

C6636212

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.

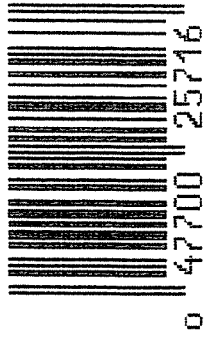
MODEL 700TM M24

MADE IN ILION, 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.	SERIAL NO. C6636212
ORDER NO. 5716	20



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636212

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	CS
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5/30/91	TH
	Apply Coating (Bolt)		5/30/91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-6-91	RM

op. #	BARBER M24 0031794	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-6-91	JK
	G) Safety Off Force	4	4	4			6-6-91	JK
	H) Trigger Pull Test & Retainability						6-6-91	JK
	I) Firing Pin Indent	.020	.021	.021			6-6-91	JK
	J) Assemble Stock						6/8/91	RW
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/8/92	RW
	M) Iron Sight Alignment						6/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/8/91	RW
	O) Attach Scope to Rifle						6/8/91	RW
	P) Detach & Attach Scope 20 Times						6/8/91	RW
640	Gallery Target & Test						6/8/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/8/91	KT
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.75	2.29	2.39	2.33	2.31	6-12-91	JK
	C) Function						6-13-91	AC
660	Pack						6-20-91	W

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636212

DATE C-6-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.57	2.50	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.52	2.53	2.29	
PULL #3	2.52	2.58	2.56	2.39	
PULL #4	2.55	2.57	2.55	2.33	
PULL #5	2.57	2.59	2.45	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.60		
PULL #2	3.46	3.62		
PULL #3	3.56	3.62		
PULL #4	3.54	3.61		
PULL #5	3.55	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.21		4.37
PULL #2	4.27	4.24		4.30
PULL #3	4.23	4.37		4.31
PULL #4	4.19	4.31		4.32
PULL #5	4.20	4.28		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636212
8 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.319038
1 TO	2	.342187
1 TO	3	.113358
1 TO	4	.182989
1 TO	5	.278173

4 (----POB

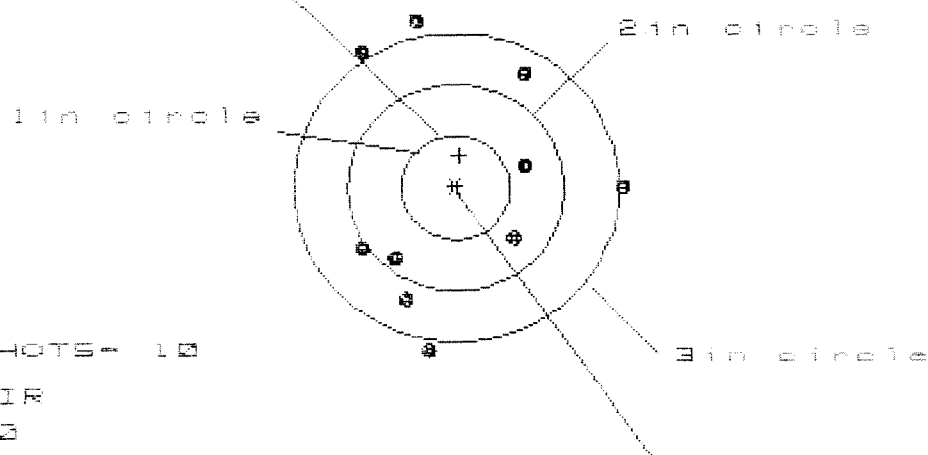
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .255473
THE AMR FOR THIS RIFLE IS: .9802

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636212

CENTERFIRE PATTERNS # 1

POR



OF SHOTS- 10

IN CIR

1in = 6

2in = 3

3in = 7

HS= 3.349

VS= 3.203

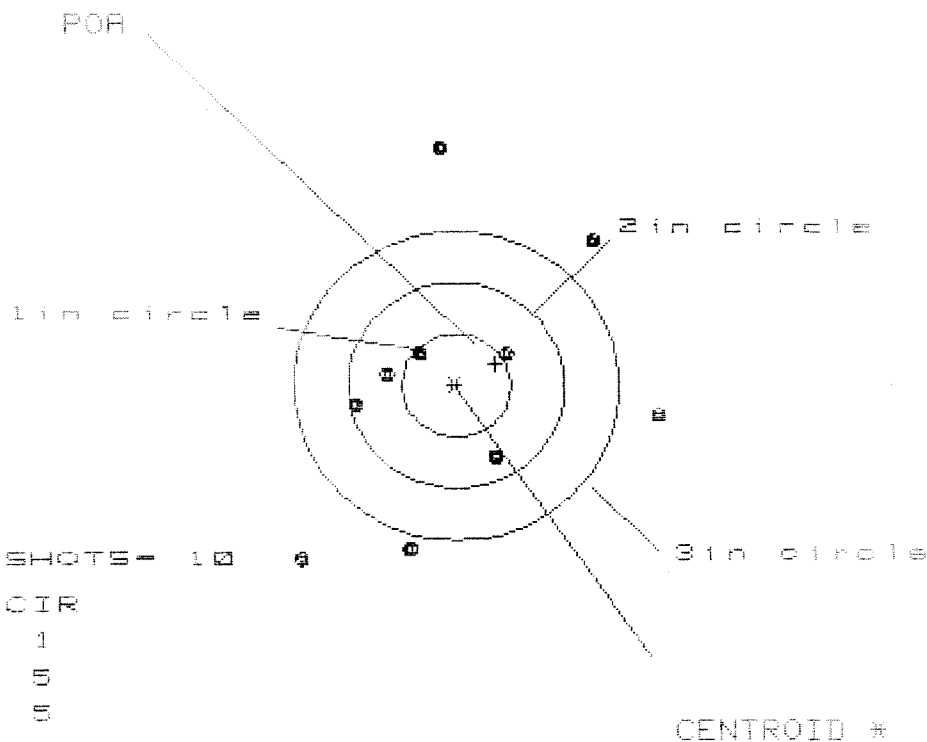
GS= 3.206

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.492	1.453	1.420
MINIMUM X	-1.857	-0.996	-0.929
MAXIMUM Y	1.644	1.493	1.321
MINIMUM Y	-1.559	-1.377	-1.032
CENTROID X	-0.036	.003	.036
CENTROID Y	-0.317	-0.499	-0.327
POR TO CENTROID in.	.319	.499	.329
MIN RADIUS	.683	.548	.622
MEAN RADIUS	1.206	1.123	1.094
MAX RADIUS	1.680	1.735	1.608
HORIZONTAL SPREAD	2.349	2.349	2.349
VERTICAL SPREAD	3.203	2.870	2.353
EXTREME SPREAD	3.206	2.937	2.661
NUMBER IN ONE INCH CIRCLE =	6	5	4
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	7	7	7

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636212

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 5

HS = 3.313

VS = 3.935

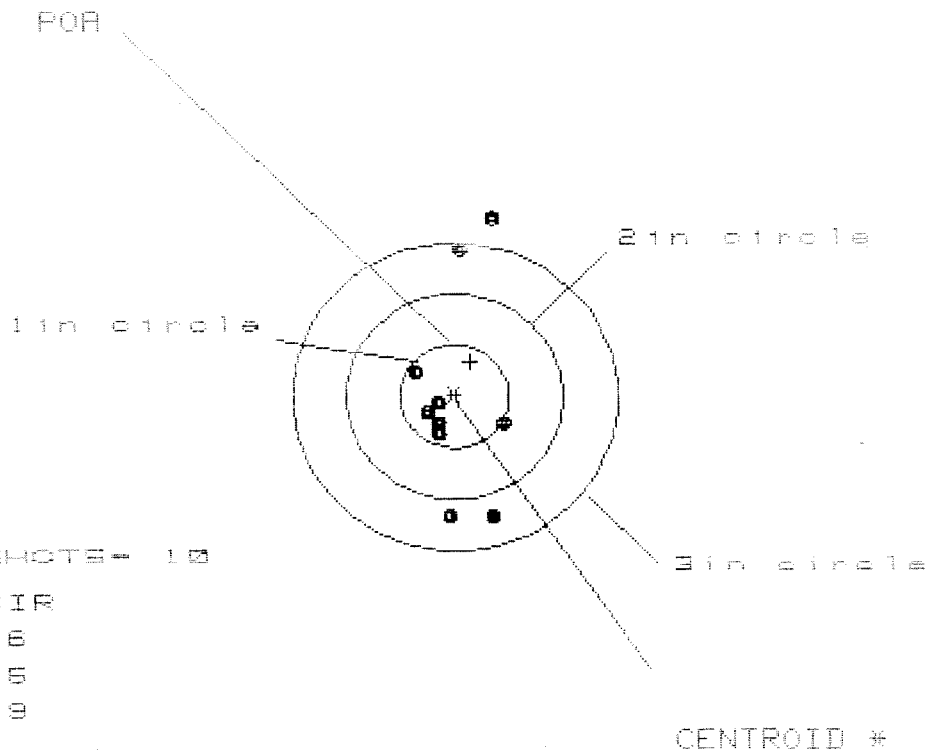
GS = 4.143

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.838
MINIMUM X	-1.475
MAXIMUM Y	2.279
MINIMUM Y	-1.656
CENTROID X	-0.362
CENTROID Y	-0.213
POA TO CENTROID in.	.420
MIN RADIUS	.455
MEAN RADIUS	1.325
MAX RADIUS	2.286
HORIZONTAL SPREAD	3.313
VERTICAL SPREAD	3.935
EXTREME SPREAD	4.143
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	5

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FILE://PATTERNING/CENTERFIRE_PATT/06636212

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 6

2in = 5

3in = 9

HS= .750

VS= 2.907

GS= 2.928

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.424
MINIMUM X	-.326
MAXIMUM Y	1.704
MINIMUM Y	-1.203
CENTROID X	-.147
CENTROID Y	-.340
POA TO CENTROID in.	.371
MIN RADIUS	.203
MEAN RADIUS	.759
MAX RADIUS	1.731
HORIZONTAL SPREAD	.750
VERTICAL SPREAD	2.907
EXTREME SPREAD	2.928
NUMBER IN ONE INCH CIRCLE	6
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636212

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.307

VS= 2.197

GS= 2.498

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	.958	.850
MINIMUM X	:	-1.214	-.859	-.903
MAXIMUM Y	:	1.008	1.116	.981
MINIMUM Y	:	-1.189	-1.081	-.644
CENTROID X	:	.041	.176	.284
CENTROID Y	:	-.151	-.259	-.124
POA TO CENTROID in.	:	.156	.313	.310
MIN RADIUS	:	.346	.183	.187
MEAN RADIUS	:	.878	.743	.660
MAX RADIUS	:	1.556	1.381	1.109
HORIZONTAL SPREAD	:	2.307	1.817	1.753
VERTICAL SPREAD	:	2.197	2.197	1.625
EXTREME SPREAD	:	2.498	2.498	1.976
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8536212

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.209

VS= 1.104

GS= 2.435

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.068
MINIMUM X	-1.141
MAXIMUM Y	.669
MINIMUM Y	-.435
CENTROID X	-.162
CENTROID Y	-.069
POA TO CENTROID in.	.176
MIN RADIUS	.399
MEAN RADIUS	.733
MAX RADIUS	1.260
HORIZONTAL SPREAD	2.209
VERTICAL SPREAD	1.104
EXTREME SPREAD	2.435
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10