

C6636192

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington




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

MODEL 700™ M24

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

20

SERIAL NO.
C6636192

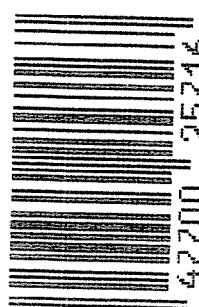
ORDER NO.
5716

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



5716 C6636192

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636192

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	LI
615	Rollmark Caliber		4/10/91	LS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/17/91	KS
	C) Inspect Ejector Hole for Chamfer		5/17/91	KS
	D) Oil Firing Pin Ass'y		5/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-18-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-18-91	K
	G) Safety Off Force	3	4	3			5-18-91	K
	H) Trigger Pull Test & Retainability						5-18-91	DH
	I) Firing Pin Indent	.021	.021	.020			5-18-91	AC
	J) Assemble Stock						5/18/91	KS
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/18/91	KS
	M) Iron Sight Alignment						5/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/18/91	KS
	O) Attach Scope to Rifle						5/18/91	KS
	P) Detach & Attach Scope 20 Times						5/18/91	KS
640	Gallery Target & Test						5/20/91	KF
	A) Time							KF
	B) Malfunctions							KF
	C) Pierced Primers							KF
	D) Optical Clarity of Scope							KF
645	Inspect for Live Ammo						5/20/91	KF
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	269	270	256	260	255	5/21/91	QU
	C) Function						5-21-91	DH
660	Pack						6-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6636192

DATE 5-18-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.71	2.63	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.75	2.54	2.70	
PULL #3	2.63	2.60	2.40	2.56	
PULL #4	2.58	2.72	2.47	2.60	
PULL #5	2.38	2.74	2.50	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.48		
PULL #2	3.45	3.44		
PULL #3	3.38	3.46		
PULL #4	3.47	3.01		
PULL #5	3.47	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	4.51	4.47		4.71
PULL #2	4.39	4.09		4.69
PULL #3	3.95	4.56		4.57
PULL #4	4.51	4.51		4.72
PULL #5	4.44	4.55		4.74
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636192
20 May 1981

CENTROIDAL DISTANCES

0 TO	1	.0288444
1 TO	2	.110114
1 TO	3	.256757
1 TO	4	.22419
1 TO	5	.395683

3.5 <----POA

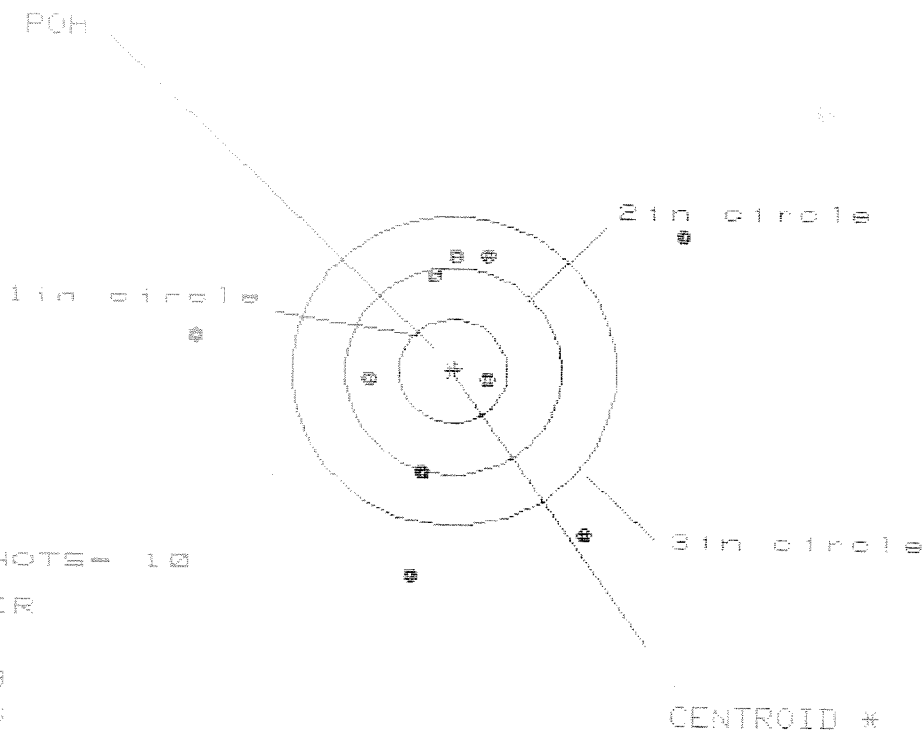
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.013
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0944
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0952909
THE AMR FOR THIS RIFLE IS: 1.081

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36192

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 4.486

VS= 3.348

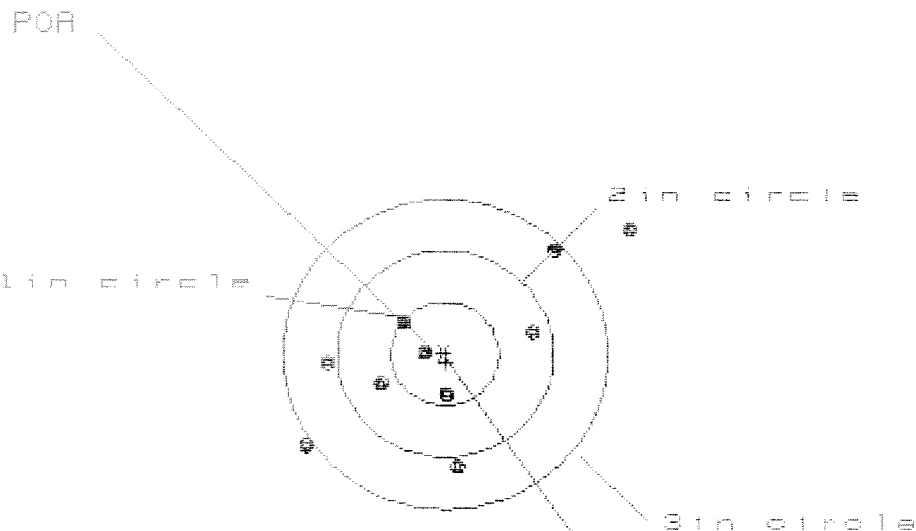
GS= 4.598

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.186	1.496	1.222
MINIMUM X	:	-2.380	-2.146	-.850
MAXIMUM Y	:	1.339	1.244	1.303
MINIMUM Y	:	-2.009	-1.860	-1.801
CENTROID X	:	-.816	-.250	.018
CENTROID Y	:	-.024	-.173	-.232
POA TO CENTROID in.	:	.029	.304	.233
MIN RADIUS	:	.284	.523	.292
MEAN RADIUS	:	1.429	1.313	1.186
MAX RADIUS	:	2.496	2.198	1.869
HORIZONTAL SPREAD	:	4.486	3.636	2.072
VERTICAL SPREAD	:	3.348	3.104	3.104
EXTREME SPREAD	:	4.598	4.126	3.166
NUMBER IN ONE INCH CIRCLE	=	1	3	6
NUMBER IN TWO INCH CIRCLE	=	3	6	9
NUMBER IN THREE INCH CIRCLE	=	6	9	10

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.020

VS= 2.306

GS= 3.669

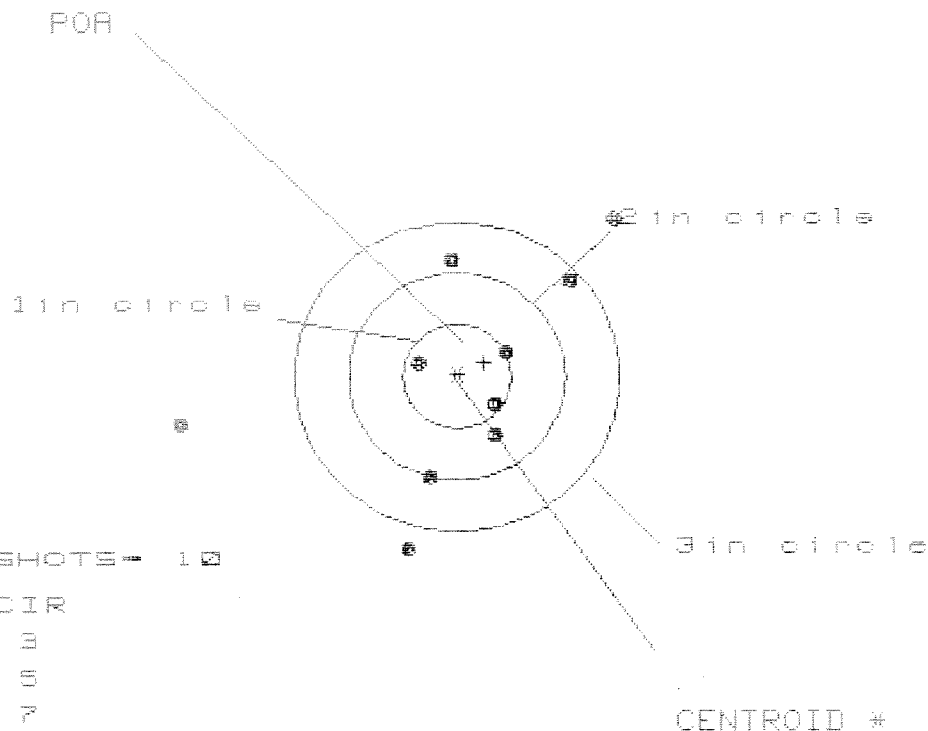
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.697	1.195	1.054
MINIMUM X	:	-1.323	-1.135	-1.051
MAXIMUM Y	:	1.174	1.166	1.069
MINIMUM Y	:	-1.132	-1.001	-1.098
CENTROID X	:	-.011	-.199	-.058
CENTROID Y	:	.086	-.045	.052
POA TO CENTROID in.	:	.086	.204	.078
MIN RADIUS	:	.214	.189	.183
MEAN RADIUS	:	.987	.823	.763
MAX RADIUS	:	2.064	1.670	1.501
HORIZONTAL SPREAD	:	3.020	2.330	2.105
VERTICAL SPREAD	:	2.306	2.167	2.167
EXTREME SPREAD	:	3.669	3.034	2.408
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.951

VS = 3.200

CS = 4.409

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.420	1.139	.952
MINIMUM X	:	-2.531	-.769	-.627
MAXIMUM Y	:	1.510	1.460	1.282
MINIMUM Y	:	-1.690	-1.740	-1.557
CENTROID X	:	-.248	.033	-.109
CENTROID Y	:	-.134	-.084	-.267
POA TO CENTROID in.	:	.282	.090	.288
MIN RADIUS	:	.341	.223	.302
MEAN RADIUS	:	1.197	1.011	.889
MAX RADIUS	:	2.570	1.902	1.679
HORIZONTAL SPREAD	:	3.951	1.908	1.579
VERTICAL SPREAD	:	3.200	3.200	2.839
EXTREME SPREAD	:	4.409	3.726	3.093
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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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 = 2

2 in = 6

3 in = 9

HS = 2.295

VS = 3.268

GS = 3.329

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.872	.876	.968
MINIMUM X	:	-1.423	-1.419	-1.310
MAXIMUM Y	:	2.457	1.486	.522
MINIMUM Y	:	-.811	-.538	-.352
CENTROID X	:	-.135	-.139	-.248
CENTROID Y	:	-.214	-.487	-.672
POA TO CENTROID in.	:	.253	.506	.717
MIN RADIUS	:	.369	.395	.288
MEAN RADIUS	:	1.035	.804	.653
MAX RADIUS	:	2.457	1.725	1.311
HORIZONTAL SPREAD	:	2.295	2.295	2.278
VERTICAL SPREAD	:	3.268	2.024	.875
EXTREME SPREAD	:	3.329	2.809	2.307
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.271

VS= 1.770

GS= 2.653

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.387	.598	.525
MINIMUM X	:	-.884	-.730	-.803
MAXIMUM Y	:	.882	.783	.671
MINIMUM Y	:	-.888	-.897	-.655
CENTROID X	:	.345	.191	.264
CENTROID Y	:	-.186	-.087	.025
POA TO CENTROID in.	:	.392	.210	.265
MIN RADIUS	:	.208	.327	.271
MEAN RADIUS	:	.758	.664	.591
MAX RADIUS	:	1.647	1.071	1.003
HORIZONTAL SPREAD	:	2.271	1.328	1.328
VERTICAL SPREAD	:	1.770	1.680	1.326
EXTREME SPREAD	:	2.653	1.755	1.597
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	