

C6498867

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498867

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/22/90	G.S.
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6/4/90	TH
	Apply Coating (Bolt)		6/4/90	TH
625	Final Assembly A) Clean inside of Bolt Assembly		6/10/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	94

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/25/90	RL
	G) Safety Off Force	3	3	3			7/25/90	RL
	H) Trigger Pull Test & Retainability						8/23/90	RL
	I) Firing Pin Indent	.0225	.0225	.0225			7/25/90	RL
	J) Assemble Stock						8/1/90	RW
	K) Assemble Swivel Studs						8/1/90	RL
	L) Attach Front and Rear Sight Assemblies						8/1/90	RW
	M) Iron Sight Alignment						8/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/90	RW
	O) Attach Scope to Rifle						8/1/90	RW
	P) Detach & Attach Scope 20 Times						8/1/90	RW
640	Gallery Target & Test						8-6-90	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						8-6-90	KT
645	Inspect for Live Ammo						29 Aug 90	RL
655	Final Inspection							
	A) Headspace						29 Aug 90	RL
	B) Trigger Pull	2.07	2.33	2.21	2.22	2.16	8/23/90	RL
	C) Function							
660	Pack						9/20/90	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06498867

DATE 8/23/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.20	2.27	2.07	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.15	2.22	2.33	
PULL #3	2.22	2.21	2.22	2.21	
PULL #4	2.28	2.18	2.22	2.22	
PULL #5	2.24	2.28	2.23	2.16	
TOTAL	11.37	11.05	11.16	10.99	
AVG.	2.274	2.21	2.232	2.198	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.27		
PULL #2	3.33	3.30		
PULL #3	3.30	3.32		
PULL #4	3.24	3.36		
PULL #5	3.24	3.23		
TOTAL	16.42	16.48		
AVG.	3.284	3.296		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.32		4.31
PULL #2	4.19	4.28		4.32
PULL #3	4.17	4.34		4.34
PULL #4	4.18	4.30		4.26
PULL #5	4.07	4.01		4.25
TOTAL	20.90	21.25		21.48
AVG.	4.18	4.25		4.296

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498867
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.520899
1 TO	2	.35
1 TO	3	.833382
1 TO	4	1.20659
1 TO	5	.502086

4
3
2+5 <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1236
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0152
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124531
THE AMR FOR THIS RIFLE IS: .8976

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/0649B867

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 0.401

VS= 2.785

GS= 3.304

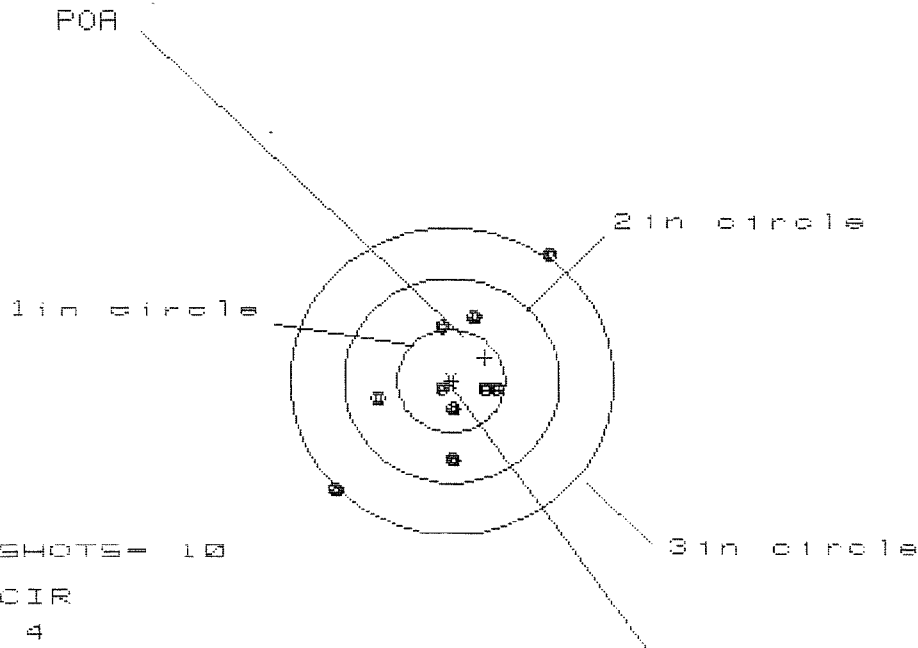
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.201	1.065	1.135
MINIMUM X	:	-1.220	-.975	-.985
MAXIMUM Y	:	1.007	.844	.601
MINIMUM Y	:	-1.778	-1.941	-1.268
CENTROID X	:	-.106	.030	-.040
CENTROID Y	:	-.510	-.347	-.104
POA TO CENTROID in.	:	.521	.348	.111
MIN RADIUS	:	.842	.780	.636
MEAN RADIUS	:	1.216	1.113	.951
MAX RADIUS	:	1.910	2.020	1.277
HORIZONTAL SPREAD	:	2.421	2.040	2.040
VERTICAL SPREAD	:	2.785	2.785	1.869
EXTREME SPREAD	:	3.304	3.008	2.208
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498867

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 8

HS= 2.004

VS= 2.326

GS= 3.070

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.914	.500	.377
MINIMUM X	:	-1.090	-.988	-.678
MAXIMUM Y	:	1.263	.815	.700
MINIMUM Y	:	-1.063	-.922	-.748
CENTROID X	:	-.316	-.417	-.294
CENTROID Y	:	-.230	-.371	-.256
POA TO CENTROID in.	:	.391	.558	.389
MIN RADIUS	:	.061	.116	.070
MEAN RADIUS	:	.695	.600	.480
MAX RADIUS	:	1.560	1.351	.749
HORIZONTAL SPREAD	:	2.004	1.498	1.055
VERTICAL SPREAD	:	2.326	1.737	1.448
EXTREME SPREAD	:	3.070	2.199	1.464
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498867

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.163

VS= 1.654

GS= 2.383

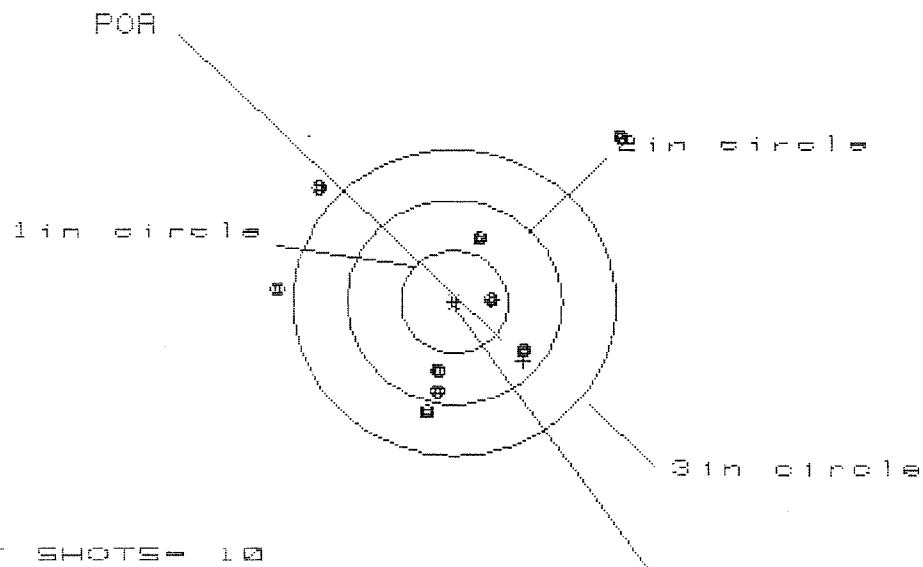
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.134	1.040	1.006
MINIMUM X	:	-1.029	-1.123	-.993
MAXIMUM Y	:	.707	.601	.635
MINIMUM Y	:	-.947	-.477	-.443
CENTROID X	:	.171	.265	.135
CENTROID Y	:	.276	.382	.348
POA TO CENTROID in.	:	.325	.465	.373
MIN RADIUS	:	.124	.101	.124
MEAN RADIUS	:	.734	.679	.613
MAX RADIUS	:	1.273	1.136	1.049
HORIZONTAL SPREAD	:	2.163	2.163	1.999
VERTICAL SPREAD	:	1.654	1.078	1.078
EXTREME SPREAD	:	2.383	2.165	2.001
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498867

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 3.233

VS= 2.676

GS= 3.563

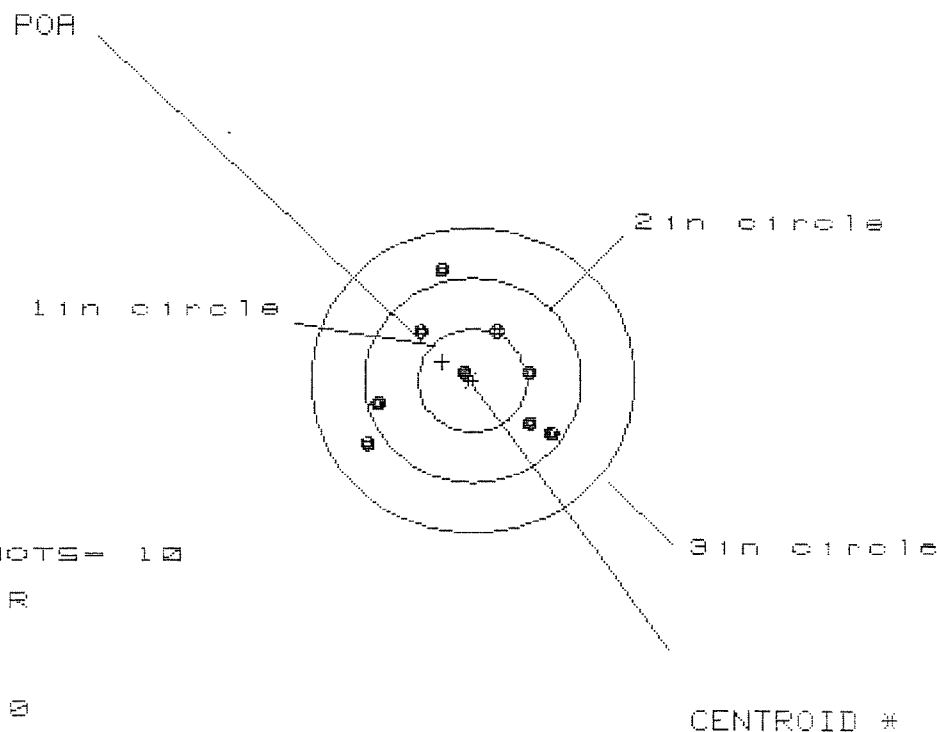
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.582	.857	.722
MINIMUM X	:	-1.651	-1.476	-1.611
MAXIMUM Y	:	1.655	1.313	.973
MINIMUM Y	:	-1.021	-.837	-.673
CENTROID X	:	-.642	-.817	-.682
CENTROID Y	:	.571	.387	.223
POA TO CENTROID in.	:	.859	.904	.718
MIN RADIUS	:	.323	.499	.359
MEAN RADIUS	:	1.091	.939	.777
MAX RADIUS	:	2.289	1.701	1.688
HORIZONTAL SPREAD	:	3.233	2.333	2.333
VERTICAL SPREAD	:	2.676	2.150	1.646
EXTREME SPREAD	:	3.563	2.544	2.429
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498867

CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.678	.550
MINIMUM X	:	-.993	-1.029	-1.002
MAXIMUM Y	:	1.126	.612	.553
MINIMUM Y	:	-.592	-.467	-.499
CENTROID X	:	.275	.311	.439
CENTROID Y	:	-.183	-.308	-.249
POA TO CENTROID in.	:	.331	.437	.505
MIN RADIUS	:	.125	.240	.300
MEAN RADIUS	:	.752	.709	.633
MAX RADIUS	:	1.169	1.130	1.010
HORIZONTAL SPREAD	:	1.707	1.707	1.552
VERTICAL SPREAD	:	1.718	1.079	1.052
EXTREME SPREAD	:	1.980	1.714	1.597
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6498867

ORDER NO.
5716

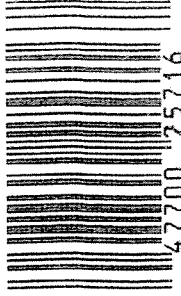
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6498867

LPC



0 47700 25716 7