

C6636170

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6636170

ORDER NO.
5716

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

5716 C6636170

LPC

0 47700 25716 7

Stock
Repaired

GUN SERIAL # C6636170

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KJ
600	Proof		5/3/91	KJ
607	Check Headspace		5/3/91	KJ
610	Dis-assemble Gun		5/3/91	KJ
612	Magnaflux Barrel Action	5 6 0 1		KCR
	Magnaflux Bolt	5 6 9 1		KCR
615	Rollmark Caliber	1 5 6 9		G.S.
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	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/4/91	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	KJ
	C) Inspect Ejector Hole for Chamfer		6/4/91	KJ
	D) Oil Firing Pin Ass'y		4/4/91	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	JP

op. #	BARBER - M24 0038520	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-11-91	QU
	G) Safety Off Force	4	4	4			6-11-91	QU
	H) Trigger Pull Test & Retainability						6-11-91	QU
	I) Firing Pin Indent	.0225	.0215	.0215			6-11-91	QU
	J) Assemble Stock						6/11/91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/11/91	KS
	M) Iron Sight Alignment						6/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/11/91	KS
	O) Attach Scope to Rifle						6/11/91	KS
	P) Detach & Attach Scope 20 Times						6/11/91	KS
640	Gallery Target & Test						6/12/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						6/12/91	KS
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.70	2.75	2.55	2.55	2.58	6-13-91	QU
	C) Function						6-13-91	K
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06636170DATE 6-11-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.53	2.60	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.55	2.58	2.75	
PULL #3	2.52	2.55	2.56	2.55	
PULL #4	2.51	2.56	2.48	2.55	
PULL #5	2.52	2.58	2.55	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.44		
PULL #2	3.50	3.54		
PULL #3	3.55	3.53		
PULL #4	3.54	3.49		
PULL #5	3.48	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.29		4.35
PULL #2	4.30	4.32		4.23
PULL #3	4.36	4.34		4.39
PULL #4	4.44	4.33		4.38
PULL #5	4.30	4.33		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636170
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.109786
1 TO	2	.240753
1 TO	3	.0870919
1 TO	4	.145602
1 TO	5	.0687095

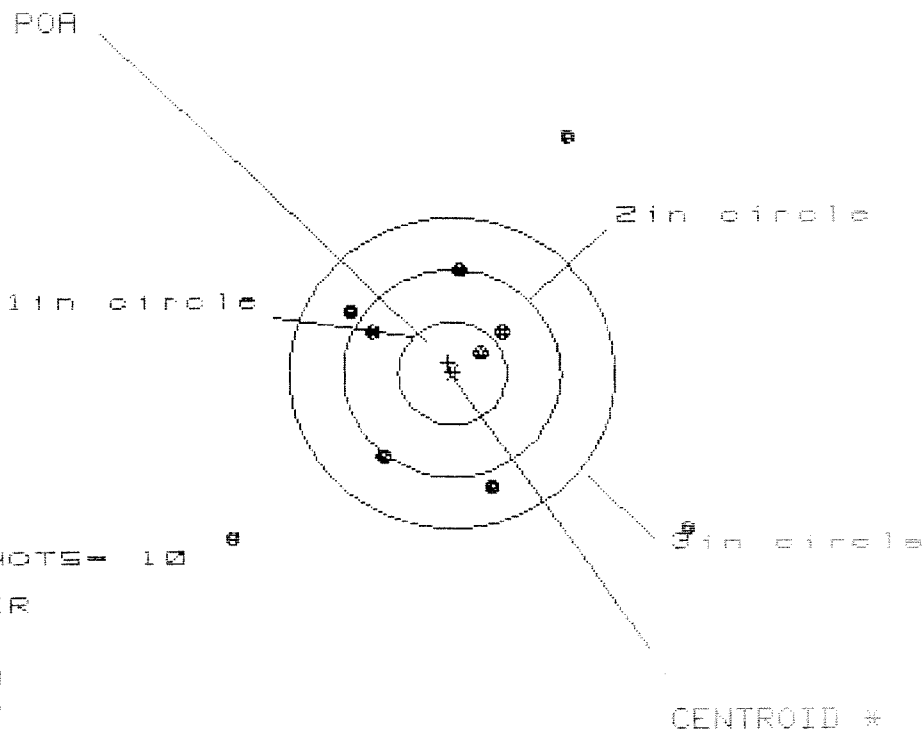
4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0312
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0854459
THE AMR FOR THIS RIFLE IS: 1.184

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635170

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 4.190

VS = 3.912

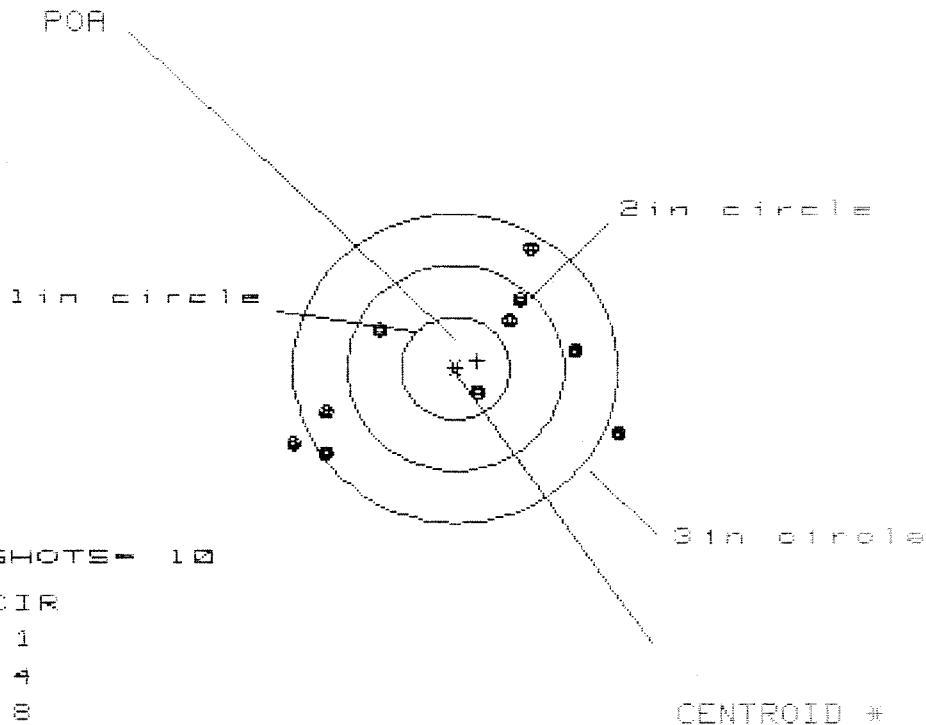
GS = 5.835

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.120	1.890	1.105
MINIMUM X	:	-2.070	-1.143	-0.907
MAXIMUM Y	:	2.301	2.122	1.909
MINIMUM Y	:	-1.611	-1.703	-1.462
CENTROID X	:	.038	.268	.032
CENTROID Y	:	-.103	.076	.289
POA TO CENTROID in.	:	.110	.279	.290
MIN RADIUS	:	.359	.070	.319
MEAN RADIUS	:	1.391	1.211	1.025
MAX RADIUS	:	2.623	2.544	2.206
HORIZONTAL SPREAD	:	4.190	3.033	2.012
VERTICAL SPREAD	:	3.912	3.825	3.372
EXTREME SPREAD	:	5.835	3.959	3.551
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C08636170

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.010

VS = 1.966

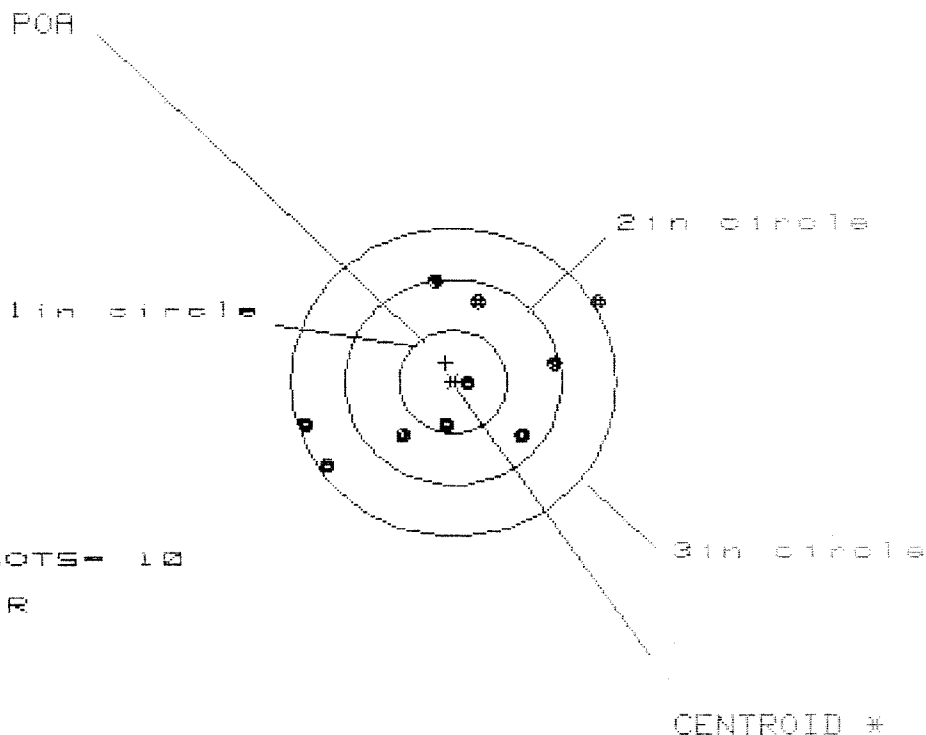
CS = 3.011

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.547
MINIMUM X	-1.463
MAXIMUM Y	1.184
MINIMUM Y	-0.782
CENTROID X	-0.201
CENTROID Y	-0.074
POA TO CENTROID in.	.214
MIN RADIUS	.308
MEAN RADIUS	1.121
MAX RADIUS	1.687
HORIZONTAL SPREAD	3.010
VERTICAL SPREAD	1.966
EXTREME SPREAD	3.011
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636170

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS= 2.740

VS= 1.818

GS= 2.993

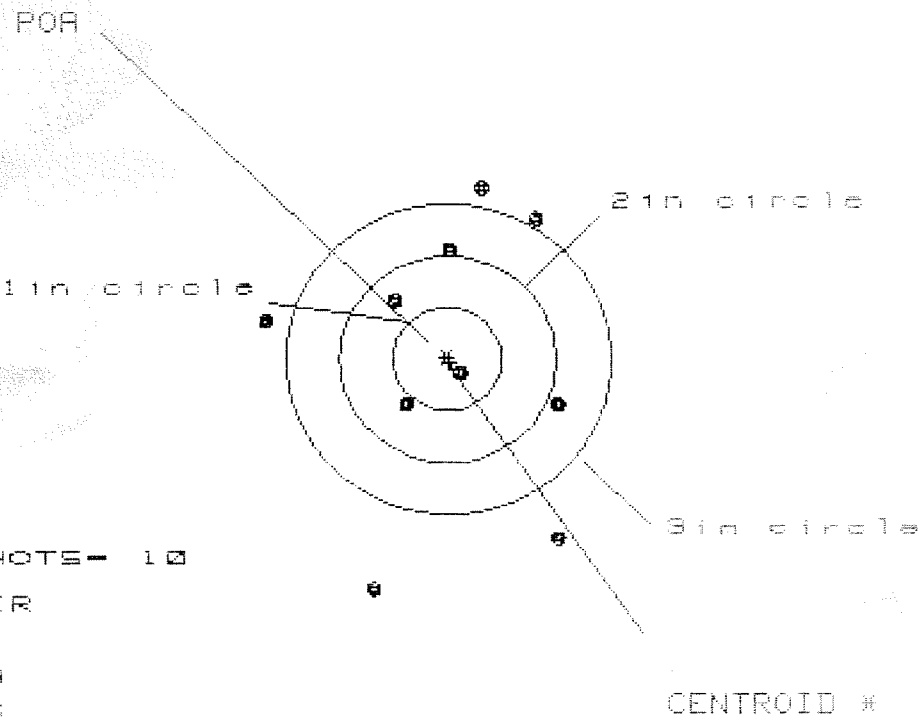
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.348	1.063	.908
MINIMUM X	:	-1.393	-1.243	-1.175
MAXIMUM Y	:	.993	1.075	1.028
MINIMUM Y	:	-.825	-.743	-.798
CENTROID X	:	.070	-.080	.075
CENTROID Y	:	-.184	-.266	-.219
POA TO CENTROID in.	:	.197	.278	.231
MIN RADIUS	:	.183	.304	.169
MEAN RADIUS	:	.928	.861	.779
MAX RADIUS	:	1.538	1.299	1.416
HORIZONTAL SPREAD	:	2.740	2.306	2.083
VERTICAL SPREAD	:	1.818	1.818	1.818
EXTREME SPREAD	:	2.993	2.392	2.310
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08686170

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS = 2.725

VS = 3.888

GS = 4.036

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.047
MINIMUM X	-1.678
MAXIMUM Y	1.636
MINIMUM Y	-2.252
CENTROID X	-.014
CENTROID Y	.033
POA TO CENTROID in.	.036
MIN RADIUS	.196
MEAN RADIUS	1.295
MAX RADIUS	2.368
HORIZONTAL SPREAD	2.725
VERTICAL SPREAD	3.888
EXTREME SPREAD	4.036
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	5

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636170

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 2.378

VS = 3.075

GS = 3.595

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.284	1.174	1.064
MINIMUM X	-1.094	-1.204	-1.314
MAXIMUM Y	1.191	.982	.752
MINIMUM Y	-1.884	-1.838	-1.424
CENTROID X	-.026	.084	.194
CENTROID Y	-.078	.131	.361
POA TO CENTROID in.	.082	.156	.410
MIN RADIUS	.306	.114	.099
MEAN RADIUS	1.186	.996	.802
MAX RADIUS	2.128	2.040	1.778
HORIZONTAL SPREAD	2.378	2.378	2.378
VERTICAL SPREAD	3.075	2.820	2.176
EXTREME SPREAD	3.595	3.266	2.763
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		