

Smead®

FORM

UPC



0 47700 25716 7

C6648977

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

5716

ORDER NO.

MODEL 700 TM M24

RemingtonVERY IMPORTANT.
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24****SERIAL NO.**
C6648977

20

ORDER NO.
5716

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



5716 C6648977

ORDER 5716
MODEL 700™ M24
UPC

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648977

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action	OCT	3 1991	Kcd
	Magnaflux Bolt	OCT	3 1991	Kcd
615	Rollmark Caliber	OCT	3 1991	GB
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-25-91	JA

op. #	BARBER M24 0030206	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-25-91	JK
	G) Safety Off Force	3	3	3			11-25-91	JK
	H) Trigger Pull Test & Retainability						11-25-91	JK
	I) Firing Pin Indent	.020	.020	.020			11-25-91	JK
	J) Assemble Stock						11/25/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	RW
	M) Iron Sight Alignment						11/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	RW
	O) Attach Scope to Rifle						11/25/91	RW
	P) Detach & Attach Scope 20 Times						11/25/91	RW
640	Gallery Target & Test						11/25/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/25/91	KT
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	254	260	260	260	260	11-26-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO C-6648977DATE 11-25-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.52	2.50	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.65	2.44	2.60	
PULL #3	2.58	2.56	2.55	2.60	
PULL #4	2.57	2.65	2.51	2.60	
PULL #5	2.62	2.65	2.54	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.37		
PULL #2	3.44	3.42		
PULL #3	3.53	3.41		
PULL #4	3.40	3.38		
PULL #5	3.45	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.38		4.36
PULL #2	4.50	4.30		4.28
PULL #3	4.57	4.35		4.35
PULL #4	4.42	4.28		4.34
PULL #5	4.44	4.36		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648977
25 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.0754321
1 TO 2	.351712
1 TO 3	.109371
1 TO 4	.0840595
1 TO 5	.139043

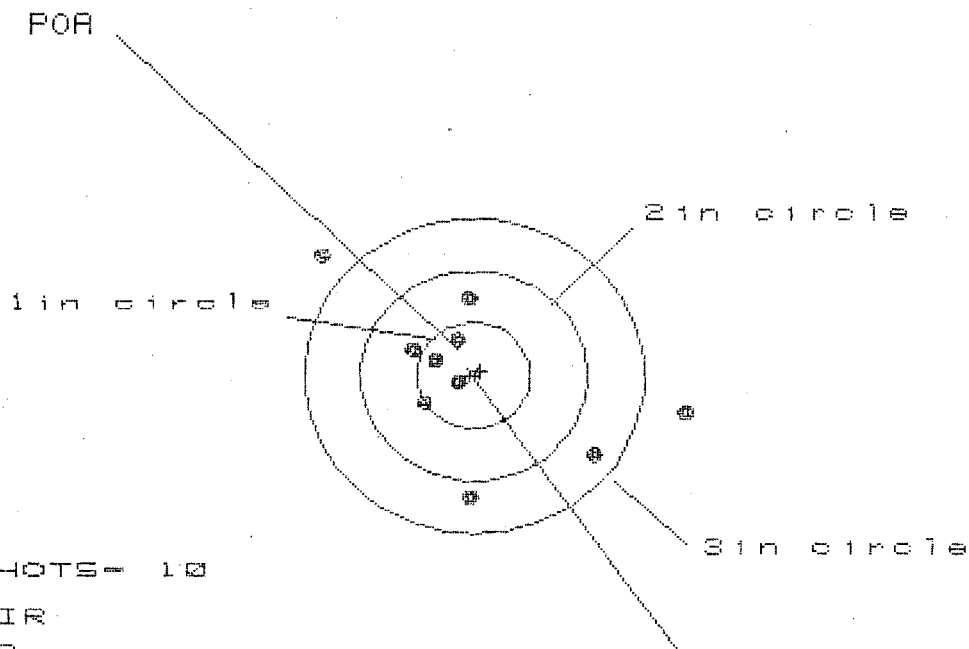
2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0392
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .02
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0440073
THE AMR FOR THIS RIFLE IS: .9198

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B977

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.226

VS= 2.274

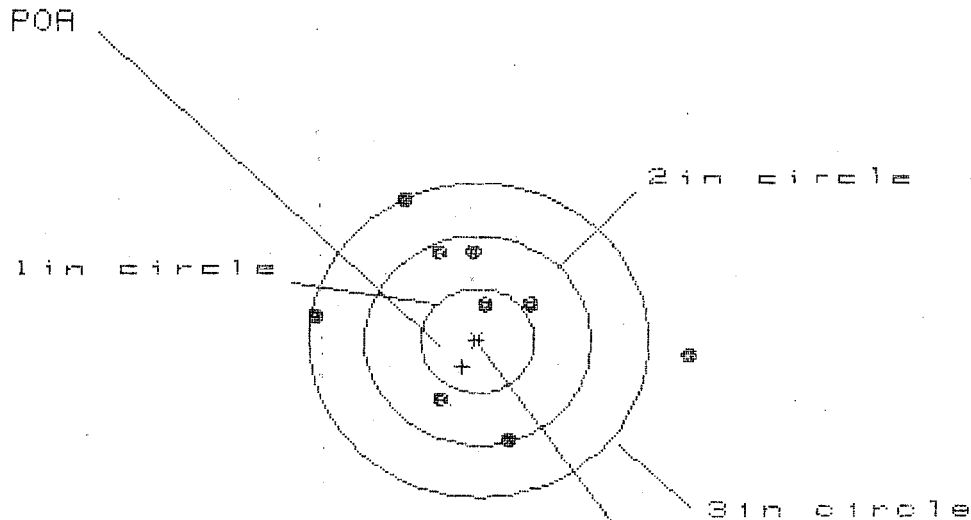
GS= 3.550

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.893	1.293	1.152
MINIMUM X	-1.333	-1.122	-.433
MAXIMUM Y	1.156	1.120	.843
MINIMUM Y	-1.118	-1.154	-1.014
CENTROID X	-.059	-.270	-.129
CENTROID Y	-.047	-.011	-.151
POA TO CENTROID in.	.076	.270	.199
MIN RADIUS	.167	.116	.092
MEAN RADIUS	.882	.699	.628
MAX RADIUS	1.921	1.586	1.345
HORIZONTAL SPREAD	3.226	2.415	1.585
VERTICAL SPREAD	2.274	2.274	1.857
EXTREME SPREAD	3.550	3.106	1.908
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648377

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 3.284

VS = 3.520

GS = 3.632

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.839	1.866	.746
MINIMUM X	-1.456	-1.428	-1.195
MAXIMUM Y	1.356	1.115	1.063
MINIMUM Y	-2.164	-1.222	-1.274
CENTROID X	.140	.112	-.121
CENTROID Y	.247	.488	.540
POA TO CENTROID in.	.284	.500	.553
MIN RADIUS	.358	.164	.364
MEAN RADIUS	1.135	.964	.845
MAX RADIUS	2.178	1.912	1.371
HORIZONTAL SPREAD	3.294	3.294	1.941
VERTICAL SPREAD	3.520	2.337	2.337
EXTREME SPREAD	3.632	3.322	2.503
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06648977

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.096

VS = 2.391

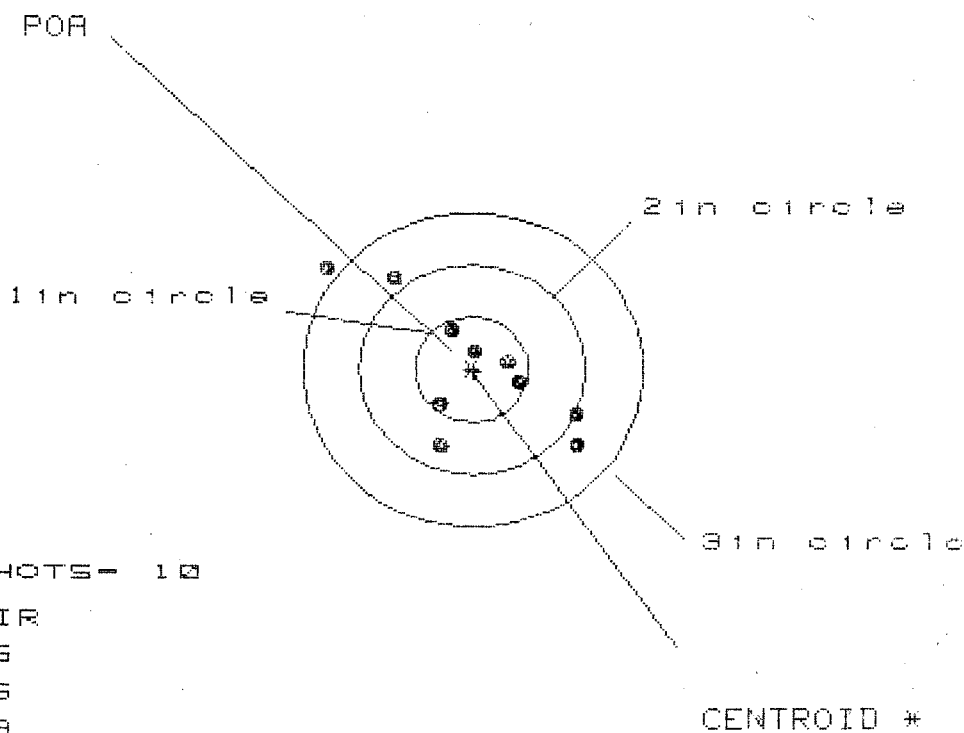
GS = 2.396

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.634	.472	.512
MINIMUM X	-1.462	-.723	-.683
MAXIMUM Y	1.334	1.339	.768
MINIMUM Y	-1.057	-1.052	-.885
CENTROID X	.050	.212	.172
CENTROID Y	-.056	-.061	-.228
POA TO CENTROID in.	.075	.221	.286
MIN RADIUS	.288	.147	.304
MEAN RADIUS	.868	.780	.714
MAX RADIUS	1.462	1.376	1.022
HORIZONTAL SPREAD	2.096	1.195	1.195
VERTICAL SPREAD	2.391	2.391	1.653
EXTREME SPREAD	2.396	2.396	1.854
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648977

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 5

2in = 6

3in = 9

HS= 2.194

VS= 1.681

GS= 2.764

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.818	.915
MINIMUM X	:	-1.238	-.793	-.691
MAXIMUM Y	:	.934	1.020	.939
MINIMUM Y	:	-.747	-.643	-.673
CENTROID X	:	-.014	.124	.021
CENTROID Y	:	.024	-.080	.001
POA TO CENTROID in.	:	.028	.147	.022
MIN RADIUS	:	.165	.267	.184
MEAN RADIUS	:	.754	.652	.595
MAX RADIUS	:	1.551	1.292	1.166
HORIZONTAL SPREAD	:	2.194	1.511	1.605
VERTICAL SPREAD	:	1.681	1.663	1.612
EXTREME SPREAD	:	2.764	2.315	2.106
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B48977

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 3.228

VS = 1.522

GS = 3.315

CENTROID *

PATTERN #	5	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.328	1.117	.942
MINIMUM X	-1.900	-1.393	-1.193
MAXIMUM Y	.826	.767	.752
MINIMUM Y	-.697	-.755	-.659
CENTROID X	.079	.290	.465
CENTROID Y	-.064	-.006	-.102
POA TO CENTROID in.	.102	.290	.476
MIN RADIUS	.076	.293	.232
MEAN RADIUS	.960	.828	.690
MAX RADIUS	1.971	1.591	1.331
HORIZONTAL SPREAD	3.228	2.510	2.135
VERTICAL SPREAD	1.522	1.522	1.411
EXTREME SPREAD	3.315	2.580	2.160
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		