

C6523463

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]


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

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

MODEL 700TM M24

SERIAL NO.
C6523463

ORDER NO.
5716

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

Q1


5716 C6523463

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523463

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 2	90	RW
610	Dis-assemble Gun	9 2	90	RW
612	Magnaflux Barrel Action		9/25/90	KR
	Magnaflux Bolt		9/26/90	KR
615	Rollmark Caliber		9/26/90	JS
617	Drill and Tap Sight Holes		9/26/90	FB
618	Polish Barrel <i>RB</i>		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/11/90	JP

op. #	BARBER - M24 0028550 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/11/90	WB
	G) Safety Off Force	7 1/2	2 1/2	2 1/2			10/11/90	WB
	H) Trigger Pull Test & Retainability						10/11/90	WB
	I) Firing Pin Indent	.023	.0235	.0235			10/11/90	WB
	J) Assemble Stock						10/11/90	RW
	K) Assemble Swivel Studs						11-26-90	WB
	L) Attach Front and Rear Sight Assemblies						10/11/90	RW
	M) Iron Sight Alignment						10/11/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/11/90	RW
	O) Attach Scope to Rifle						10/15/90	RW
	P) Detach & Attach Scope 20 Times						10/15/90	RW
640	Gallery Target & Test						10/16/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						10/16/90	AF
655	Final Inspection						11-20-90	WB
	A) Headspace						11-20-90	WB
	B) Trigger Pull	259	263	258	258	265	11-20-90	WB
	C) Function						11-20-90	WB
660	Pack						12/15/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523463DATE 10/11/90TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.26	2.35	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.32	2.26	2.63	
PULL #3	2.33	2.32	2.30	2.58	
PULL #4	2.11	2.28	2.29	2.58	
PULL #5	2.29	2.44	2.38	2.65	
TOTAL	11.59	11.62	11.58		
AVG.	2.318	2.324	2.316		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.45		
PULL #2	3.31	3.48		
PULL #3	3.32	3.17		
PULL #4	3.41	3.53		
PULL #5	3.45	3.51		
TOTAL	16.82	17.14		
AVG.	3.364	3.428		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.17		4.37
PULL #2	4.40	4.19		4.43
PULL #3	4.46	4.25		4.42
PULL #4	4.26	4.26		4.52
PULL #5	4.04	4.27		4.41
TOTAL	21.48	21.14		22.15
AVG.	4.296	4.228		4.43

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523463
17 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.22853
1 TO	2	.252676
1 TO	3	.161645
1 TO	4	.1936
1 TO	5	.50431

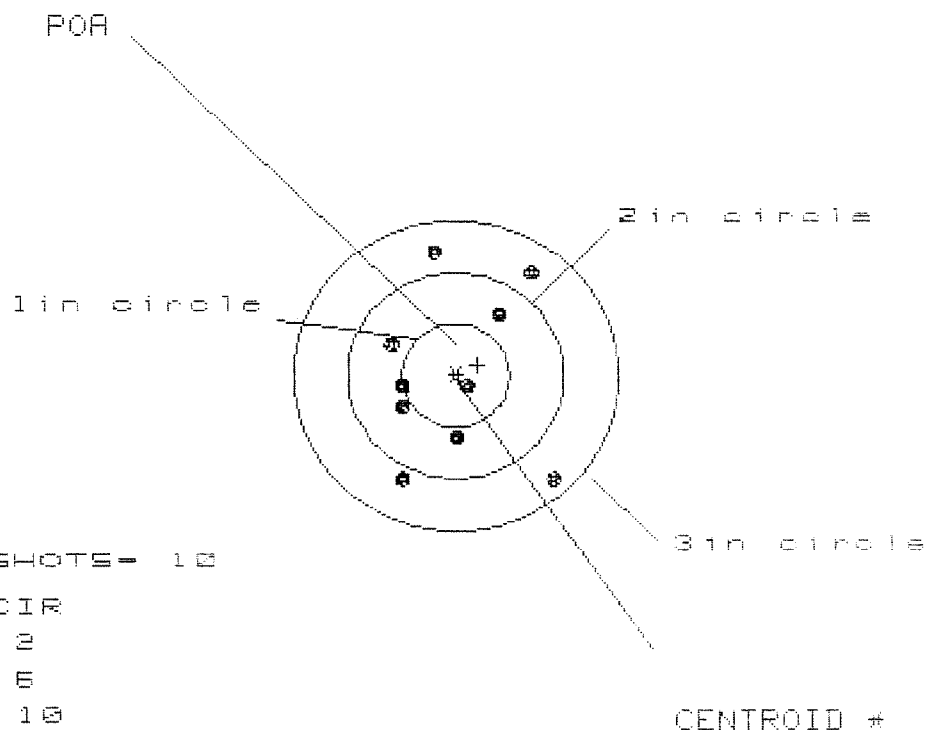
24⁵
at <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1648
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0412
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159872
THE AMR FOR THIS RIFLE IS: .7704

17 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523463

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 1.477

VS = 2.257

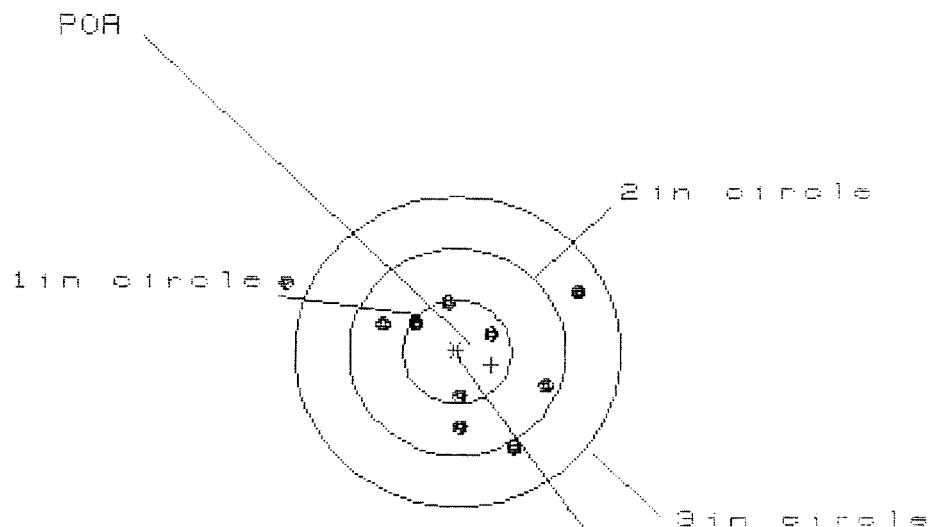
GS = 2.490

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.917	.833	.821
MINIMUM X	-.560	-.458	-.470
MAXIMUM Y	1.240	1.131	1.048
MINIMUM Y	-1.017	-1.126	-.985
CENTROID X	-.205	-.307	-.295
CENTROID Y	-.101	.008	-.133
POA TO CENTROID in.	.229	.307	.323
MIN RADIUS	.127	.277	.190
MEAN RADIUS	.808	.745	.670
MAX RADIUS	1.346	1.231	1.331
HORIZONTAL SPREAD	1.477	1.291	1.291
VERTICAL SPREAD	2.257	2.257	2.033
EXTREME SPREAD	2.490	2.351	2.351
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

17 Oct 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.700

VS = 1.542

GS = 2.700

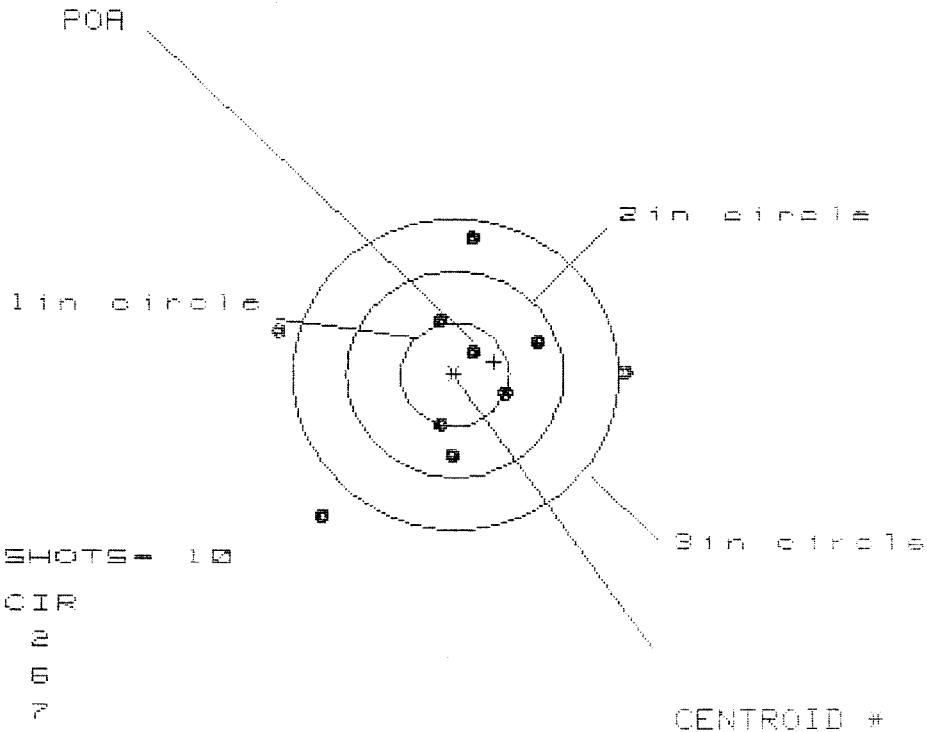
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.106
MINIMUM X	-1.602
MAXIMUM Y	.635
MINIMUM Y	-.907
CENTROID X	-.318
CENTROID Y	.125
POR TO CENTROID in.	.341
MIN RADIUS	.347
MEAN RADIUS	.806
MAX RADIUS	1.724
HORIZONTAL SPREAD	2.708
VERTICAL SPREAD	1.542
EXTREME SPREAD	2.709
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.139

VS= 2.685

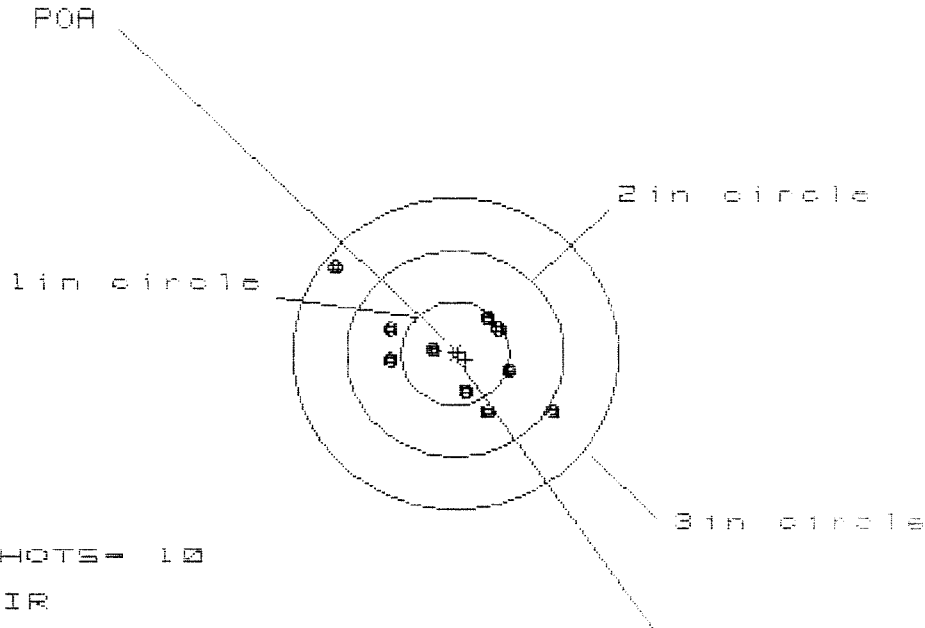
GS= 3.163

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.554	1.420	1.205
MINIMUM X	:	-1.585	-1.719	-1.507
MAXIMUM Y	:	1.324	1.172	1.204
MINIMUM Y	:	-1.361	-1.902	-1.870
CENTROID X	:	-.365	-.231	-.016
CENTROID Y	:	-.124	.028	-.004
POA TO CENTROID in.	:	.385	.233	.017
MIN RADIUS	:	.290	.091	.214
MEAN RADIUS	:	.972	.844	.724
MAX RADIUS	:	1.816	1.737	1.213
HORIZONTAL SPREAD	:	3.139	3.139	1.712
VERTICAL SPREAD	:	2.685	2.074	2.074
EXTREME SPREAD	:	3.163	3.163	2.087
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

H0 = 2.041

V0 = 1.373

G0 = 2.460

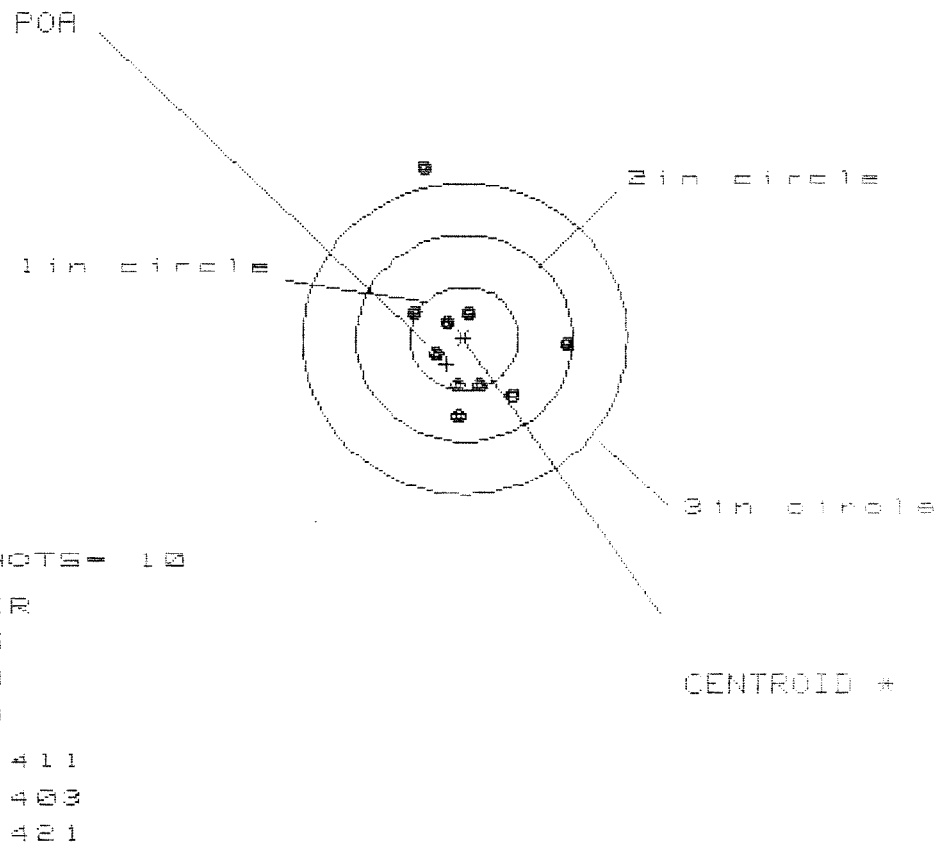
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	.802	.473
MINIMUM X	:	-1.115	-.722	-.622
MAXIMUM Y	:	.839	.426	.370
MINIMUM Y	:	-.534	-.441	-.489
CENTROID X	:	-.096	.028	-.072
CENTROID Y	:	.059	-.035	.021
POA TO CENTROID in.	:	.112	.045	.075
MIN RADIUS	:	.250	.273	.280
MEAN RADIUS	:	.634	.532	.482
MAX RADIUS	:	1.395	.915	.659
HORIZONTAL SPREAD	:	2.041	1.524	1.095
VERTICAL SPREAD	:	1.373	.867	.860
EXTREME SPREAD	:	2.460	1.688	1.153
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.913
MINIMUM X	-.499
MAXIMUM Y	1.681
MINIMUM Y	-.722
CENTROID X	.160
CENTROID Y	.247
POA TO CENTROID in.	.294
MIN RADIUS	.267
MEAN RADIUS	.632
MAX RADIUS	1.712
HORIZONTAL SPREAD	1.411
VERTICAL SPREAD	2.403
EXTREME SPREAD	2.421
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	9