

C6649290

MODEL 780TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®] **Remington**[®] **Remington**[®]

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

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

MODEL 700TM M24

SERIAL NO. C6649290

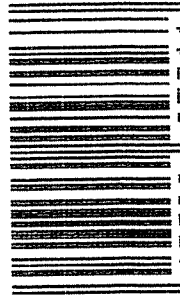
ORDER NO. 5716

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



5716 C6649290

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649290

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	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-8-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	JH

op. #	BARBER M24 0067383	READINGS				DATE	INIT
625 cont.	F) Safety On Force	5	5	5		8-15-91	JH
	G) Safety Off Force	3	3	3		8-15-91	JH
	H) Trigger Pull Test & Retainability					8-15-91	JH
	I) Firing Pin Indent	0205	0205	020		8-15-91	JH
	J) Assemble Stock					8-16-91	RW
	K) Assemble Swivel Studs					8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies					8-16-91	RW
	M) Iron Sight Alignment					8-16-91	RW
	N) Detach Front & Rear Sights & place in numbered container					8-16-91	RW
	O) Attach Scope to Rifle					8-16-91	RW
	P) Detach & Attach Scope 20 Times					8-16-91	RW
640	Gallery Target & Test					8-16-91	AC
	A) Time					8-16-91	AC
	B) Malfunctions					8-16-91	AC
	C) Pierced Primers					8-16-91	AC
	D) Optical Clarity of Scope					8-16-91	AC
645	Inspect for Live Ammo					8-16-91	AC
655	Final Inspection						
	A) Headspace					8-17-91	D/H
	B) Trigger Pull	266	278	278	278	2.42	8-17-91
	C) Function					8-17-91	D/H
660	Pack					8-17-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6649290.1000

DATE 8-15-91 (D)

TESTER JH (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.37	2.40	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.36	2.38	2.78	
PULL #3	2.58	2.46	2.35	2.78	
PULL #4	2.56	2.43	2.42	2.78	
PULL #5	2.66	2.35	2.44	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.18		
PULL #2	3.25	3.22		
PULL #3	3.24	3.14		
PULL #4	3.23	3.22		
PULL #5	3.20	3.18		
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	4.22		4.38
PULL #2	4.56	4.38		4.48
PULL #3	4.53	4.30		4.44
PULL #4	4.56	4.31		4.46
PULL #5	4.60	4.43		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649290
22 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.435178
1 TO 2	.181397
1 TO 3	.495371
1 TO 4	.484451
1 TO 5	.214133

POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0704
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2306
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241187
THE AMR FOR THIS RIFLE IS: 1.053

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649290

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 4

HS = 2.033

VS = 3.595

GS = 3.812

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.016	.670	.729
MINIMUM X	-1.017	-.904	-.845
MAXIMUM Y	1.804	2.002	1.945
MINIMUM Y	-1.791	-1.593	-1.343
CENTROID X	-.098	-.211	-.270
CENTROID Y	-.424	-.622	-.872
POA TO CENTROID in.	.436	.657	.913
MIN RADIUS	.463	.475	.397
MEAN RADIUS	1.339	1.231	1.086
MAX RADIUS	2.046	2.057	2.077
HORIZONTAL SPREAD	2.033	1.574	1.574
VERTICAL SPREAD	3.595	3.595	3.288
EXTREME SPREAD	3.812	3.599	3.344
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	4		

22 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8849290

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 8

HS = 2.973

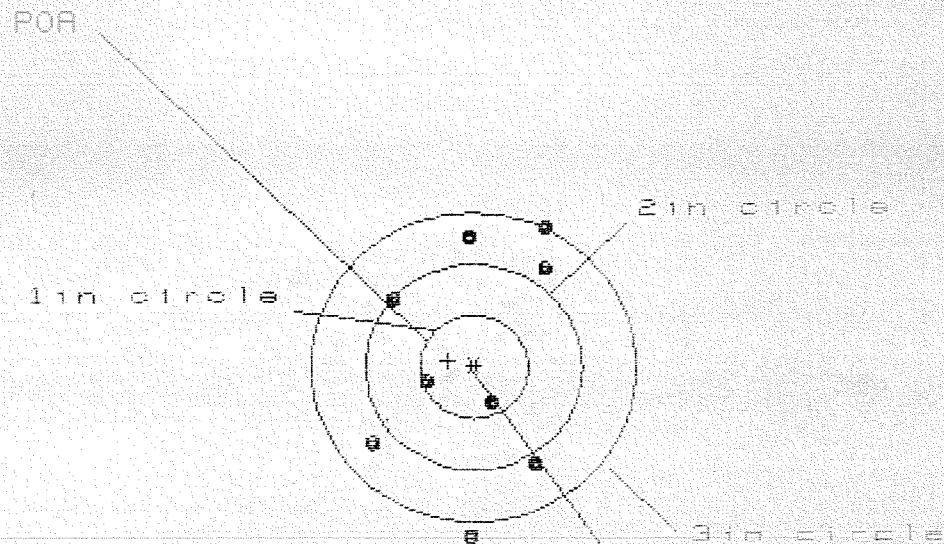
VS = 1.938

GS = 3.267

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	1.182	1.009
MINIMUM X	:	-1.543	-1.384	-1.365
MAXIMUM Y	:	.958	.849	.882
MINIMUM Y	:	-.980	-1.066	-1.033
CENTROID X	:	.083	-.076	.097
CENTROID Y	:	-.412	-.303	-.336
POA TO CENTROID in.	:	.420	.312	.349
MIN RADIUS	:	.258	.241	.182
MEAN RADIUS	:	1.070	.993	.902
MAX RADIUS	:	1.734	1.452	1.553
HORIZONTAL SPREAD	:	2.973	2.566	2.374
VERTICAL SPREAD	:	1.938	1.915	1.915
EXTREME SPREAD	:	3.267	2.824	2.824
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

FILE:/PATTERNING/CENTERFIRE PATT/CS649290

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

11-13

217 - 4

$$\sin = 0$$

15- 1-567

$$V_3 = 3.927$$

CE- 3.105

GENERAL

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.655	.651	.720
MINIMUM X	:	-.911	-.916	-.834
MAXIMUM Y	:	1.377	1.193	1.183
MINIMUM Y	:	-1.651	-1.005	-.936
CENTROID X	:	.238	.243	.161
CENTROID Y	:	-.060	.123	-.026
POA TO CENTROID in.	:	.246	.272	.163
MIN RADIUS	:	.387	.556	.416
MEAN RADIUS	:	1.003	.943	.858
MAX RADIUS	:	1.651	1.359	1.104
HORIZONTAL SPREAD	:	1.567	1.567	1.554
VERTICAL SPREAD	:	3.027	2.278	2.119
EXTREME SPREAD	:	3.105	2.668	2.327
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649290

CENTERFIRE PATTERNS

4

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.479

VS= 2.213

GS= 3.137

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.852	.847
MINIMUM X	:	-1.464	-1.018	-.912
MAXIMUM Y	:	.991	1.069	.926
MINIMUM Y	:	-1.222	-1.144	-1.026
CENTROID X	:	.285	.368	.262
CENTROID Y	:	-.046	-.124	.019
POB TO CENTROID in.	:	.218	.388	.262
MIN RADIUS	:	.348	.253	.278
MEAN RADIUS	:	.953	.859	.779
MAX RADIUS	:	1.623	1.427	1.249
HORIZONTAL SPREAD	:	2.479	1.870	1.759
VERTICAL SPREAD	:	2.213	2.213	1.952
EXTREME SPREAD	:	3.137	2.525	2.020
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649290

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.720

VS = 1.513

GS = 3.076

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.083

.901

.933

MINIMUM X

-1.637

-1.383

-1.271

MAXIMUM Y

.825

.749

.833

MINIMUM Y

-.688

-.617

-.533

CENTROID X

-.076

.106

-.006

CENTROID Y

-.211

-.135

-.219

POA TO CENTROID in.

.224

.172

.219

MIN RADIUS

.244

.086

.176

MEAN RADIUS

.898

.757

.717

MAX RADIUS

1.776

1.462

1.329

HORIZONTAL SPREAD

2.720

2.284

2.204

VERTICAL SPREAD

1.513

1.366

1.366

EXTREME SPREAD

3.076

2.556

2.205

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9