

05648968

MODEL 700TH M24

Model SMSTH

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.



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

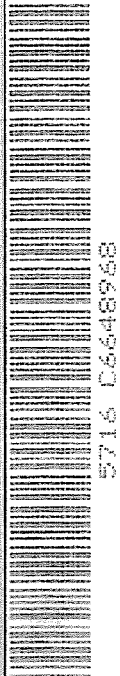
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

MODEL 700TM M24

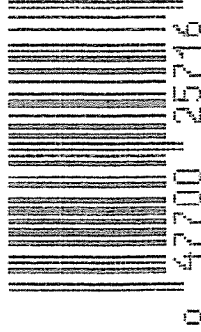
SERIAL NO.
 C6648968

ORDER NO.
 5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GFMGUN SERIAL # *C6648968*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	<i>7 2 9 1</i>		<i>RW</i>
600	Proof	<i>7 2 9 1</i>		<i>RW</i>
607	Check Headspace	<i>7 2 9 1</i>		<i>RW</i>
610	Dis-assemble Gun			<i>RW</i>
612	Magnaflux Barrel Action		<i>JUL 22 1991</i>	<i>GS</i>
	Magnaflux Bolt		<i>JUL 22 1991</i>	<i>GS</i>
615	Rollmark Caliber		<i>JUL 22 1991</i>	<i>GS</i>
617	Drill and Tap Sight Holes		<i>JUL 22 1991</i>	<i>FB</i>
618	Polish Barrel		<i>7/22/91</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>8-28-91</i>	<i>AD</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		<i>8/29/91</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>8/29/91</i>	<i>Red</i>
	C) Inspect Ejector Hole for Chamfer		<i>8/29/91</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>8/29/91</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>7-7-91</i>	<i>DH</i>

op. #	BARBER - M24 0030105	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9-7-91	DH
	G) Safety Off Force	3 1/2	3 1/2	4			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.022	.022	.023			9-7-91	DH
	J) Assemble Stock						9/7/91	RW
	K) Assemble Swivel Studs						9-9-91	AC
	L) Attach Front and Rear Sight Assemblies						9/7/91	RW
	M) Iron Sight Alignment						9/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/7/91	RW
	O) Attach Scope to Rifle						9/7/91	RW
	P) Detach & Attach Scope 20 Times						9/7/91	RW
640	Gallery Target & Test						9-9-91	AC
	A) Time						9-9-91	AC
	B) Malfunctions						9-9-91	AC
	C) Pierced Primers						9-9-91	AC
	D) Optical Clarity of Scope						9-9-91	AC
645	Inspect for Live Ammo						9-9-91	AC
655	Final Inspection							
	A) Headspace						9-9-91	AC
	B) Trigger Pull	2.56	2.53	2.54	2.52	2.53	9-9-91	DH
	C) Function						9-9-91	AC
660	Pack						9/7/91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648968

DATE 9-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.29	2.61	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.41	2.50	2.53	
PULL #3	2.48	2.32	2.30	2.54	
PULL #4	2.51	2.37	2.60	2.52	
PULL #5	2.51	2.41	2.55	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.23		
PULL #2	3.20	3.06		
PULL #3	3.10	3.22		
PULL #4	3.23	3.30		
PULL #5	3.21	3.10		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.34		4.19
PULL #2	4.36	4.40		4.00
PULL #3	4.35	4.30		4.12
PULL #4	4.32	4.33		4.11
PULL #5	4.00	4.01		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649968
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.520312
1 TO	2	.370385
1 TO	3	.24016
1 TO	4	.453816
1 TO	5	1.21116

4
4
5 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .116
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1538
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .192641
THE AMR FOR THIS RIFLE IS: .9286

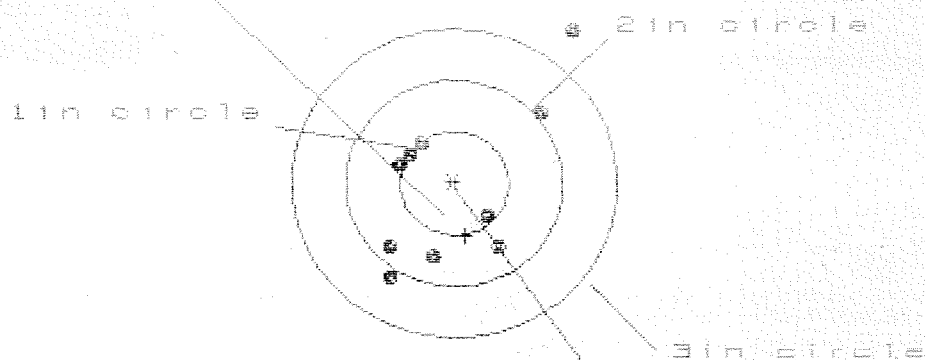
9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646966

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.644

VS= 2.372

GS= 2.886

CENTROID #

PATTERN

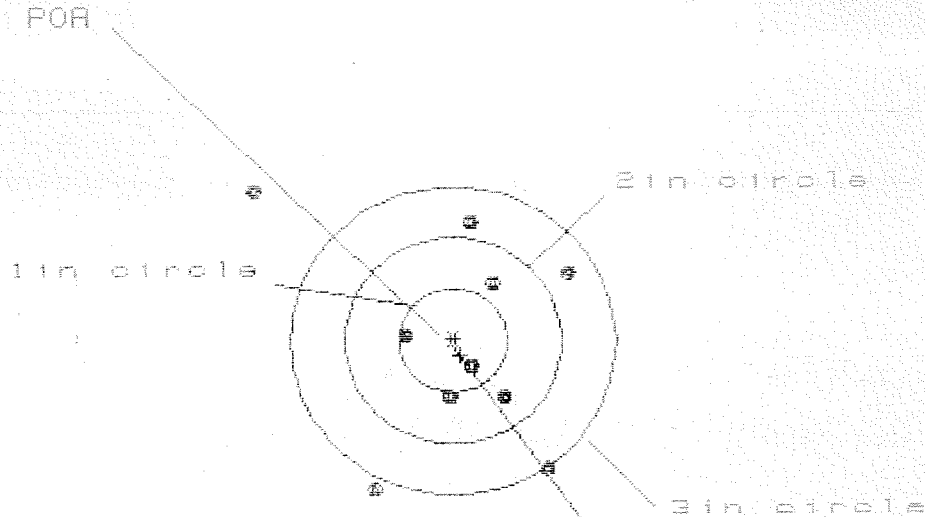
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.071	.922	.672
MINIMUM X	-.573	-.454	-.339
MAXIMUM Y	1.476	.878	.696
MINIMUM Y	-.896	-.732	-.622
CENTROID X	-.098	-.217	-.332
CENTROID Y	.511	.347	.237
POA TO CENTROID in.	.520	.409	.408
MIN RADIUS	.453	.439	.418
MEAN RADIUS	.829	.683	.599
MAX RADIUS	1.824	1.273	.747
HORIZONTAL SPREAD	1.644	1.376	1.011
VERTICAL SPREAD	2.372	1.610	1.318
EXTREME SPREAD	2.886	2.118	1.354
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

9 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.888

VS= 2.815

GS= 3.732

CENTROID *

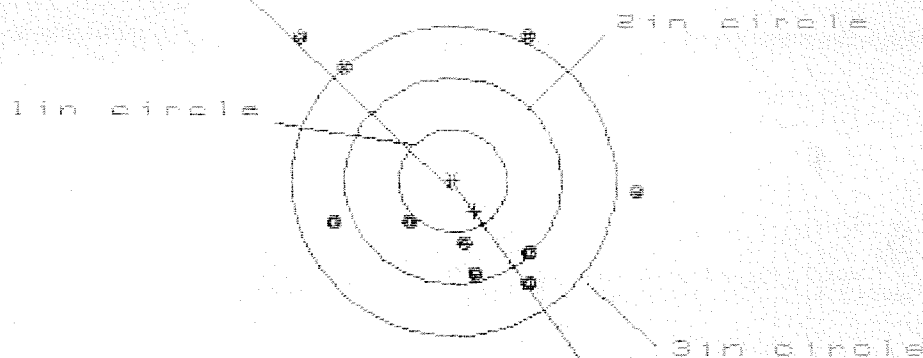
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.052	.849	.732
MINIMUM X	-1.827	-.942	-.772
MAXIMUM Y	1.489	1.346	1.190
MINIMUM Y	-1.406	-1.249	-1.195
CENTROID X	-.066	.138	.255
CENTROID Y	.142	-.015	.141
POB TO CENTROID in.	.156	.138	.292
MIN RADIUS	.288	.038	.221
MEAN RADIUS	1.046	.854	.784
MAX RADIUS	2.308	1.564	1.385
HORIZONTAL SPREAD	2.888	1.791	1.564
VERTICAL SPREAD	2.815	2.595	2.385
EXTREME SPREAD	3.732	2.749	2.494
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

9 Sep 1991

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CENTERFIRE PATTERNS # 3

POB



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 3.097

VS= 2.419

GS= 3.448

CENTROID #

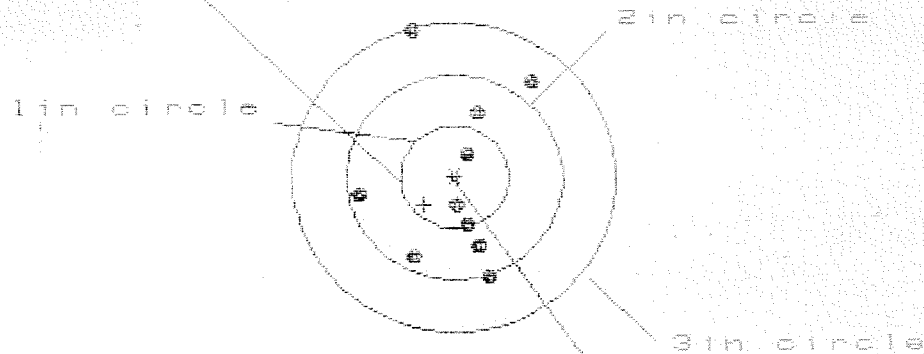
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.642	1.480	.758
MINIMUM X	-1.455	-1.307	-1.121
MAXIMUM Y	1.437	1.542	1.552
MINIMUM Y	-.982	-.823	-.813
CENTROID X	-.192	-.030	-.215
CENTROID Y	.290	.131	.121
POB TO CENTROID in.	.348	.134	.247
MIN RADIUS	.533	.432	.418
MEAN RADIUS	1.207	1.062	.993
MAX RADIUS	2.045	1.695	1.727
HORIZONTAL SPREAD	3.097	2.787	1.879
VERTICAL SPREAD	2.419	2.365	2.365
EXTREME SPREAD	3.448	2.866	2.642
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

9 Sep 1991

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CENTERFIRE PATTERNS # 4

FOR



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.605

VS= 2.395

GS= 2.508

PATTERN #

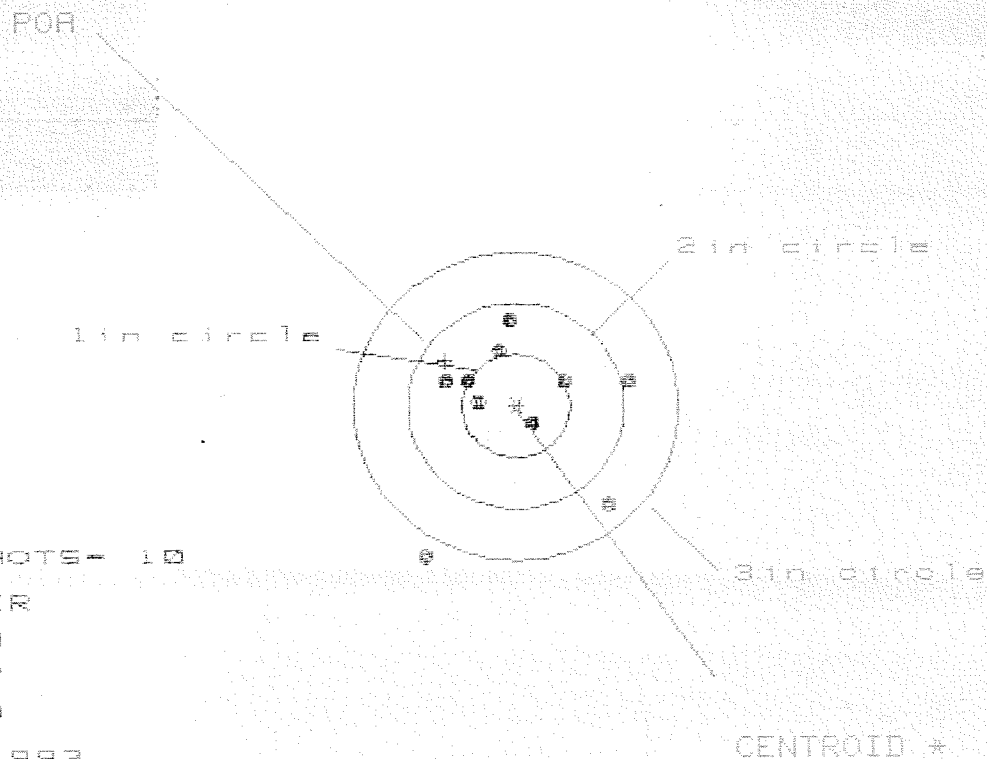
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	.700	.652	.344
MINIMUM X	-.905	-.953	-.872
MAXIMUM Y	1.462	1.096	.974
MINIMUM Y	-.933	-.771	-.634
CENTROID X	.284	.332	.251
CENTROID Y	.266	.104	-.033
FOR TO CENTROID in.	.389	.348	.253
MIN RADIUS	.209	.142	.074
MEAN RADIUS	.785	.665	.559
MAX RADIUS	1.524	1.275	1.006
HORIZONTAL SPREAD	1.605	1.605	1.216
VERTICAL SPREAD	2.395	1.867	1.608
EXTREME SPREAD	2.508	2.019	1.611
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

5 Sep 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.993

VS= 2.286

GS= 2.621

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.097	.997	1.090
MINIMUM X	-1.896	-.757	-.664
MAXIMUM Y	.853	.693	.558
MINIMUM Y	-1.433	-1.082	-.418
CENTROID X	.652	.752	.659
CENTROID Y	-.440	-.280	-.145
POA TO CENTROID in.	.787	.883	.675
MIN RADIUS	.230	.298	.272
MEAN RADIUS	.776	.652	.543
MAX RADIUS	1.691	1.313	1.090
HORIZONTAL SPREAD	1.993	1.754	1.754
VERTICAL SPREAD	2.286	1.775	.976
EXTREME SPREAD	2.621	1.981	1.754
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		