID Y	.026	.260	.138
POA TO CENTROID in.	.272	.302	.303
MIN RADIUS	.189	.222	.227
MEAN RADIUS	.890	.701	.605
MAX RADIUS	2.351	1.343	.913
HORIZONTAL SPREAD	2.083	1.624	1.298
VERTICAL SPREAD	3.317	1.835	1.363
EXTREME SPREAD	3.917	2.232	1.631
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		

10 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.734

VS = 2.423

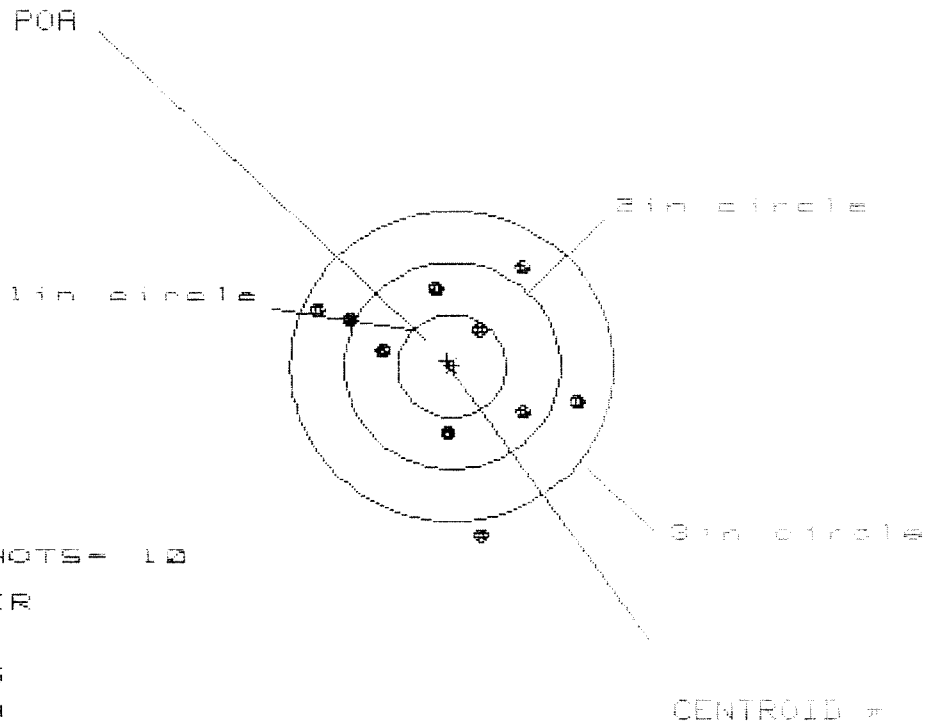
GS = 2.810

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.444	.839	.897
MINIMUM X	-1.296	-1.129	-1.071
MAXIMUM Y	1.355	1.280	1.035
MINIMUM Y	-1.069	-1.143	-1.983
CENTROID X	-.153	-.314	-.372
CENTROID Y	-.357	-.283	-.443
POA TO CENTROID in.	.389	.423	.579
MIN RADIUS	.030	.149	.224
MEAN RADIUS	.919	.834	.775
MAX RADIUS	1.591	1.361	1.155
HORIZONTAL SPREAD	2.734	1.968	1.968
VERTICAL SPREAD	2.423	2.423	2.018
EXTREME SPREAD	2.810	2.425	2.077
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.466

VS= 2.564

GS= 2.640

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.205
MINIMUM X	:	-1.261
MAXIMUM Y	:	.932
MINIMUM Y	:	-1.632
CENTROID X	:	.044
CENTROID Y	:	-.053
FOR TO CENTROID in.	:	.069
MIN RADIUS	:	.393
MEAN RADIUS	:	.972
MAX RADIUS	:	1.645
HORIZONTAL SPREAD	:	2.466
VERTICAL SPREAD	:	2.564
EXTREME SPREAD	:	2.640
NUMBER IN ONE INCH CIRCLE =	:	1
NUMBER IN TWO INCH CIRCLE =	:	5
NUMBER IN THREE INCH CIRCLE =	:	9

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CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = 1.457

VS = 1.514

GS = 1.653

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	.741	.474	.451
MINIMUM X	:	-.716	-.634	-.657
MAXIMUM Y	:	.863	.879	.513
MINIMUM Y	:	-.711	-.635	-.526
CENTROID X	:	.137	.055	.078
CENTROID Y	:	-.104	-.180	-.289
POR TO CENTROID in.	:	.172	.188	.300
MIN RADIUS	:	.217	.118	.042
MEAN RADIUS	:	.592	.530	.464
MAX RADIUS	:	1.008	.899	.661
HORIZONTAL SPREAD	:	1.457	1.108	1.108
VERTICAL SPREAD	:	1.514	1.514	1.039
EXTREME SPREAD	:	1.653	1.585	1.176
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	