

C6649085

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington

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

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

MODEL 700™ M24

SERIAL NO. C6649086

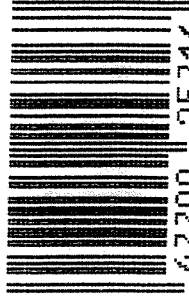
ORDER NO. 5716

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



5716 C6649086

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649086

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	SL
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 7 3 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KL
	C) Inspect Ejector Hole for Chamfer		9/4/91	KL
	D) Oil Firing Pin Ass'y		9/4/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		9/5/91	KL

op. #	BARBER M24 0031489	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 $\frac{3}{4}$	5 $\frac{1}{4}$	5			9-5-91	D/H
	G) Safety Off Force	2 $\frac{1}{2}$	2 $\frac{3}{4}$	2 $\frac{1}{4}$			9-5-91	D/H
	H) Trigger Pull Test & Retainability						9-5-91	SH
	I) Firing Pin Indent	1020	1020	1020			9-5-91	D/H
	J) Assemble Stock						9-10-91	KE
	K) Assemble Swivel Studs						9-12-91	D/H
	L) Attach Front and Rear Sight Assemblies						9-10-91	KE
	M) Iron Sight Alignment						9-10-91	KE
	N) Detach Front & Rear Sights & place in numbered container						9-10-91	KE
	O) Attach Scope to Rifle						9-10-91	KE
	P) Detach & Attach Scope 20 Times						9-10-91	KE
640	Gallery Target & Test						9-11-91	AC
	A) Time						9-11-91	AC
	B) Malfunctions						9-11-91	AC
	C) Pierced Primers						9-11-91	AC
	D) Optical Clarity of Scope						9-11-91	AC
645	Inspect for Live Ammo						9-11-91	AC
655	Final Inspection						9-12-91	D/H
	A) Headspace						9-12-91	SH
	B) Trigger Pull	2.53	2.41	2.39	2.36	2.36	9-12-91	D/H
	C) Function						9-12-91	D/H
660	Pack						9-18-91	N

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

SERIAL NO. 06649086DATE 9-5-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.49	2.55	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.51	2.49	2.41	
PULL #3	2.53	2.59	2.44	2.39	
PULL #4	2.39	2.55	2.50	2.36	
PULL #5	2.53	2.63	2.50	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.33		
PULL #2	3.49	3.37		
PULL #3	3.47	3.44		
PULL #4	3.62	3.51		
PULL #5	3.61	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.43		4.30
PULL #2	4.36	4.45		4.33
PULL #3	4.35	4.36		4.46
PULL #4	4.30	4.34		4.54
PULL #5	4.26	4.38		4.51
TOTAL				
AVG.				

MISSILE CALCULATIONS

MISSILE # 06649086

MISSILE DISTANCES

1	.289527
2	.27347
3	.0936483
4	.427649
Tot 5	.496847

$\pm \frac{1}{2}$ <----POA

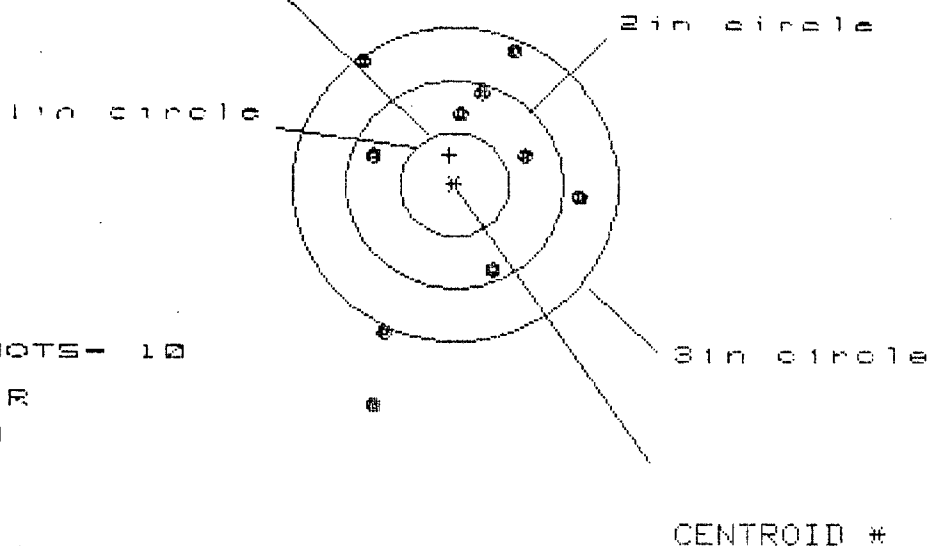
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1816
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1702
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .24882

THE AMR FOR THIS RIFLE IS: .8944

(1 Sep 61)

FILE: PATTERNING/CENTERFIRE_PATT/06649086

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 1.970

VS = 3.327

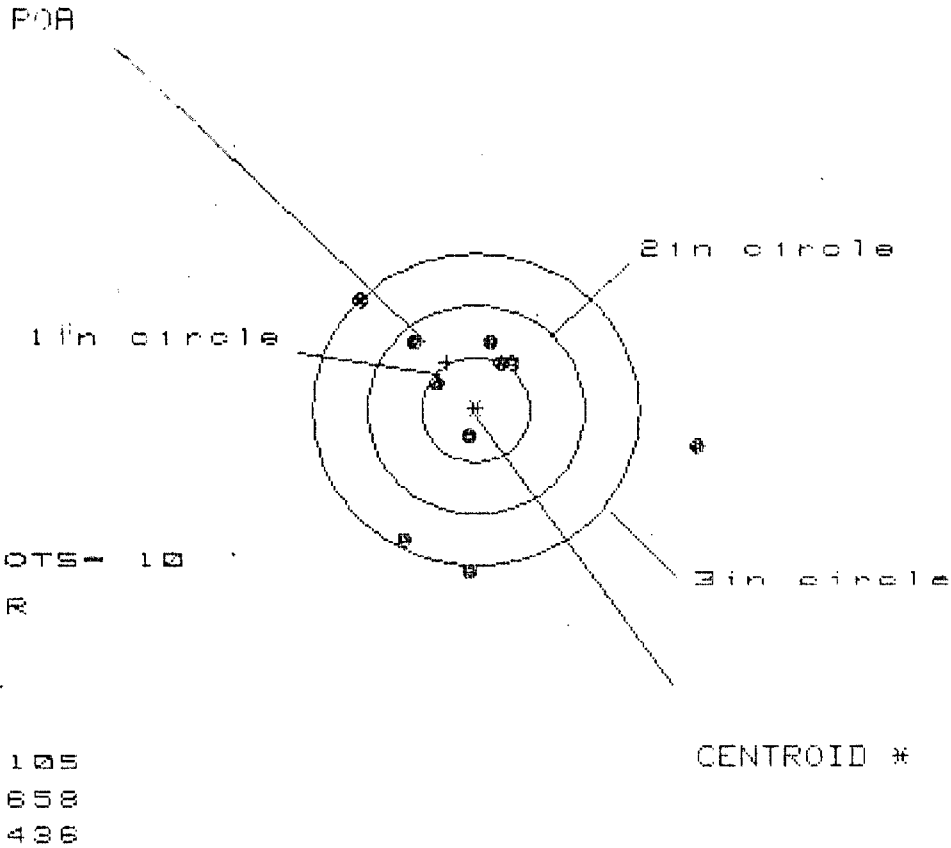
GS = 3.563

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.167	1.081	.984
MINIMUM X	-.803	-.889	-.986
MAXIMUM Y	1.245	1.014	.813
MINIMUM Y	-2.082	-1.606	-1.257
CENTROID X	.051	.137	.234
CENTROID Y	-.285	-.054	.147
POA TO CENTROID in.	.290	.147	.277
MIN RADIUS	.644	.408	.233
MEAN RADIUS	1.155	.977	.819
MAX RADIUS	2.222	1.785	1.262
HORIZONTAL SPREAD	1.970	1.970	1.970
VERTICAL SPREAD	3.327	2.620	2.070
EXTREME SPREAD	3.563	2.878	2.355
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

(1 Sep 1991)

FILE: PATTERNING/CENTERFIRE_PATT/C6649086

CENTERFIRE PATTERNS # 2



PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.080	.558	.576
MINIMUM X	-1.025	-.794	-.776
MAXIMUM Y	1.091	1.049	.848
MINIMUM Y	-1.567	-1.609	-1.485
CENTROID X	.266	.035	.017
CENTROID Y	-.454	-.412	-.211
POA TO CENTROID in.	.526	.413	.211
MIN RADIUS	.281	.217	.107
MEAN RADIUS	.988	.845	.700
MAX RADIUS	2.114	1.616	1.555
HORIZONTAL SPREAD	3.105	1.352	1.352
VERTICAL SPREAD	2.658	2.658	2.333
EXTREME SPREAD	3.436	2.819	2.354
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6645086

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.785

VS= 1.760

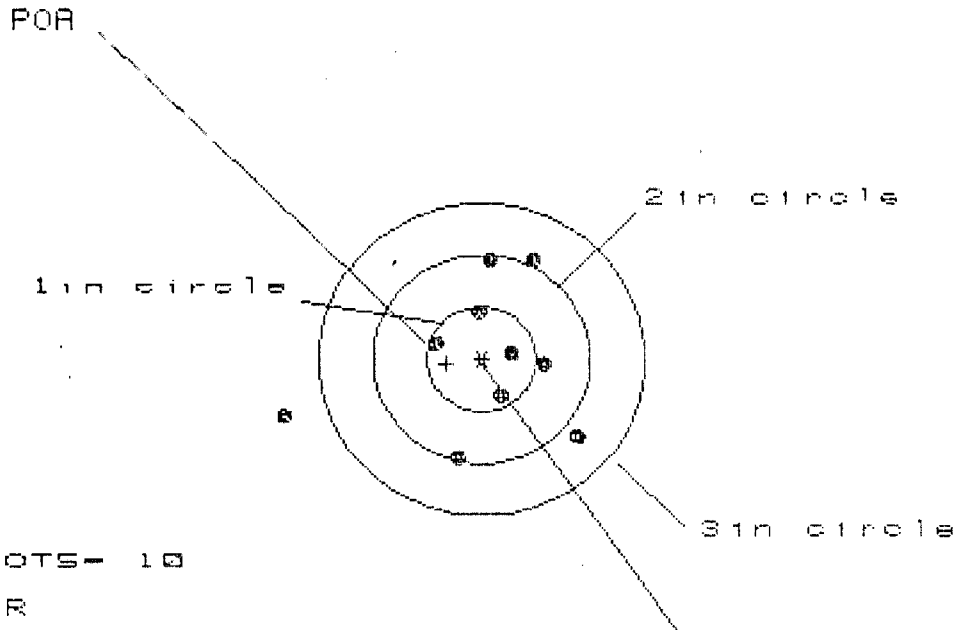
GS= 2.082

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.027	.953	.622
MINIMUM X	-.758	-.832	-.713
MAXIMUM Y	1.162	.784	.794
MINIMUM Y	-.598	-.469	-.459
CENTROID X	-.042	.032	-.087
CENTROID Y	-.296	-.425	-.435
POA TO CENTROID in.	.299	.426	.444
MIN RADIUS	.090	.122	.157
MEAN RADIUS	.654	.557	.504
MAX RADIUS	1.340	.956	.874
HORIZONTAL SPREAD	1.785	1.785	1.335
VERTICAL SPREAD	1.760	1.253	1.253
EXTREME SPREAD	2.082	1.855	1.619
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.753

VS= 1.886

GS= 2.768

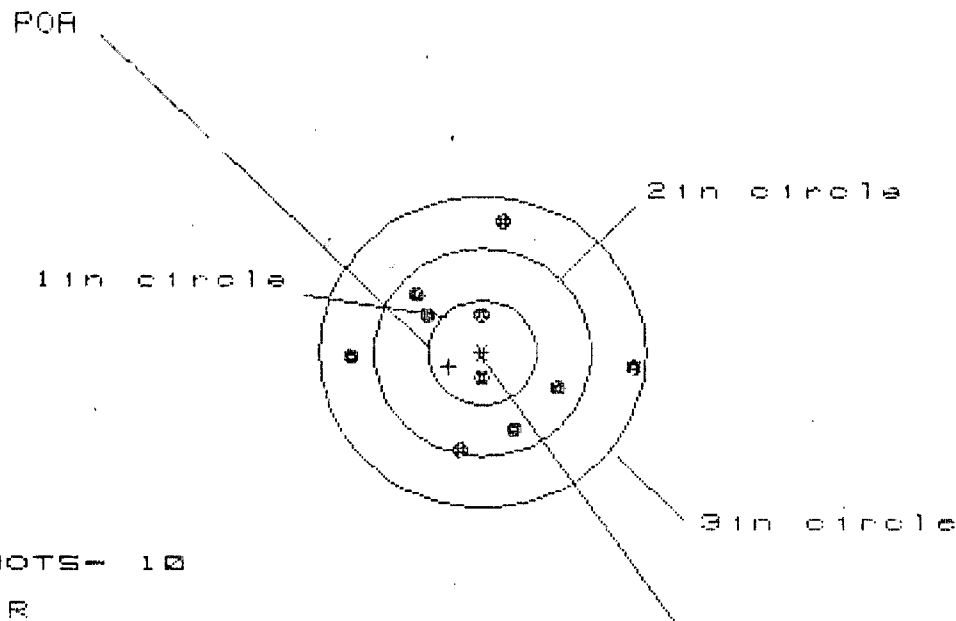
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.691	.421
MINIMUM X	-1.856	-.606	-.519
MAXIMUM Y	.962	.904	.805
MINIMUM Y	-.924	-.982	-1.081
CENTROID X	.323	.529	.442
CENTROID Y	.045	.103	.202
POA TO CENTROID in.	.326	.539	.486
MIN RADIUS	.330	.116	.218
MEAN RADIUS	.814	.650	.599
MAX RADIUS	1.928	1.054	1.121
HORIZONTAL SPREAD	2.753	1.297	.940
VERTICAL SPREAD	1.886	1.886	1.886
EXTREME SPREAD	2.768	1.966	1.966
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.585

VS= 2.273

GS= 2.587

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.383	.851	.892
MINIMUM X	-1.202	-1.048	-1.006
MAXIMUM Y	1.295	1.279	.720
MINIMUM Y	-.978	-.994	-.834
CENTROID X	.310	.156	.114
CENTROID Y	.139	.155	-.005
FOR TO CENTROID in.	.340	.220	.115
MIN RADIUS	.240	.269	.167
MEAN RADIUS	.861	.791	.716
MAX RADIUS	1.391	1.322	1.010
HORIZONTAL SPREAD	2.585	1.899	1.899
VERTICAL SPREAD	2.273	2.273	1.554
EXTREME SPREAD	2.587	2.305	1.923
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	