

Call
Remington

C6594599

MODEL 700TM M24

Model **SMS** TH

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™ H24		SERIAL NO. C6594599
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6594599

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594599

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action	1 18 91		KR
	Magnaflux Bolt	1 18 91		KR
615	Rollmark Caliber	1 18 91		28.
617	Drill and Tap Sight Holes	1 24 91		FSB
618	Polish Barrel	1 24 91		WB
620	Apply Coatings (Barrel Action)		1/15/91	TH
	Apply Coating (Bolt)		1/15/91	TH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/8/91	KR
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KA
	C) Inspect Ejector Hole for Chamfer		3/8/91	KA
	D) Oil Firing Pin Ass'y		3/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		4/1/91	KA

BARBER - M24 0020043								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	4/1/91	SH		
	G) Safety Off Force	3	2	3	4/1/91	SH		
	H) Trigger Pull Test & Retainability				4/1/91	SH		
	I) Firing Pin Indent	.0215	.0215	.0215	4/1/91	SH		
	J) Assemble Stock				4/2/91	KS		
	K) Assemble Swivel Studs				4-8-91	D/H		
	L) Attach Front and Rear Sight Assemblies				4/2/91	KS		
	M) Iron Sight Alignment				4/2/91	KS		
	N) Detach Front & Rear Sights & place in numbered container				4/2/91	KS		
	O) Attach Scope to Rifle				4/2/91	KS		
	P) Detach & Attach Scope 20 Times				4/2/91	KS		
640	Gallery Target & Test				4-3-91	DH		
	A) Time				4-3-91	DH		
	B) Malfunctions				4-3-91	DH		
	C) Pierced Primers				4-3-91	DH		
	D) Optical Clarity of Scope				4-3-91	DH		
645	Inspect for Live Ammo				4-3-91	DH		
655	Final Inspection				4-8-91	D/H		
	A) Headspace							
	B) Trigger Pull	2.23	2.18	2.20	2.20	2.21	4/5/91	SH
	C) Function						4-8-91	D/H
660	Pack						6-17-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6594599

DATE 4/1/91

TESTER 84

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.15	2.20	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.29	2.27	2.18	
PULL #3	2.32	2.28	2.30	2.20	
PULL #4	2.18	2.26	2.28	2.20	
PULL #5	2.34	2.27	2.30	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.35		
PULL #2	3.43	3.30		
PULL #3	3.41	3.29		
PULL #4	3.40	3.34		
PULL #5	3.41	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.30		4.29
PULL #2	4.48	4.28		4.25
PULL #3	4.18	4.28		4.28
PULL #4	4.33	4.30		4.24
PULL #5	4.31	4.28		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594599
3 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0735527
1 TO	2	.313949
1 TO	3	.182395
1 TO	4	.261123
1 TO	5	.523978

2#5 <----FOR

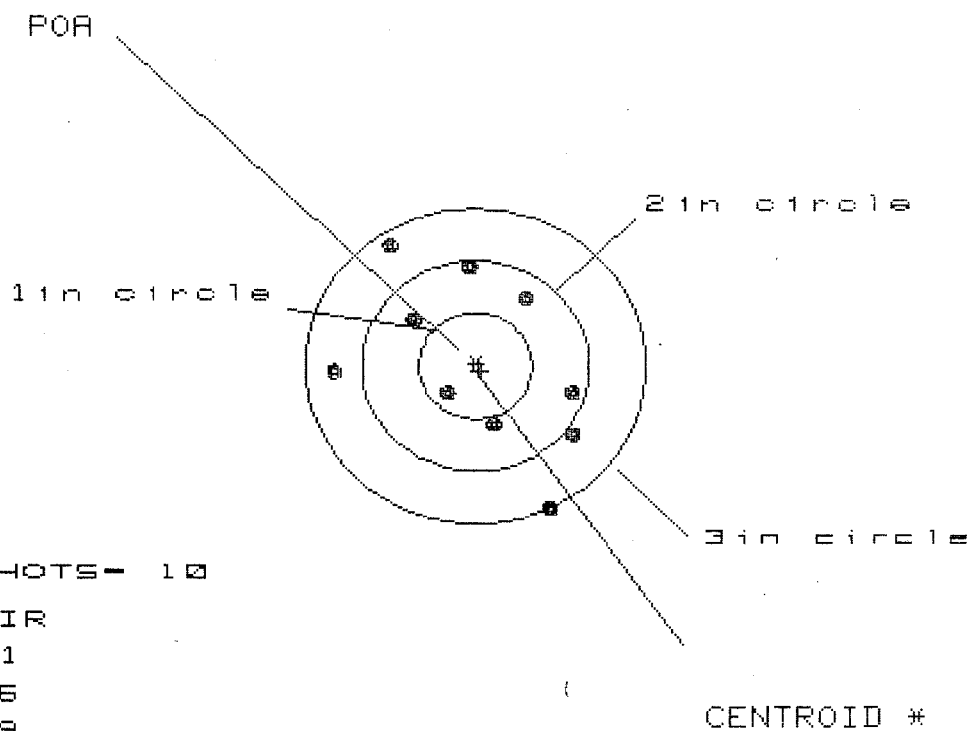
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0102
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102708

THE AMR FOR THIS RIFLE IS: .9266

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594599

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.127

VS = 2.506

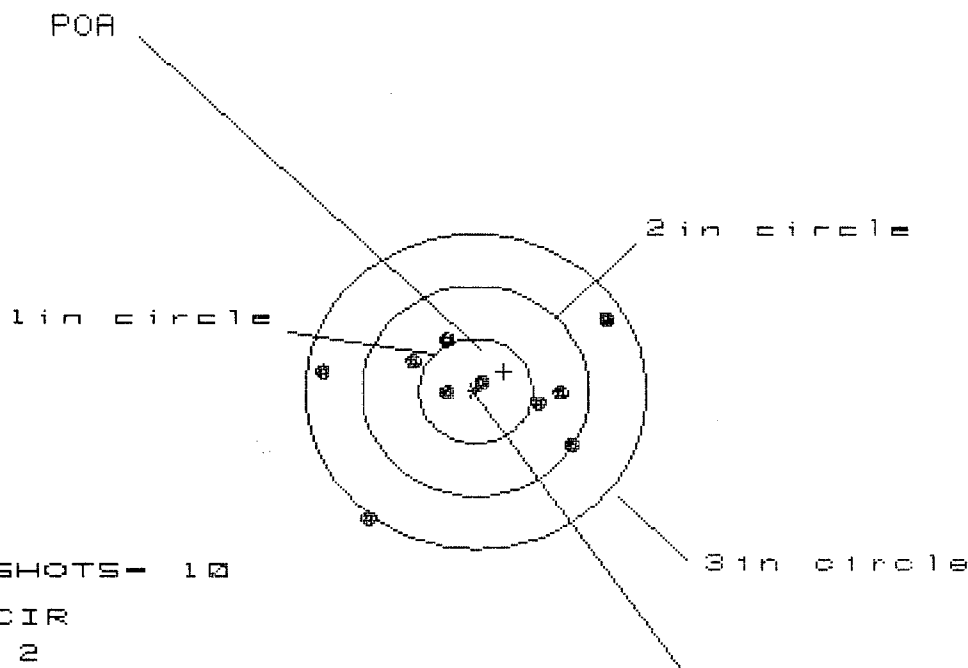
GS = 2.867

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.855	.922	.832
MINIMUM X	-1.272	-1.205	-1.295
MAXIMUM Y	1.131	.978	.929
MINIMUM Y	-1.375	-.835	-.713
CENTROID X	-.051	-.118	-.028
CENTROID Y	.053	.205	.083
POA TO CENTROID in.	.073	.237	.088
MIN RADIUS	.394	.483	.432
MEAN RADIUS	.962	.894	.843
MAX RADIUS	1.502	1.221	1.296
HORIZONTAL SPREAD	2.127	2.127	2.127
VERTICAL SPREAD	2.506	1.813	1.642
EXTREME SPREAD	2.867	2.426	2.199
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

3 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.430

VS= 1.906

GS= 2.835

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.107	.997	.818
MINIMUM X	-1.323	-1.433	-.807
MAXIMUM Y	.697	.563	.565
MINIMUM Y	-1.209	-.646	-.644
CENTROID X	-.251	-.141	.038
CENTROID Y	-.189	-.055	-.057
POA TO CENTROID in.	.314	.151	.069
MIN RADIUS	.076	.100	.261
MEAN RADIUS	.807	.712	.625
MAX RADIUS	1.564	1.433	.994
HORIZONTAL SPREAD	2.430	2.430	1.625
VERTICAL SPREAD	1.906	1.209	1.209
EXTREME SPREAD	2.835	2.491	1.669
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.943

VS = 1.513

GS = 3.006

CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.004	.969
MINIMUM X	:	-1.745	-.951	-.826
MAXIMUM Y	:	.798	.720	.656
MINIMUM Y	:	-.715	-.793	-.857
CENTROID X	:	.131	.325	.200
CENTROID Y	:	.041	.119	.183
POA TO CENTROID in.	:	.138	.346	.271
MIN RADIUS	:	.128	.244	.261
MEAN RADIUS	:	.857	.731	.671
MAX RADIUS	:	1.880	1.238	1.190
HORIZONTAL SPREAD	:	2.943	1.955	1.795
VERTICAL SPREAD	:	1.513	1.513	1.513
EXTREME SPREAD	:	3.006	2.134	2.134
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

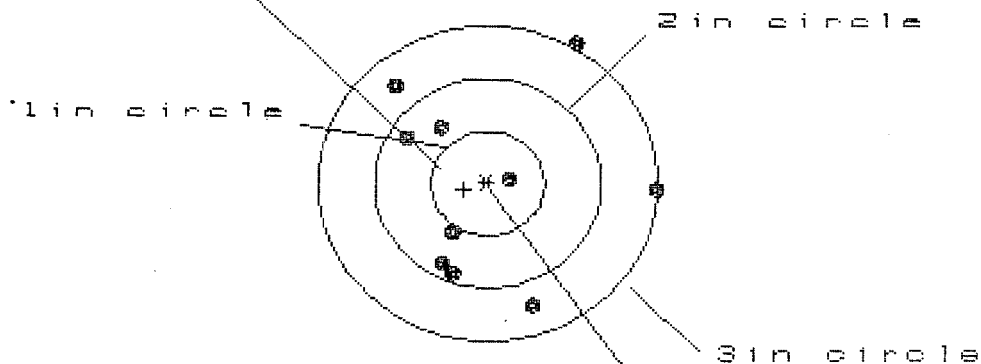
3 Apr 1991

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CENTERFIRE PATTERNS

4

POR



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.331

VS = 2.534

GS = 2.561

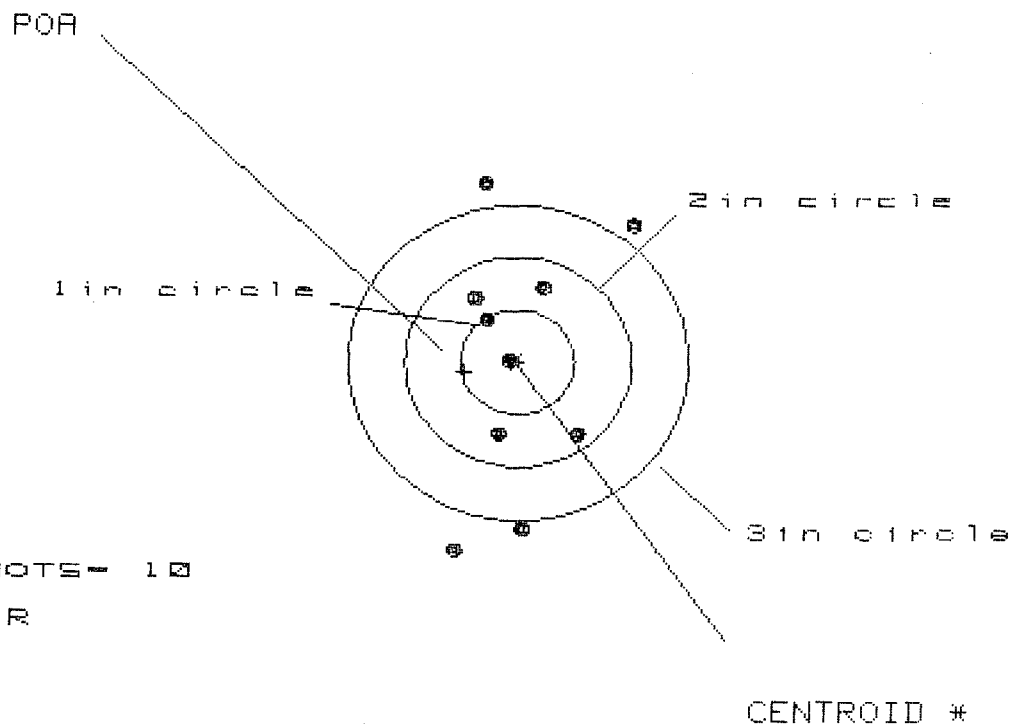
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.538	1.627	.724
MINIMUM X	:	-.793	-.704	-.500
MAXIMUM Y	:	1.376	1.138	1.151
MINIMUM Y	:	-1.158	-1.005	-.992
CENTROID X	:	.210	.121	-.083
CENTROID Y	:	.061	-.092	-.105
POR TO CENTROID in.	:	.219	.152	.133
MIN RADIUS	:	.197	.324	.276
MEAN RADIUS	:	.966	.869	.751
MAX RADIUS	:	1.593	1.630	1.255
HORIZONTAL SPREAD	:	2.331	2.331	1.224
VERTICAL SPREAD	:	2.534	2.143	2.143
EXTREME SPREAD	:	2.561	2.551	2.468
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 6

HS = 1.621

VS = 3.453

GS = 3.487

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.047	.983	.937
MINIMUM X	-.574	-.409	-.455
MAXIMUM Y	1.675	1.478	1.297
MINIMUM Y	-1.778	-1.821	-1.636
CENTROID X	.472	.536	.582
CENTROID Y	.085	.282	.097
POA TO CENTROID in.	.479	.605	.590
MIN RADIUS	.123	.254	.232
MEAN RADIUS	1.041	.934	.869
MAX RADIUS	1.868	1.823	1.641
HORIZONTAL SPREAD	1.621	1.392	1.392
VERTICAL SPREAD	3.453	3.299	2.933
EXTREME SPREAD	3.487	3.312	3.119
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	6		