

C6594526

MODEL 700TM M24

Model SMS TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

DUPONT

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

MODEL 700™ M24

SERIAL NO.
C6594526

ORDER NO.
5716

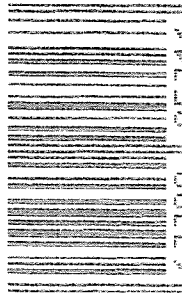
MADE IN ILION, N.Y. USA, Reg. U.S. Pat. & Tm. Off., Marca Registrada. Marque Deposee.

20



5716 C6594526

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594526

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	YG
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-18-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/23/91	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			1/28/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			1/28/91	WB
	H) Trigger Pull Test & Retainability						1/28/91	921
	I) Firing Pin Indent	.021	.021	.021			1/28/91	WB
	J) Assemble Stock						1/28/91	RW
	K) Assemble Swivel Studs						2-4-91	A
	L) Attach Front and Rear Sight Assemblies						1/28/91	RW
	M) Iron Sight Alignment						1/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/28/91	RW
	O) Attach Scope to Rifle						1/28/91	RW
	P) Detach & Attach Scope 20 Times						1/28/91	RW
640	Gallery Target & Test						1/28/91	LS
	A) Time							123
	B) Malfunctions							108
	C) Pierced Primers							184
	D) Optical Clarity of Scope							125
645	Inspect for Live Ammo						1/28/91	127
655	Final Inspection							
	A) Headspace						2-4-91	A
	B) Trigger Pull	2.17	2.37	2.34	2.30	2.49	2-1-91	921
	C) Function						2-4-91	AC
660	Pack						3-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594526

DATE 1-28-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.57	2.41	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.52	2.15	2.37	
PULL #3	2.48	2.39	2.54	2.34	
PULL #4	2.45	2.39	2.40	2.30	
PULL #5	2.59	2.39	2.50	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.35		
PULL #2	3.36	3.30		
PULL #3	3.48	3.47		
PULL #4	3.49	3.26		
PULL #5	3.50	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.45		4.44
PULL #2	4.30	4.47		4.50
PULL #3	4.28	4.40		4.20
PULL #4	4.39	4.50		4.36
PULL #5	4.41	4.36		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594526
29 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.15003
1 TO	2	.16059
1 TO	3	.366292
1 TO	4	.520289
1 TO	5	.282708

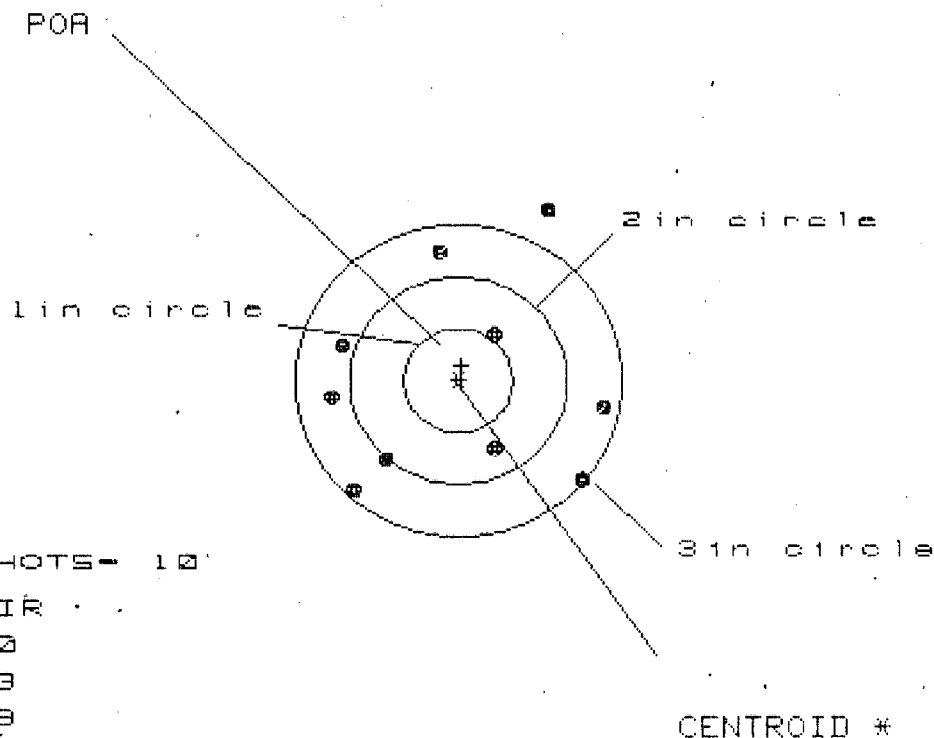
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .036
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .107
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .112894
THE AMR FOR THIS RIFLE IS: 1.081

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ 06594526

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 2.453

VS= 2.721

GS= 3.276

PATTERN #

#1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.314	1.407	1.561
MINIMUM X	-1.139	-1.046	-0.892
MAXIMUM Y	1.654	1.456	1.357
MINIMUM Y	-1.067	-0.883	-0.982
CENTROID X	-0.030	-0.123	-0.277
CENTROID Y	-0.147	-0.331	-0.232
POA TO CENTROID in.	.150	.353	.362
MIN RADIUS	.600	.615	.787
MEAN RADIUS	1.198	1.104	1.046
MAX RADIUS	1.854	1.464	1.566
HORIZONTAL SPREAD	2.453	2.453	2.453
VERTICAL SPREAD	2.721	2.339	2.339
EXTREME SPREAD	3.276	2.620	2.464
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C8594526

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 2

3 in = 8

HS= 2.929

VS= 2.820

GS= 3.061

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	1.278	1.072
MINIMUM X	:	-1.716	-1.651	-1.259
MAXIMUM Y	:	1.734	1.392	1.407
MINIMUM Y	:	-1.086	-0.893	-0.878
CENTROID X	:	.045	-.020	.186
CENTROID Y	:	-.005	-.198	-.213
POA TO CENTROID in.	:	.045	.199	.283
MIN RADIUS	:	.221	.350	.231
MEAN RADIUS	:	1.196	1.104	1.002
MAX RADIUS	:	1.830	1.655	1.514
HORIZONTAL SPREAD	:	2.929	2.929	2.331
VERTICAL SPREAD	:	2.820	2.285	2.285
EXTREME SPREAD	:	3.061	2.949	2.639
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Jan 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.342

VS = 2.616

GS = 3.343

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

-1.101

1.190

1.050

MINIMUM X

-1.241

-1.119

-.998

MAXIMUM Y

1.870

.229

.222

MINIMUM Y

-.746

-.538

-.545

CENTROID X

.019

-.103

.037

CENTROID Y

.216

.000

.015

POA TO CENTROID in.

.217

.103

.040

MIN RADIUS

.180

.093

.177

MEAN RADIUS

.892

.704

.656

MAX RADIUS

2.170

1.212

1.137

HORIZONTAL SPREAD

2.342

2.309

2.048

VERTICAL SPREAD

2.616

.767

.767

EXTREME SPREAD

3.343

2.327

2.187

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

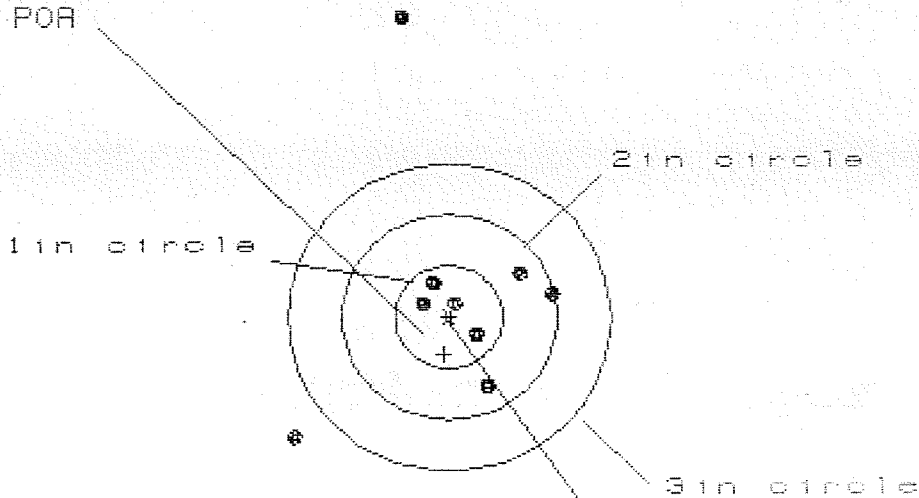
NUMBER IN THREE INCH CIRCLE =

9

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594526

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 6

3 in = 7

HS= 2.462

VS= 5.059

GS= 5.077

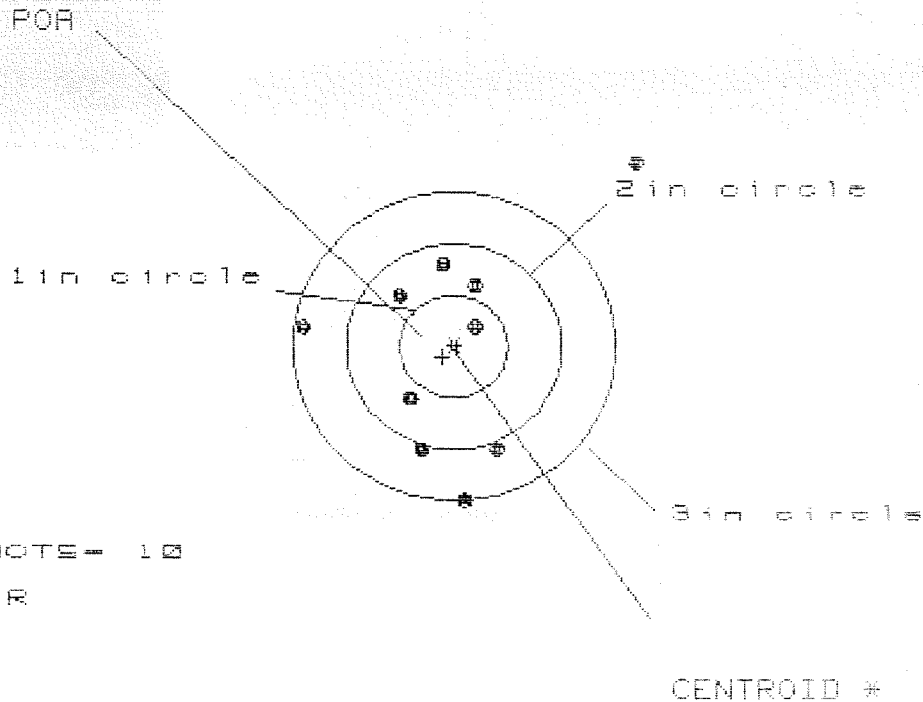
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.975	.924	.913
MINIMUM X	-1.487	-1.538	-1.549
MAXIMUM Y	2.938	.744	.520
MINIMUM Y	-2.120	-1.794	-1.071
CENTROID X	.044	.095	.106
CENTROID Y	.368	.041	.265
POA TO CENTROID in.	.370	.103	.286
MIN RADIUS	.099	.268	.204
MEAN RADIUS	1.069	.893	.709
MAX RADIUS	2.974	1.796	1.883
HORIZONTAL SPREAD	2.462	2.462	2.462
VERTICAL SPREAD	5.059	2.538	1.591
EXTREME SPREAD	5.077	2.859	2.859
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

29 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 3.067

VS = 3.214

GS = 3.597

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.696	.631	.665
MINIMUM X	-1.371	-1.183	-1.149
MAXIMUM Y	1.755	1.002	.844
MINIMUM Y	-1.459	-1.264	-.995
CENTROID X	.102	-.086	-.120
CENTROID Y	.103	-.092	.066
POA TO CENTROID in.	.145	.126	.137
MIN RADIUS	.247	.367	.453
MEAN RADIUS	1.048	.881	.813
MAX RADIUS	2.440	1.292	1.165
HORIZONTAL SPREAD	3.067	1.814	1.814
VERTICAL SPREAD	3.214	2.266	1.839
EXTREME SPREAD	3.597	2.276	2.140
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	