

C6611402

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **571E**

*Includes 1 in chamber.



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

MODEL 700TM M24

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

SERIAL NO.
C6611402

ORDER NO.
5716

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

20



5716 C6611402

UPC



0 47700 25716 7

GEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611402

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1' 25"		RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1' 25	91	GLS
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel <i>RBB</i>	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/14/91	SL

op. #	BARBER M24 0076241	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/16/91	WB
	G) Safety Off Force	3	3	3			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/16/91	JL
	I) Firing Pin Indent	0205	0203	0205			2/16/91	WB
	J) Assemble Stock						2/18/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	RW
	M) Iron Sight Alignment						2/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	RW
	O) Attach Scope to Rifle						2/18/91	RW
	P) Detach & Attach Scope 20 Times						2/18/91	RW
640	Gallery Target & Test						2-19-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-19-91	NF
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.33	2.35	2.33	2.34	2.39	2/21/91	JL
	C) Function						2-22-91	AC
660	Pack						3-19-91	NF

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

SERIAL NO. C6611402DATE 2/16/91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.21	2.41	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.23	2.38	2.35	
PULL #3	2.22	2.25	2.40	2.33	
PULL #4	2.50	2.19	2.42	2.34	
PULL #5	2.27	2.42	2.42	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.34		
PULL #2	3.38	3.31		
PULL #3	3.35	3.35		
PULL #4	3.50	3.50		
PULL #5	3.39	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	4.23	4.14		4.30
PULL #2	4.40	4.27		4.25
PULL #3	4.23	4.26		4.32
PULL #4	4.34	4.20		4.28
PULL #5	4.30	4.31		4.20
TOTAL				
AVG.				

REL DISTANCE CALCULATIONS
 RIFLE # 06611402
 Feb 1991

INITIAL DISTANCES

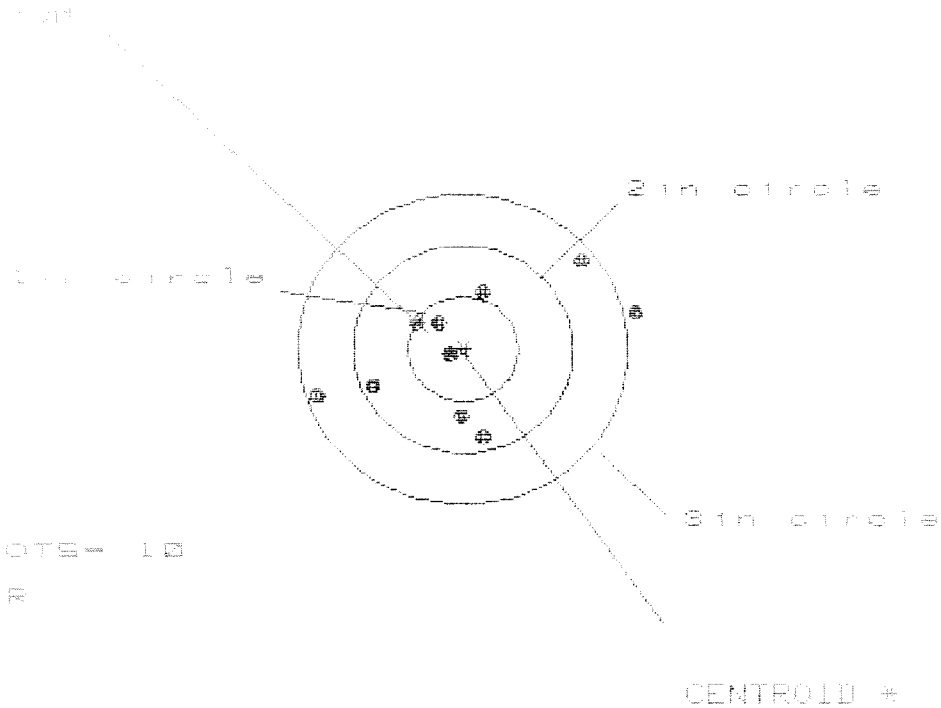
0 TO	1	.131913
1 TO	2	.281784
1 TO	3	.256564
1 TO	4	.135772
1 TO	5	.338195

54 <----POR

THE BORE - PORRAGE FOR THIS RIFLE IS: -.047
 THE BORE - PORRAGE FOR THIS RIFLE IS: -.019
 THE BORE - PORRAGE RADIUS FOR THIS RIFLE IS: .0506952
 THE BORE - PORRAGE RADIUS FOR THIS RIFLE IS: .0228

FILE: PATTERNING/CENTERFIRE_PATT/00811482

CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 6

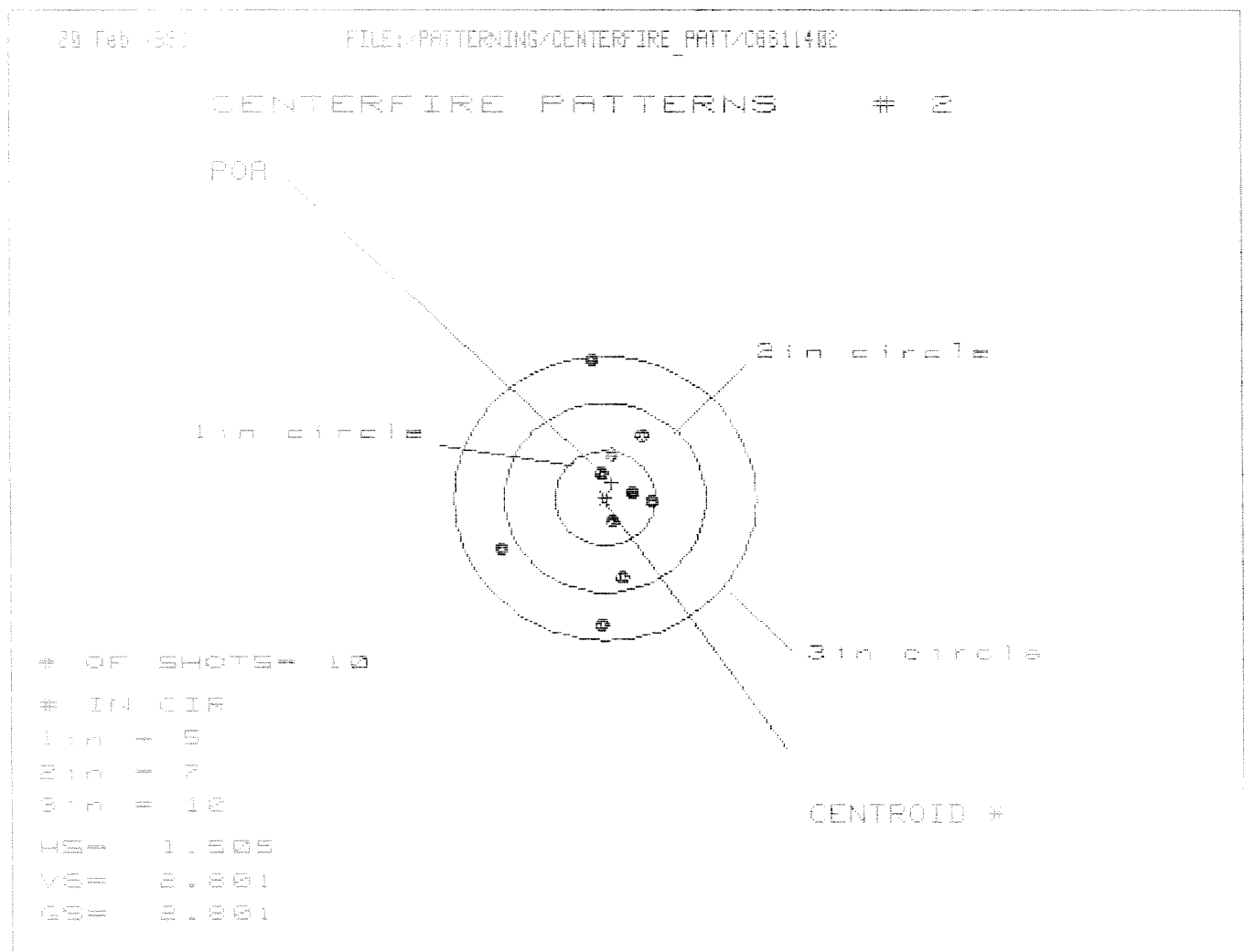
ME = 2.656

SE = 1.781

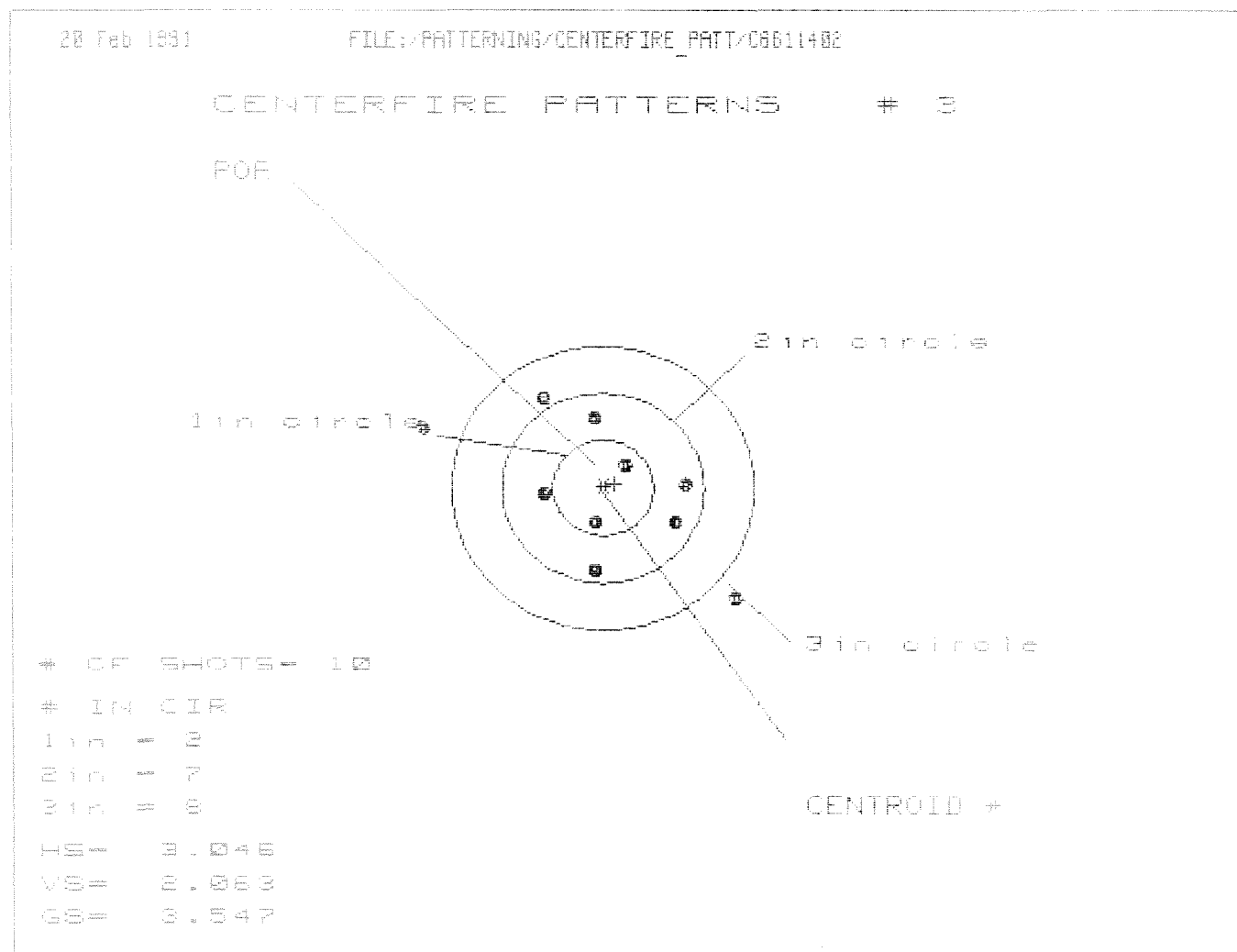
GE = 2.976

PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.560	1.248	.494
MINIMUM X	-1.296	-1.122	-.966
MAXIMUM Y	.861	.985	.694
MINIMUM Y	-.840	-.796	-.683
CENTROID X	.124	-.050	-.206
CENTROID Y	.045	.001	-.112
FOR TO CENTROID in.	.132	.050	.234
1 in. RADIUS	.120	.060	.247
2 in. RADIUS	.830	.707	.609
3 in. RADIUS	1.611	1.541	1.006
1 in. SPREAD	2.856	2.370	1.461
2 in. SPREAD	1.701	1.701	1.377
3 in. SPREAD	2.976	2.701	1.736
ONE INCH CIRCLE =		2	
TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

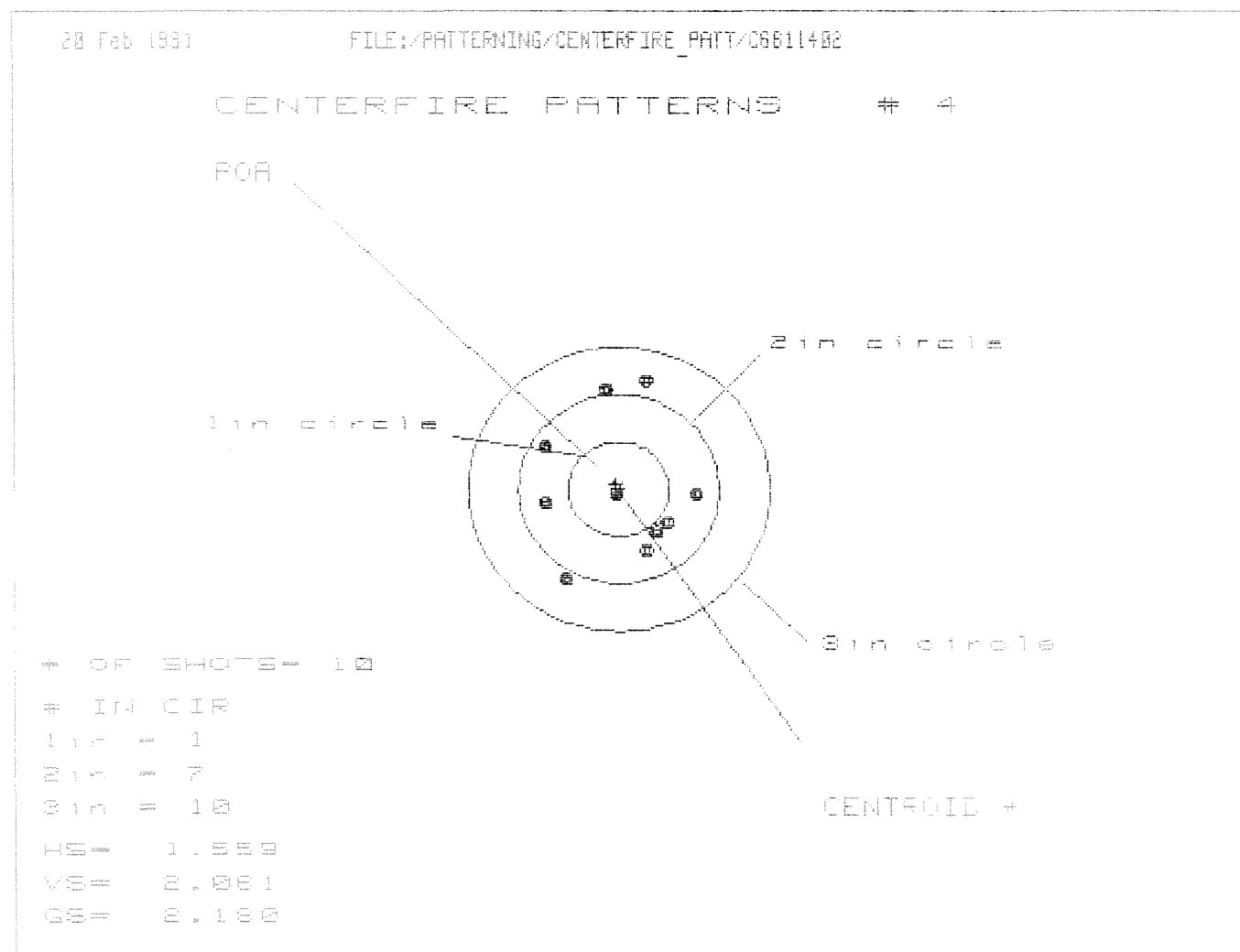


PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.422	.411	.401
MINIMUM X	-1.083	-1.094	-1.104
MAXIMUM Y	1.479	.876	.731
MINIMUM Y	-1.322	-1.157	-.849
CENTROID X	-.065	-.054	-.044
CENTROID Y	-.164	-.329	-.184
POB TO CENTROID (in.)	.177	.333	.190
1in RADIUS	.235	.091	.224
2in RADIUS	.729	.650	.559
3in RADIUS	1.483	1.159	1.217
HORIZONTAL SPREAD	1.505	1.505	1.505
VERTICAL SPREAD	2.801	2.033	1.580
EXTREME SPREAD	2.801	2.070	1.880
NUMBER IN ONE INCH CIRCLE =	5		



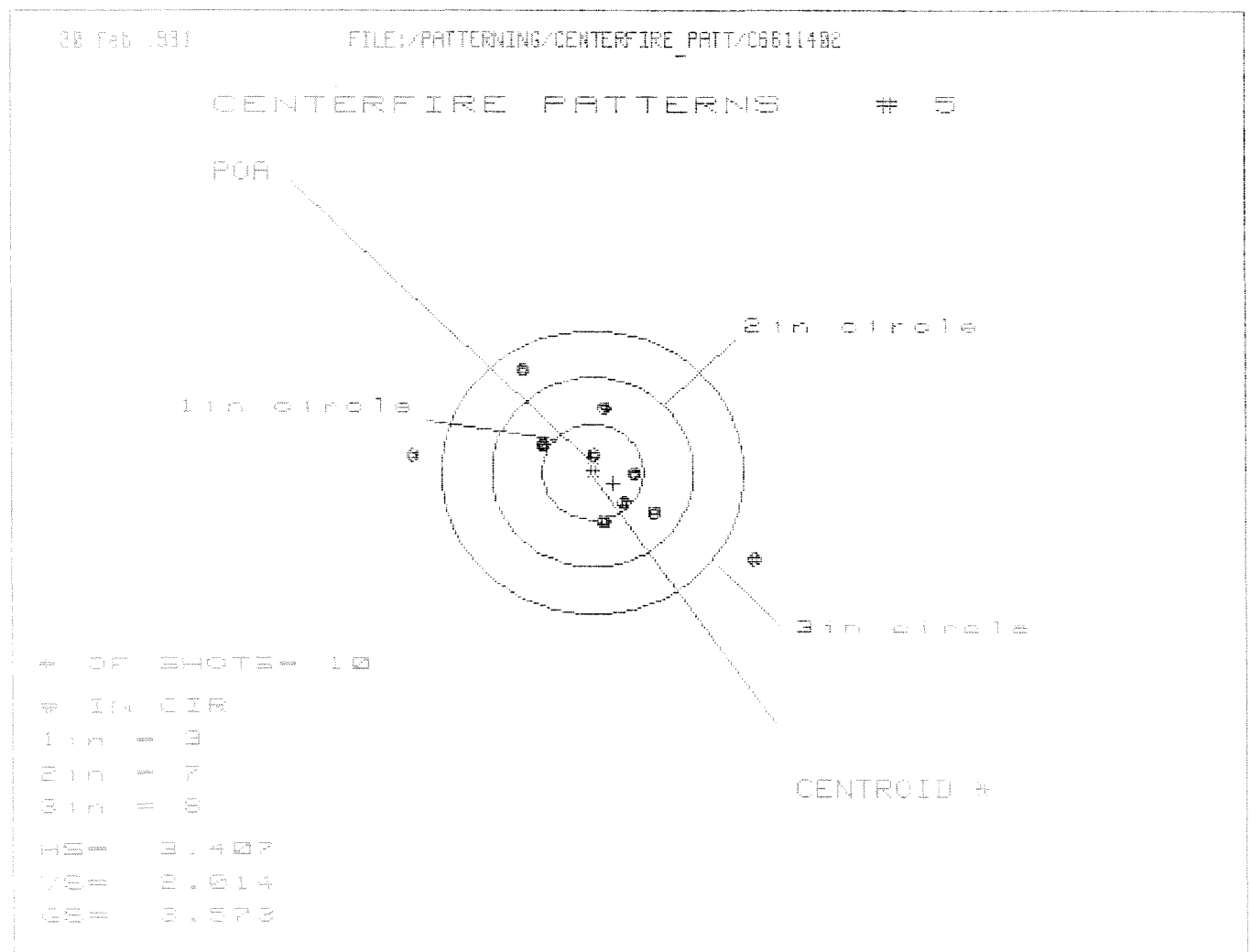
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.295	1.100	.865
MINIMUM X	:	-1.751	-.782	-.644
MAXIMUM Y	:	.923	.998	.865
MINIMUM Y	:	-1.140	-1.065	-.871
CENTROID X	:	-.117	.078	-.060
CENTROID Y	:	-.043	-.118	.015
POB TO CENTROID in.	:	.124	.141	.062
MIN RADIUS	:	.355	.368	.308
MEAN RADIUS	:	.933	.814	.712
MAX RADIUS	:	1.878	1.531	1.078
HORIZONTAL SPREAD	:	3.046	1.882	1.449

SPREAD : 2.883 2.883 1.738
 SPREAD : 3.547 2.792 1.856
BARBER - M24 0076247
 1 INCH CIRCLE = 2
 RINGS IN TWO INCH CIRCLE = 7
 RINGS IN THREE INCH CIRCLE = 8



PATTERN #		10	9	8
SHOTS (BEST DF)		10	9	8
MAXIMUM X		.792	.818	.807
MINIMUM X		-.766	-.741	-.751
MAXIMUM Y		1.140	1.185	.737
MINIMUM Y		-.921	-.795	-.646
CENTROID X		.029	.004	.014
CENTROID Y		-.052	-.178	-.327
POA TO CENTROID in.		.060	.178	.327
MIN RADIUS		.070	.080	.227

VELOCITY	:	1.162	1.188	1.052
BARBER - M240076248	:	1.559	1.559	1.559
MINIMUM SPREAD	:	2.061	1.980	1.383
EXTREME SPREAD	:	2.180	2.015	1.626
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:			
SHOT (BEST OF)	:	10	9	8
MAXIMUM	:	1.581	.739	.533
MINIMUM	:	-1.826	-1.651	-.718
MAXIMUM	:	1.075	.971	.975
MINIMUM	:	-.939	-.647	-.643
CENTROID	:	-.206	-.381	-.175
CENTROID	:	1.12	2.02	2.12

FOR TO CENTROID IN:	.237	.442	.280
MIN. RADIUS :	.160	.194	.063
MEAN RADIUS :	.848	.756	.592
MAX. RADIUS :	1.838	1.651	1.211
HORIZONTAL SPREAD :	3.407	2.390	1.251
VERTICAL SPREAD :	2.014	1.618	1.618
EXTREME SPREAD :	3.573	2.462	1.975
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	