

CS649304

MODEL 700TM M24

Model **SMS**

TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

SERIAL NO. C6649304

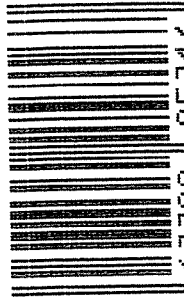
ORDER NO. 5716

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



5716 C6649304

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649304

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	LS
617	Drill and Tap Sight Holes	JUL	2 1991	WB
618	Polish Barrel	JUL	1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/1/91	JP

op. #	BARBER - M24 0067588 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-1-91	JH
	G) Safety Off Force	4	4	4			8-1-91	JH
	H) Trigger Pull Test & Retainability						8-1-91	JH
	I) Firing Pin Indent	.0215	.0215	.0215			8-1-91	JH
	J) Assemble Stock						8/2/91	Rev
	K) Assemble Swivel Studs						8-6-91	Ac
	L) Attach Front and Rear Sight Assemblies						8/2/91	Rev
	M) Iron Sight Alignment						8/2/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						8/2/91	Rev
	O) Attach Scope to Rifle						8/2/91	Rev
	P) Detach & Attach Scope 20 Times						8/2/91	Rev
640	Gallery Target & Test						8/2/91	KT
	A) Time						1	KT
	B) Malfunctions						1	KT
	C) Pierced Primers						1	KT
	D) Optical Clarity of Scope						1	KT
645	Inspect for Live Ammo						8/2/91	KT
655	Final Inspection							
	A) Headspace						8-6-91	Ac
	B) Trigger Pull	259	251	249	250	248	8-6-91	JH
	C) Function						8-6-91	Ac
660	Pack						9-19-91	Ac

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

SERIAL NO. C-6649304DATE 8-1-91TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.51	2.40	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.59	2.38	2.51	
PULL #3	2.22	2.51	2.55	2.49	
PULL #4	2.47	2.58	2.50	2.50	
PULL #5	2.46	2.43	2.48	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.31		
PULL #2	3.59	3.23		
PULL #3	3.58	3.15		
PULL #4	3.34	3.18		
PULL #5	3.45	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.36		4.37
PULL #2	4.36	4.41		4.49
PULL #3	4.37	4.43		4.42
PULL #4	4.34	4.46		4.40
PULL #5	4.41	4.50		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649304
2 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.412167
1 TO	2	.321759
1 TO	3	.495534
1 TO	4	.351161
1 TO	5	.840669

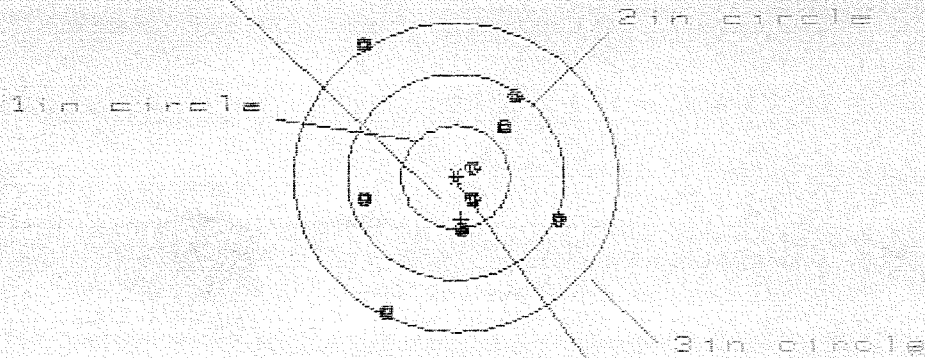
1/2 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1826
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .159
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .242123
THE ANR FOR THIS RIFLE IS: .9712

FILE:/PATTERNING/CENTERFIRE PATT/C6649304

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

17-3

217 - 2

$$21n = 9$$

HE- 1.017

V3= 2.500

GS- 2.074

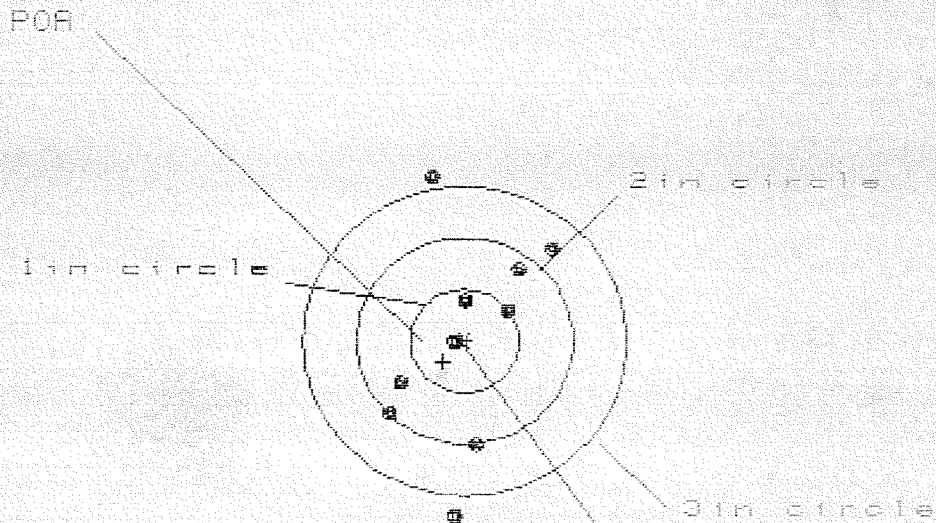
CENTROID $\bar{x}$

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.951	.856	.762
MINIMUM X	:	-.866	-.961	-1.055
MAXIMUM Y	:	1.256	.967	.821
MINIMUM Y	:	-1.310	-1.171	-1.508
CENTROID X	:	-.051	.044	.138
CENTROID Y	:	.409	.270	.416
POA TO CENTROID in.	:	.412	.273	.438
MIN RADIUS	:	.205	.053	.116
MEAN RADIUS	:	.772	.645	.556
MAX RADIUS	:	1.521	1.389	1.074
HORIZONTAL SPREAD	:	1.817	1.817	1.817
VERTICAL SPREAD	:	2.566	2.138	1.329
EXTREME SPREAD	:	2.574	2.442	1.825
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Aug 1991

FILE: /PATTERNING/CENTERFIRE_PATT/08649304

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.495

VS= 3.259

GS= 3.268

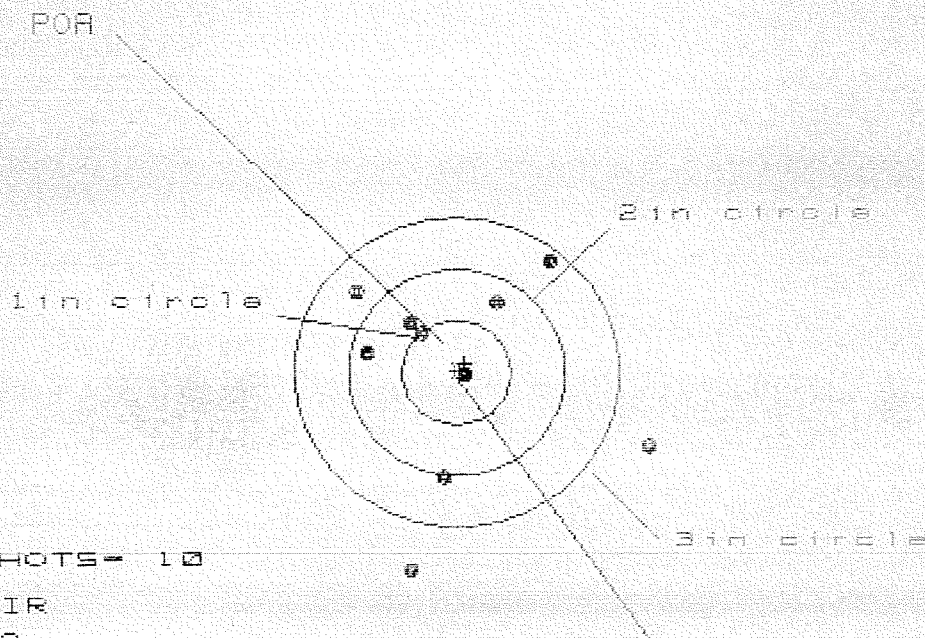
CENTROID x

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.790	.780	.737
MINIMUM X	:	-.705	-.715	-.758
MAXIMUM Y	:	1.605	1.422	.867
MINIMUM Y	:	-1.653	-1.200	-1.022
CENTROID X	:	.197	.207	.250
CENTROID Y	:	.204	.387	.210
POA TO CENTROID in.	:	.283	.439	.326
MIN RADIUS	:	.101	.180	.153
MEAN RADIUS	:	.908	.805	.725
MAX RADIUS	:	1.656	1.463	1.138
HORIZONTAL SPREAD	:	1.495	1.495	1.495
VERTICAL SPREAD	:	3.259	2.622	1.889
EXTREME SPREAD	:	3.268	2.665	2.192
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Aug 1981

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.707

VS= 2.954

GS= 3.200

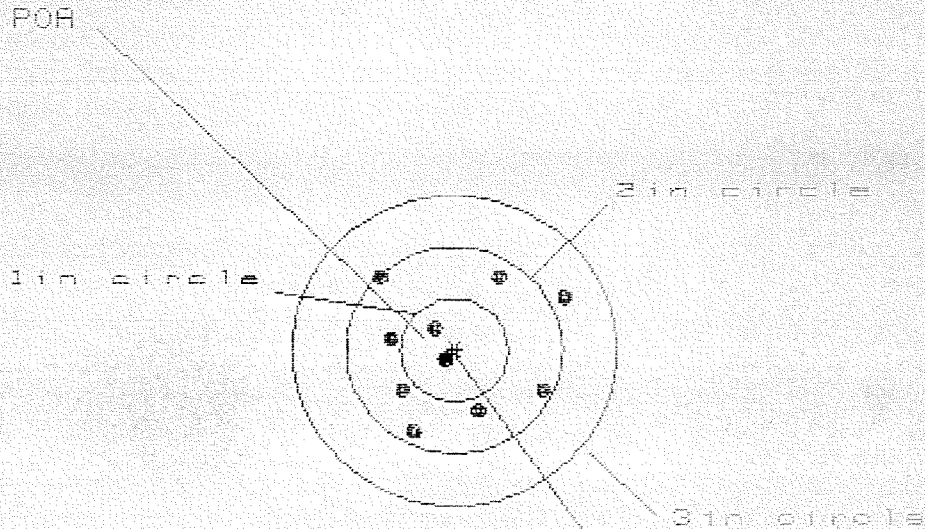
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.742	1.697	.993
MINIMUM X	:	-.966	-1.010	-.798
MAXIMUM Y	:	1.063	.852	.734
MINIMUM Y	:	-1.891	-1.187	-1.305
CENTROID X	:	-.074	-.030	-.242
CENTROID Y	:	-.086	.125	.243
POA TO CENTROID in.	:	.113	.128	.343
MIN RADIUS	:	.072	.184	.135
MEAN RADIUS	:	1.021	.891	.700
MAX RADIUS	:	1.934	1.943	1.306
HORIZONTAL SPREAD	:	2.707	2.707	1.791
VERTICAL SPREAD	:	2.954	2.039	2.039
EXTREME SPREAD	:	3.200	3.100	2.243
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 1.687

VS= 1.436

GS= 1.863

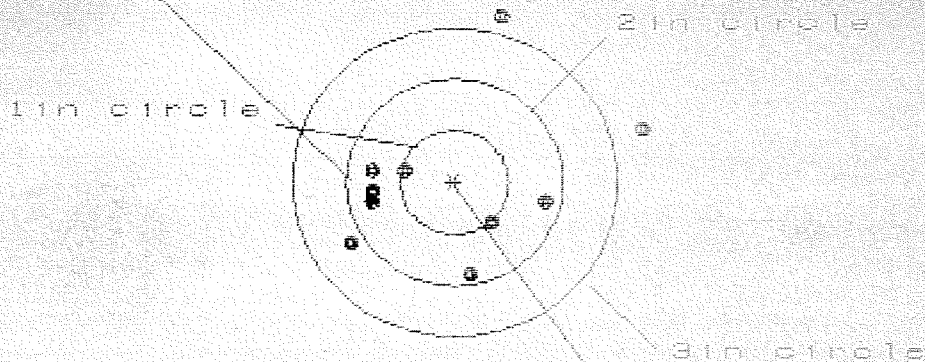
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.992
MINIMUM X	-.695
MAXIMUM Y	.679
MINIMUM Y	-.757
CENTROID X	.082
CENTROID Y	.084
POA TO CENTROID in.	.118
MIN RADIUS	.130
MEAN RADIUS	.696
MAX RADIUS	1.118
HORIZONTAL SPREAD	1.687
VERTICAL SPREAD	1.436
EXTREME SPREAD	1.863
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	9
NUMBER IN THREE INCH CIRCLE	10

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 2.680

VS= 2.493

GS= 2.881

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.756	1.059	1.143
MINIMUM X	-.924	-.729	-.645
MAXIMUM Y	1.606	1.658	1.401
MINIMUM Y	-.887	-.835	-.628
CENTROID X	.759	.564	.486
CENTROID Y	.184	.132	-.075
POA TO CENTROID in.	.782	.580	.486
MIN RADIUS	.447	.300	.427*
MEAN RADIUS	.959	.808	.653
MAX RADIUS	1.818	1.790	1.148
HORIZONTAL SPREAD	2.680	1.788	1.788
VERTICAL SPREAD	2.493	2.493	1.029
EXTREME SPREAD	2.881	2.604	1.841
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		