

C6649070

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.

MODEL 700TM H24

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

SERIAL NO.
 C6649070

ORDER NO.
5716

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

20



5716 C6649070

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649070

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KA
600	Proof		6/25/91	KA
607	Check Headspace		6/25/91	KA
610	Dis-assemble Gun		6/25/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		6/27/91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/10/91	D/H

op. #	BARBER, M24 0031305 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-10-91	DH
	G) Safety Off Force	3	2½	2½			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	DH
	I) Firing Pin Indent	.022	.021	.022			8-10-91	DH
	J) Assemble Stock						8/10/91	KH
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8/10/91	KH
	M) Iron Sight Alignment						8/10/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	KH
	O) Attach Scope to Rifle						8/10/91	KH
	P) Detach & Attach Scope 20 Times						8/10/91	KH
640	Gallery Target & Test						8/12/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/12/91	KT
655	Final Inspection							
	A) Headspace						8-13-91	DH
	B) Trigger Pull	2.71	2.57	2.56	2.55	2.49	8-13-91	92
	C) Function						8-13-91	DH
660	Pack						9-18-91	NF

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

SERIAL NO. C6649070DATE 8-10-91TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.79	2.80	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.96	2.81	2.57	
PULL #3	2.76	2.91	2.71	2.56	
PULL #4	2.71	2.97	2.73	2.55	
PULL #5	2.70	2.92	2.80	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.28		
PULL #2	3.09	3.38		
PULL #3	3.18	3.29		
PULL #4	3.30	3.12		
PULL #5	3.12	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.64		4.57
PULL #2	4.32	4.75		4.68
PULL #3	4.58	4.74		4.75
PULL #4	4.56	4.68		4.85
PULL #5	4.67	4.59		4.90
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649070
12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.24016
1 TO	2	.467247
1 TO	3	.194815
1 TO	4	.0798123
1 TO	5	.179622

2
M <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .122376
THE AMR FOR THIS RIFLE IS: .8874

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/G8649070

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.219

VS = 1.773

GS = 2.840

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.071	.943	.796
MINIMUM X	-1.148	-1.127	-1.009
MAXIMUM Y	.930	.836	.391
MINIMUM Y	-.843	-.444	-.340
CENTROID X	.214	.342	.224
CENTROID Y	-.109	-.015	-.119
POA TO CENTROID in.	.240	.342	.254
MIN RADIUS	.188	.142	.198
MEAN RADIUS	.785	.684	.626
MAX RADIUS	1.425	1.260	1.059
HORIZONTAL SPREAD	2.219	2.070	1.805
VERTICAL SPREAD	1.773	1.280	.730
EXTREME SPREAD	2.840	2.424	1.840
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649070

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.107

VS = 2.267

GS = 2.734

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.014	1.004	.912
MINIMUM X	-1.093	-.980	-1.071
MAXIMUM Y	.975	.899	.784
MINIMUM Y	-1.292	-1.184	-1.299
CENTROID X	-.034	-.147	-.055
CENTROID Y	.287	.179	.294
POA TO CENTROID in.	.289	.231	.300
MIN RADIUS	.177	.310	.172
MEAN RADIUS	.911	.860	.797
MAX RADIUS	1.407	1.201	1.333
HORIZONTAL SPREAD	2.107	1.984	1.984
VERTICAL SPREAD	2.267	2.083	2.083
EXTREME SPREAD	2.734	2.135	2.086
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

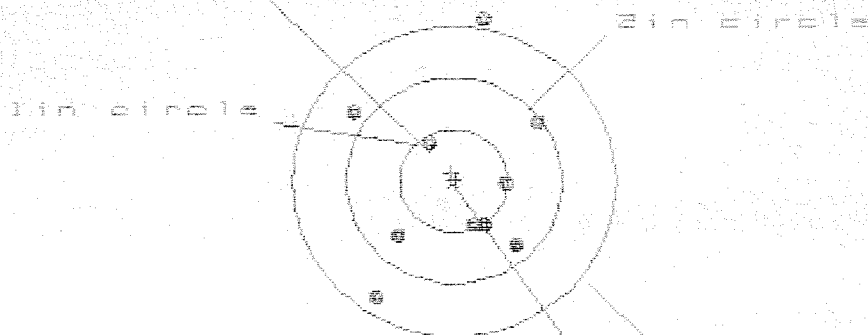
12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849070

CENTERFIRE PATTERNS

3

FOR



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.697

VS= 2.629

GS= 2.816

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.740	.769	.678
MINIMUM X	-.957	-.928	-1.019
MAXIMUM Y	1.544	.849	.735
MINIMUM Y	-1.085	-.914	-.615
CENTROID X	.022	-.007	.084
CENTROID Y	-.076	-.247	-.133
FOR TO CENTROID in.	.079	.248	.157
MIN RADIUS	.455	.369	.394
MEAN RADIUS	.854	.750	.690
MAX RADIUS	1.565	1.258	1.256
HORIZONTAL SPREAD	1.697	1.697	1.697
VERTICAL SPREAD	2.629	1.763	1.350
EXTREME SPREAD	2.816	2.247	2.024
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

(12 Aug 1991)

FILE: /PATTERNING/CENTERFIRE_PATT/C6649070

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 9

HS = 2.724

VS = 2.229

GS = 2.886

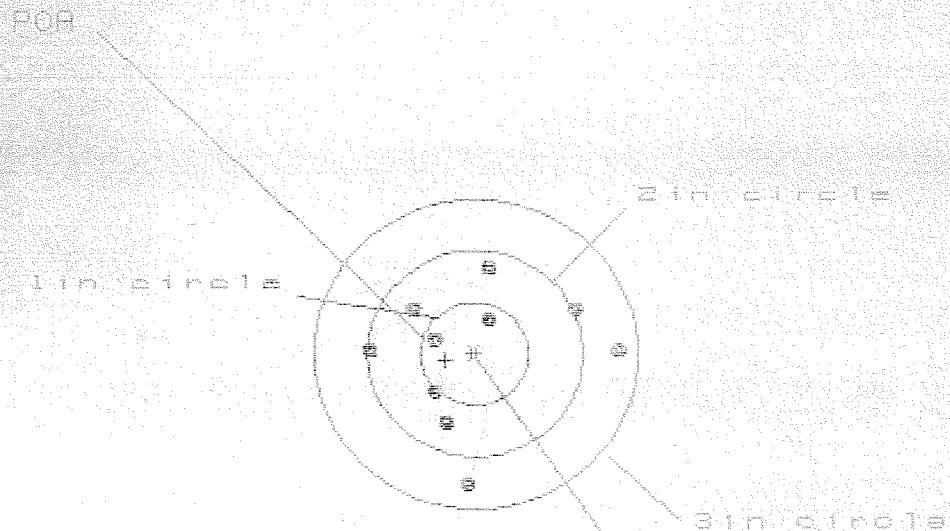
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.153	.979	1.058
MINIMUM X	-1.571	-1.237	-1.148
MAXIMUM Y	1.135	1.192	1.219
MINIMUM Y	-1.094	-1.037	-.888
CENTROID X	.137	.311	.222
CENTROID Y	-.130	-.187	-.336
POA TO CENTROID in.	.189	.363	.402
MIN RADIUS	.277	.338	.189
MEAN RADIUS	1.078	.982	.917
MAX RADIUS	1.653	1.391	1.304
HORIZONTAL SPREAD	2.724	2.216	2.216
VERTICAL SPREAD	2.229	2.229	2.107
EXTREME SPREAD	2.886	2.673	2.223
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

12 Aug 1997

FILE:/PATTERNING/CENTERFIRE_PATT/C6649070

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HE= 2.356

VS= 2.142

GS= 2.356

CENTROID *

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.367	1.085	1.091
MINIMUM X	-.989	-.837	-.831
MAXIMUM Y	.859	.868	.709
MINIMUM Y	-1.283	-1.274	-.787
CENTROID X	.272	.120	.114
CENTROID Y	.061	.052	.211
POA TO CENTROID in.	.279	.131	.240
MIN RADIUS	.358	.278	.195
MEAN RADIUS	.817	.728	.639
MAX RADIUS	1.370	1.275	1.119
HORIZONTAL SPREAD	2.356	1.922	1.922
VERTICAL SPREAD	2.142	2.142	1.496
EXTREME SPREAD	2.356	2.157	1.955
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	