

C6636165

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700TM M24

SERIAL NO. C6636165

ORDER NO. 5716

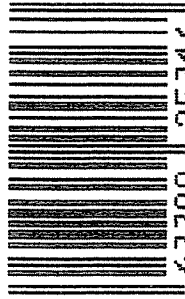
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636165

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636165

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	AD
	Apply Coating (Bolt)			P
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/7/91	WB

op. #	BARBER - M24 0038465	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			6/7/91	WB
	G) Safety Off Force	2 1/4	2	2			6/7/91	WB
	H) Trigger Pull Test & Retainability						6/7/91	WB
	I) Firing Pin Indent	.022	.022	.022			6/7/91	WB
	J) Assemble Stock						6/7/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/7/91	RW
	M) Iron Sight Alignment						6/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/7/91	RW
	O) Attach Scope to Rifle						6/7/91	RW
	P) Detach & Attach Scope 20 Times						6/7/91	RW
640	Gallery Target & Test						6-7-91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						6/7/91	KT
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.58	2.66	2.53	2.60	2.61	6-8-91	JP
	C) Function						6-8-91	DH
660	Pack						9-15-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6636165

DATE 6/7/91

TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.31	2.48	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.79	2.41	2.49	2.66	
PULL #3	2.30	2.46	2.35	2.53	
PULL #4	2.36	2.30	2.51	2.60	
PULL #5	2.25	2.34	2.53	2.61	
TOTAL	11.57	11.82	12.36		
AVG.	2.31	2.36	2.47		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.19		
PULL #2	3.11	3.15		
PULL #3	3.02	3.00		
PULL #4	3.11	3.15		
PULL #5	3.01	3.10		
TOTAL	15.47	15.59		
AVG.	3.09	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.18		4.19
PULL #2	4.14	4.00		4.09
PULL #3	4.25	4.03		4.26
PULL #4	4.15	4.15		4.18
PULL #5	4.18	4.15		4.23
TOTAL	20.79	20.51		20.95
AVG.	4.16	4.10		4.19

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636165
7 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0743303
1 TO	2	.189489
1 TO	3	.298518
1 TO	4	.238076
1 TO	5	.192169

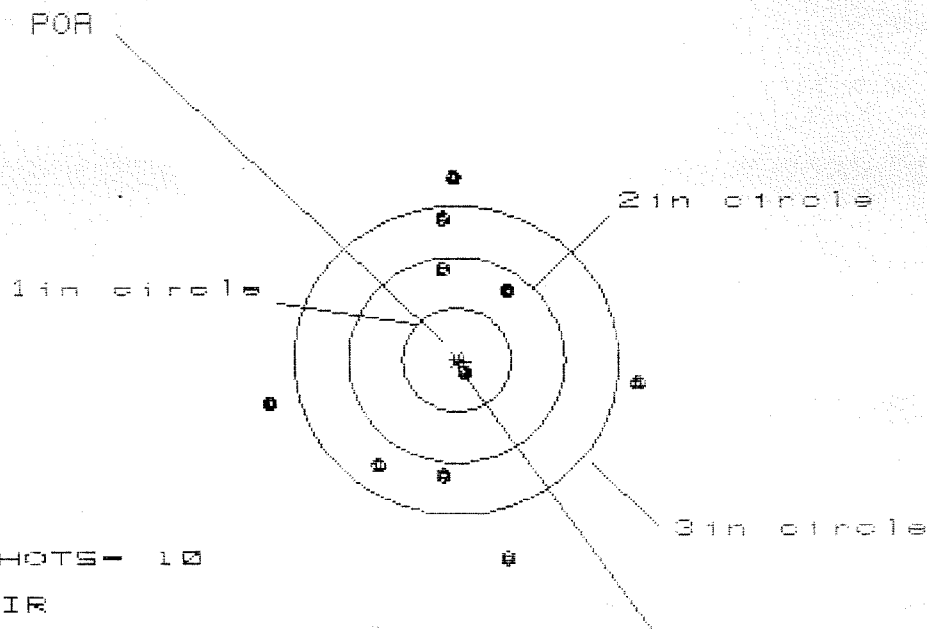
48 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0516
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0166
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0542044
THE AMR FOR THIS RIFLE IS: .8914

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836165

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 3

3in - 6

HS= 3.445

VS= 3.718

GS= 3.757

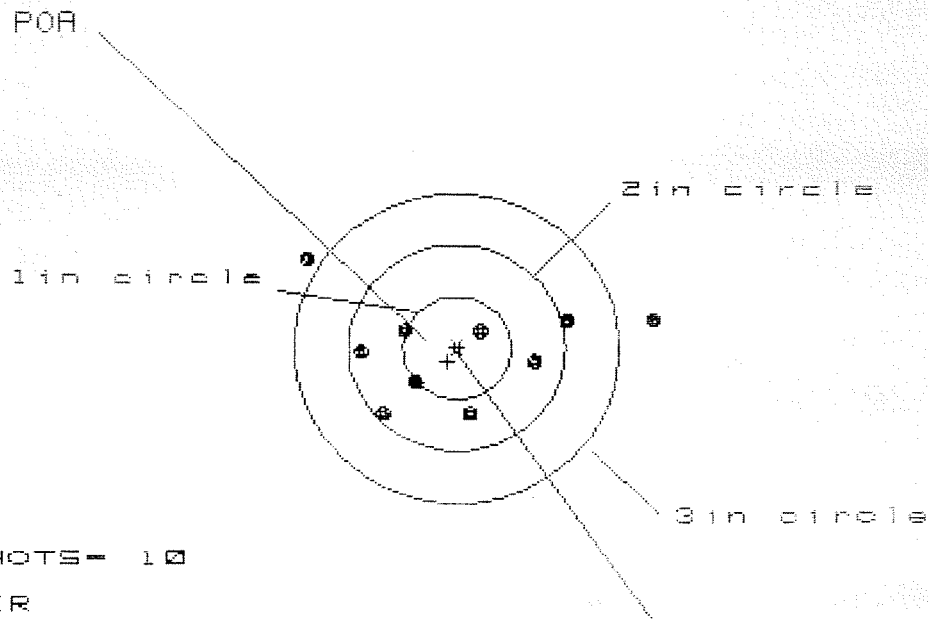
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.714	1.771	1.776
MINIMUM X	-1.731	-1.674	-1.669
MAXIMUM Y	1.791	1.577	1.335
MINIMUM Y	-1.927	-1.325	-1.128
CENTROID X	-.071	-.128	-.133
CENTROID Y	.022	.236	.039
POA TO CENTROID in.	.074	.269	.138
MIN RADIUS	.110	.321	.168
MEAN RADIUS	1.292	1.204	1.147
MAX RADIUS	1.995	1.817	1.788
HORIZONTAL SPREAD	3.445	3.445	3.445
VERTICAL SPREAD	3.718	2.902	2.463
EXTREME SPREAD	3.757	3.455	3.455
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 3.154

VS= 1.485

GS= 3.208

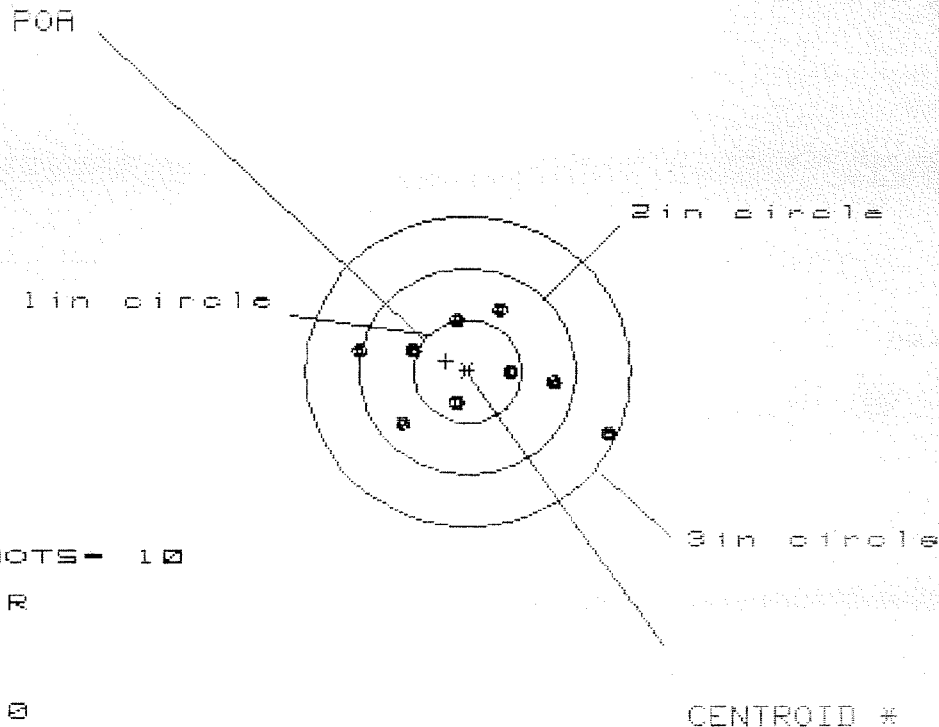
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.770	1.248	1.100
MINIMUM X	:	-1.384	-1.187	-.870
MAXIMUM Y	:	.861	.892	.367
MINIMUM Y	:	-.624	-.593	-.482
CENTROID X	:	.084	-.113	.035
CENTROID Y	:	.131	.100	-.011
POA TO CENTROID in.	:	.155	.151	.037
MIN RADIUS	:	.275	.313	.341
MEAN RADIUS	:	.894	.769	.671
MAX RADIUS	:	1.792	1.485	1.159
HORIZONTAL SPREAD	:	3.154	2.435	1.970
VERTICAL SPREAD	:	1.485	1.485	.849
EXTREME SPREAD	:	3.208	2.517	1.993
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.349

VS= 1.181

GS= 2.494

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.309	.954	.842
MINIMUM X	:	-1.039	-.894	-.534
MAXIMUM Y	:	.573	.506	.526
MINIMUM Y	:	-.608	-.614	-.594
CENTROID X	:	.201	.056	.168
CENTROID Y	:	-.101	-.034	-.054
POA TO CENTROID in.	:	.225	.065	.176
MIN RADIUS	:	.351	.375	.393
MEAN RADIUS	:	.707	.604	.566
MAX RADIUS	:	1.444	.976	.862
HORIZONTAL SPREAD	:	2.349	1.848	1.376
VERTICAL SPREAD	:	1.181	1.120	1.120
EXTREME SPREAD	:	2.494	1.884	1.436
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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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 = 5

2 in = 7

3 in = 10

HS = 1.771

VS = 2.464

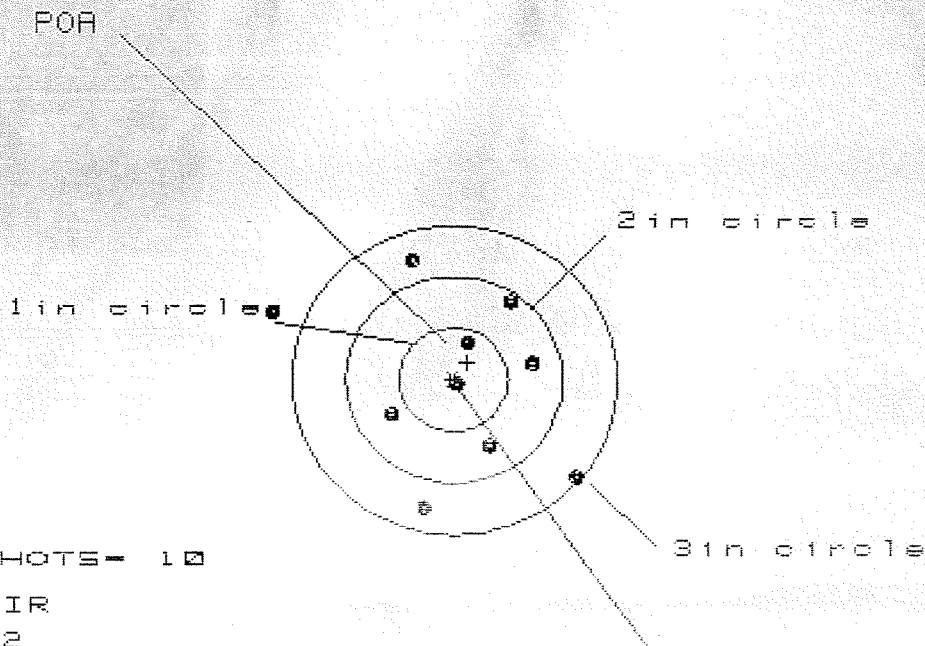
GS = 2.487

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.100	1.170	1.214
MINIMUM X	:	-.671	-.601	-.557
MAXIMUM Y	:	1.188	.473	.330
MINIMUM Y	:	-1.276	-1.144	-.289
CENTROID X	:	.167	.097	.053
CENTROID Y	:	.028	-.104	.039
POA TO CENTROID in.	:	.169	.143	.066
MIN RADIUS	:	.130	.052	.100
MEAN RADIUS	:	.632	.536	.425
MAX RADIUS	:	1.342	1.262	1.250
HORIZONTAL SPREAD	:	1.771	1.771	1.771
VERTICAL SPREAD	:	2.464	1.617	.619
EXTREME SPREAD	:	2.487	1.876	1.876
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.842

VS= 2.413

GS= 3.261

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.116	.925	.686
MINIMUM X	-1.726	-.732	-.617
MAXIMUM Y	1.161	1.233	1.123
MINIMUM Y	-1.252	-1.180	-1.290
CENTROID X	-.123	.068	-.047
CENTROID Y	-.163	-.235	-.126
POA TO CENTROID in.	.204	.245	.134
MIN RADIUS	.078	.154	.113
MEAN RADIUS	.932	.819	.746
MAX RADIUS	1.844	1.352	1.332
HORIZONTAL SPREAD	2.842	1.657	1.303
VERTICAL SPREAD	2.413	2.413	2.413
EXTREME SPREAD	3.261	2.578	2.415
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	