

C6649073

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.

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

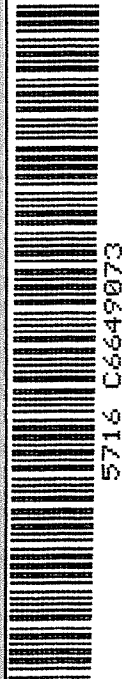
MODEL 700™ M24

SERIAL NO. C6649073

ORDER NO. 5716

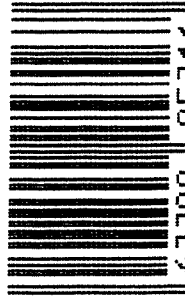
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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



5716 C6649073

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFMGUN SERIAL # **C6649073**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KA
600	Proof		7/24/91	KA
607	Check Headspace		7/24/91	KA
610	Dis-assemble Gun		7/24/91	KA
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	JS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KA
	C) Inspect Ejector Hole for Chamfer		8/29/91	KA
	D) Oil Firing Pin Ass'y		8/29/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9/14/91	KA

op. #	BARBER M24 0031341	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/7/91	SL
	G) Safety Off Force	4	4	4			9/4/91	SL
	H) Trigger Pull Test & Retainability						9/4/91	SL
	I) Firing Pin Indent	.0205	.021	.021			9/4/91	SL
	J) Assemble Stock						9/5/91	SL
	K) Assemble Swivel Studs						9-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/5/91	SL
	M) Iron Sight Alignment						9/5/91	SL
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	SL
	O) Attach Scope to Rifle						9/5/91	SL
	P) Detach & Attach Scope 20 Times						9/5/91	SL
640	Gallery Target & Test						9-7-91	NE
	A) Time						"	NE
	B) Malfunctions						"	NE
	C) Pierced Primers						"	NE
	D) Optical Clarity of Scope						"	NE
645	Inspect for Live Ammo						9-7-91	NE
655	Final Inspection						9-11-91	D/H
	A) Headspace						9-11-91	D/H
	B) Trigger Pull	217	217	211	216	214	9-11-91	D/H
	C) Function						9-11-91	D/H
660	Pack						9-11-91	NE

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

SERIAL NO C-6649073DATE 9-4-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.34	2.38	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.34	2.25	2.17	
PULL #3	2.35	2.38	2.36	2.11	
PULL #4	2.30	2.34	2.38	2.16	
PULL #5	2.38	2.32	2.40	2.14	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.32		
PULL #2	3.45	3.37		
PULL #3	3.45	3.32		
PULL #4	3.35	3.31		
PULL #5	3.37	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.66		4.35
PULL #2	4.55	4.41		4.39
PULL #3	4.57	4.34		4.39
PULL #4	4.54	4.30		4.43
PULL #5	4.57	4.36		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C8649073

7 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.302154
1 TO 2	.203745
1 TO 3	.207171
1 TO 4	.331593
1 TO 5	.244182

←---FOR

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.096

AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0496

AVERAGE POI RADIUS FOR THIS RIFLE IS: .108056

AVERAGE FOR THIS RIFLE IS: 1.026

5-1 (31)

FILE:/PATTERNING/CENTERFIRE_PATT/C6645073

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 5.300

VS= 2.493

GS= 5.857

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =



10

9

8

2.165

1.816

1.279

-3.135

-1.765

-1.538

1.343

1.215

1.170

-1.150

-1.100

-.948

-.279

.070

-.157

-.116

.012

-.140

.302

.071

.210

.379

.707

.436

1.485

1.291

1.122

3.340

2.185

1.611

5.300

3.581

2.817

2.493

2.315

2.118

5.857

3.922

2.994

1

3

6

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649073

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.554

VS = 1.964

GS = 2.859

PATTERN #

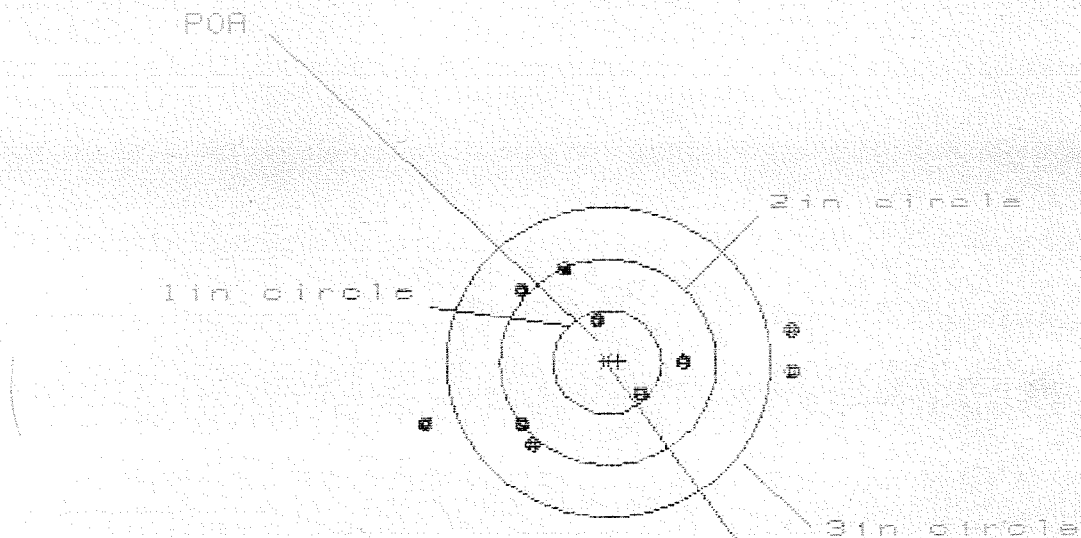
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.516	.758	.598
MINIMUM X	-1.138	-.970	-.875
MAXIMUM Y	.766	.689	.529
MINIMUM Y	-1.198	-1.275	-.689
CENTROID X	-.105	-.273	-.368
CENTROID Y	-.010	.067	.227
POA TO CENTROID in.	.105	.282	.433
MIN RADIUS	.342	.396	.214
MEAN RADIUS	.874	.768	.652
MAX RADIUS	1.667	1.484	1.032
HORIZONTAL SPREAD	2.654	1.728	1.473
VERTICAL SPREAD	1.964	1.964	1.218
EXTREME SPREAD	2.859	2.378	1.773
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6549073

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 7

HS = 3.389

VS = 1.710

GS = 3.482

PATTERN #

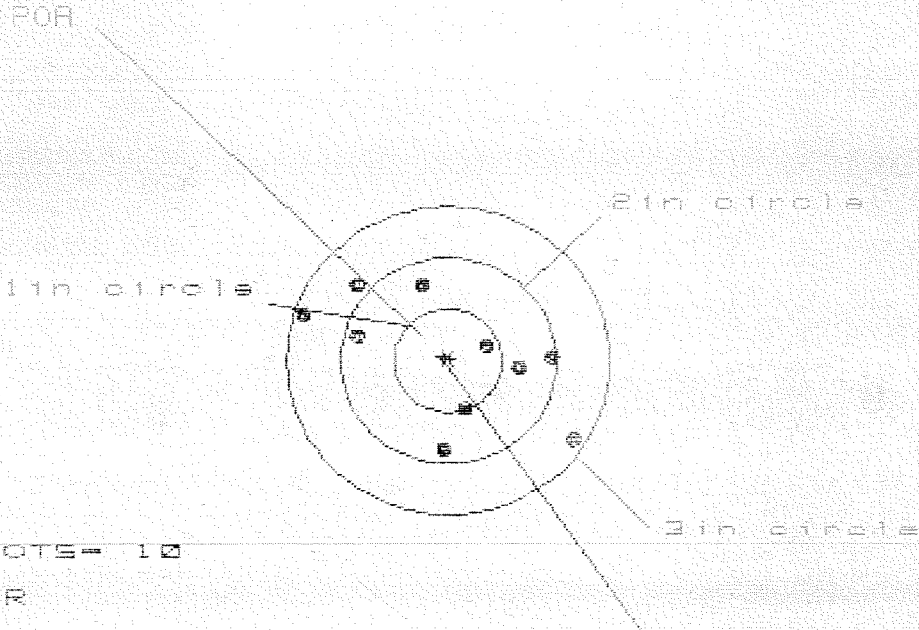
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.710	1.527	1.672
MINIMUM X	-1.676	-0.964	-0.773
MAXIMUM Y	.928	.859	.836
MINIMUM Y	-0.782	-0.851	-0.874
CENTROID X	-0.101	.085	-0.106
CENTROID Y	-0.010	.059	.082
POA TO CENTROID in.	.102	.103	.134
MIN RADIUS	.369	.339	.310
MEAN RADIUS	1.075	.990	.901
MAX RADIUS	1.786	1.538	1.692
HORIZONTAL SPREAD	3.389	2.491	2.445
VERTICAL SPREAD	1.710	1.710	1.710
EXTREME SPREAD	3.482	2.620	2.611
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649073

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.450

VS= 1.639

GS= 2.721

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.145	1.068	.920
MINIMUM X	-1.305	-1.177	-.837
MAXIMUM Y	.770	.683	.722
MINIMUM Y	-.869	-.956	-.917
CENTROID X	.044	-.084	.063
CENTROID Y	-.041	.046	.007
POA TO CENTROID in.	.060	.096	.064
MIN RADIUS	.389	.505	.360
MEAN RADIUS	.878	.827	.752
MAX RADIUS	1.387	1.218	1.059
HORIZONTAL SPREAD	2.450	2.245	1.757
VERTICAL SPREAD	1.639	1.639	1.639
EXTREME SPREAD	2.721	2.281	1.892
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649873

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.742

VS = 2.578

GS = 2.744

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X	1.479	.592	.619
MINIMUM X	-1.263	-1.098	-1.071
MAXIMUM Y	1.349	1.387	.781
MINIMUM Y	-1.229	-1.191	-1.018
CENTROID X	-.039	-.204	-.231
CENTROID Y	-.071	-.109	-.282
POA TO CENTROID in.	.081	.231	.365
MIN RADIUS	.116	.279	.258
MEAN RADIUS	.818	.759	.667
MAX RADIUS	1.518	1.404	1.161
HORIZONTAL SPREAD	2.742	1.690	1.690
VERTICAL SPREAD	2.578	2.578	1.799
EXTREME SPREAD	2.744	2.644	1.891
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	