

C6636218

MODEL 700TH M24

Model SMSTH

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.



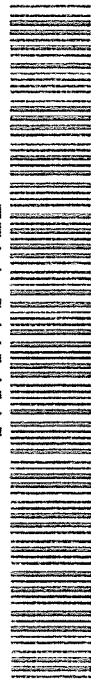
Remington®



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

MODEL 700™ M24

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

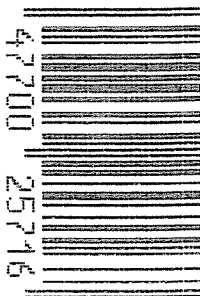


5716 C6636218

SERIAL NO.
C6636218

ORDER NO.
5716

UPC



0 47700 25716 7

Rear ~~stud~~ Swive l
Stud hole Stripped

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636218

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	5 30 91		RW
612	Magnaflux Barrel Action	5 6 91		KCR
	Magnaflux Bolt	5 6 91		KCR
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-50-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/19/91	AF

op. #	BARBER - M24 0031862	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-19-91	RL
	G) Safety Off Force	4	4	4			7-19-91	RL
	H) Trigger Pull Test & Retainability						7-18-91	RL
	I) Firing Pin Indent	.0215	.0215	.0215			7-19-91	RL
	J) Assemble Stock						7/22/91	RW
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						7/22/91	RW
	M) Iron Sight Alignment						7/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	RW
	O) Attach Scope to Rifle						7/22/91	RW
	P) Detach & Attach Scope 20 Times						7/22/91	RW
640	Gallery Target & Test						8-2-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-2-91	NF
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.47	2.43	2.46	2.47	2.53	8-5-91	RL
	C) Function						8-6-91	AC
660	Pack						9-19-91	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-6636218

DATE 7-18-91

TESTER 81.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.58	2.40	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.44	2.52	2.43	
PULL #3	2.55	2.45	2.43	2.46	
PULL #4	2.43	2.42	2.40	2.47	
PULL #5	2.60	2.42	2.40	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.43		
PULL #2	3.36	3.40		
PULL #3	3.39	3.40		
PULL #4	3.43	3.41		
PULL #5	3.36	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	4.51	4.20		4.22
PULL #2	4.54	4.24		4.28
PULL #3	4.42	4.29		4.33
PULL #4	4.42	4.24		4.15
PULL #5	4.56	4.19		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636218
2 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.35412
1 TO	2	.624395
1 TO	3	.363
1 TO	4	.209619
1 TO	5	.559323

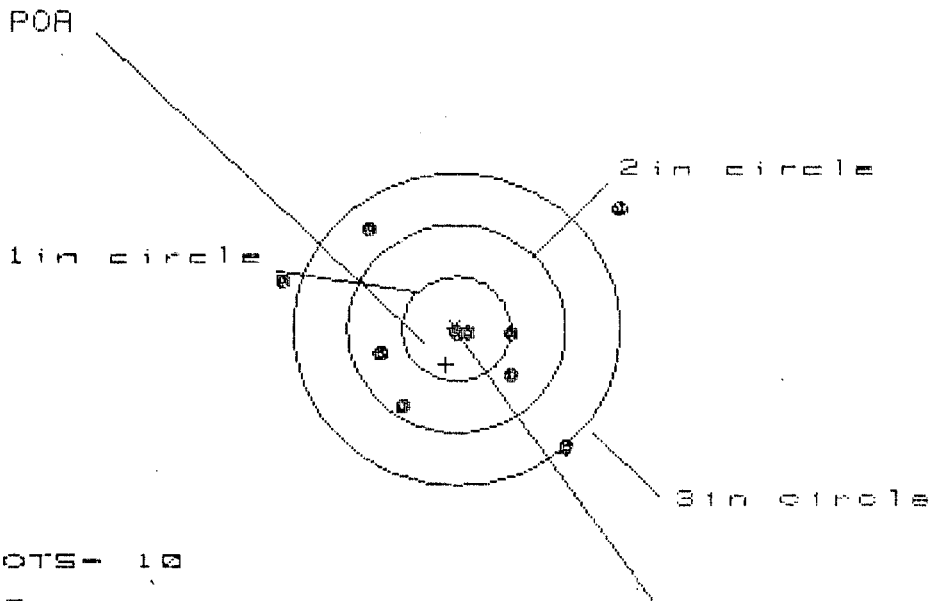
2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .205
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .209226
THE AMP FOR THIS RIFLE IS: .7826

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636218

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS= 3.121

VS= 2.288

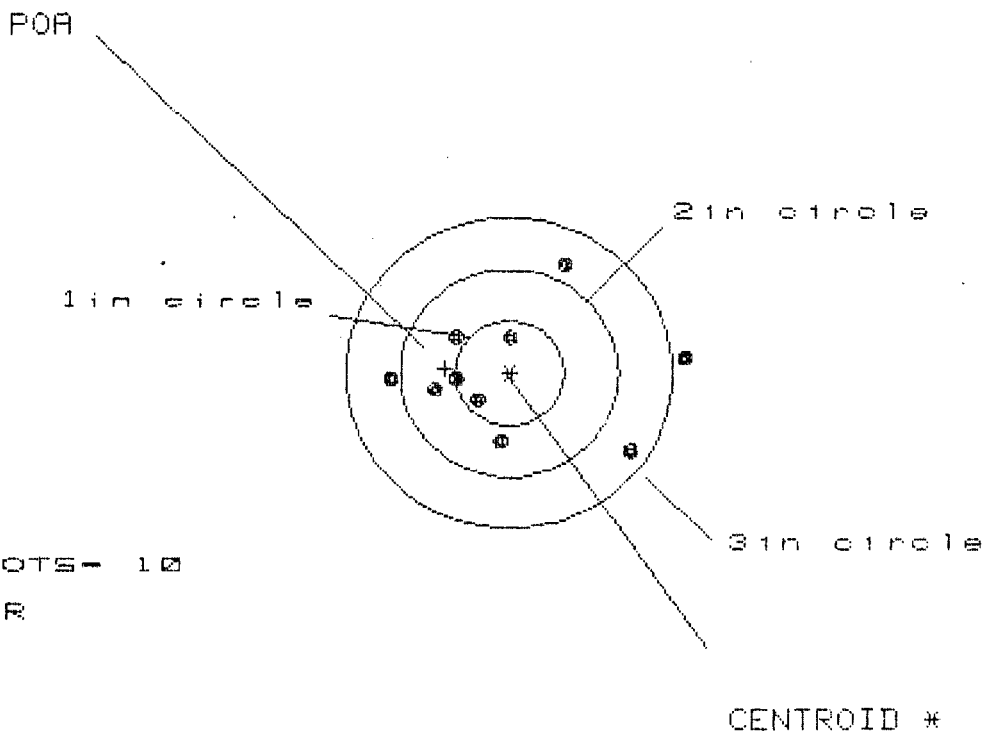
GS= 3.184

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.536	1.151	.974
MINIMUM X	-1.585	-1.414	-.820
MAXIMUM Y	1.139	1.079	1.158
MINIMUM Y	-1.141	-1.014	-.935
CENTROID X	.099	-.072	.105
CENTROID Y	.340	.213	.134
POA TO CENTROID in.	.354	.225	.170
MIN RADIUS	.044	.172	.198
MEAN RADIUS	.926	.826	.710
MAX RADIUS	1.912	1.550	1.419
HORIZONTAL SPREAD	3.121	2.565	1.794
VERTICAL SPREAD	2.288	2.093	2.093
EXTREME SPREAD	3.184	3.049	2.757
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

2 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.717

VS = 1.825

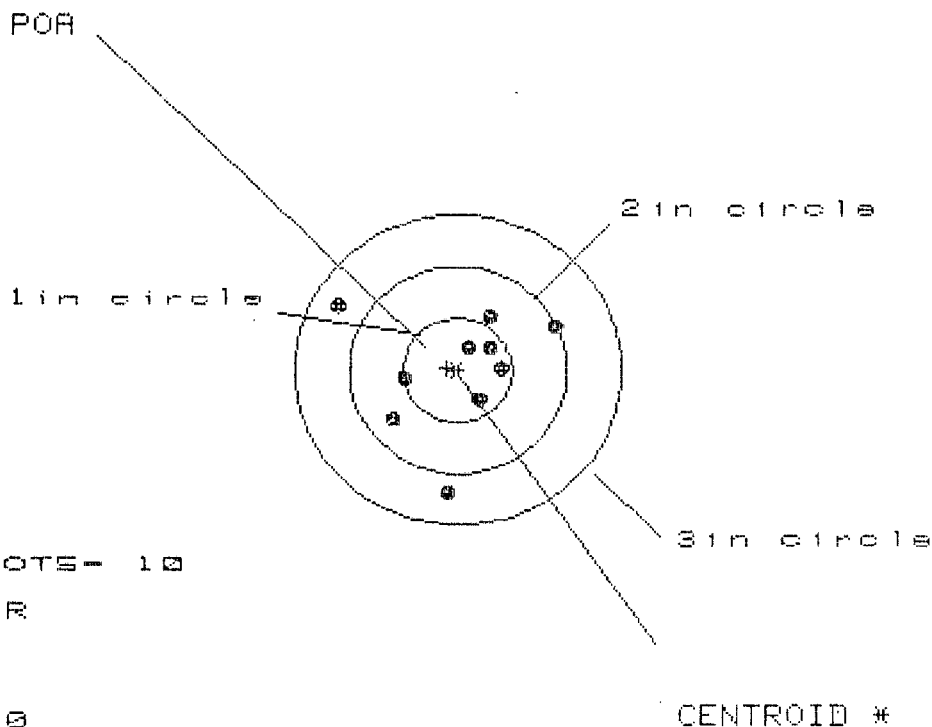
GS = 2.721

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.307	.858
MINIMUM X	:	-1.108	-.929	-.766
MAXIMUM Y	:	1.081	1.094	1.003
MINIMUM Y	:	-.744	-.731	-.748
CENTROID X	:	.589	.410	.247
CENTROID Y	:	-.047	-.060	.031
POA TO CENTROID in.	:	.591	.415	.249
MIN RADIUS	:	.341	.274	.178
MEAN RADIUS	:	.850	.706	.564
MAX RADIUS	:	1.614	1.497	1.320
HORIZONTAL SPREAD	:	2.717	2.236	1.624
VERTICAL SPREAD	:	1.825	1.825	1.751
EXTREME SPREAD	:	2.721	2.351	1.961
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.011

VS= 1.803

GS= 2.047

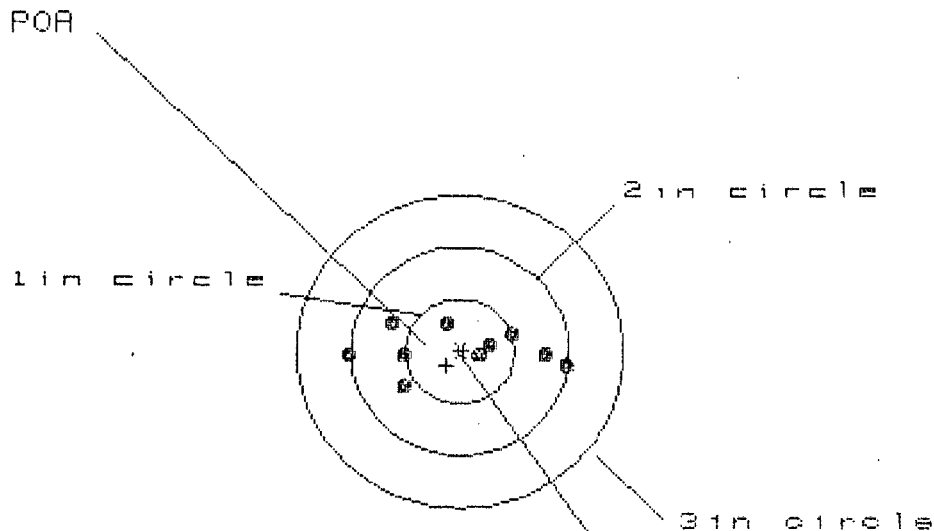
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.948	.938	.803
MINIMUM X	:	-1.063	-1.073	-.781
MAXIMUM Y	:	.585	.450	.454
MINIMUM Y	:	-1.218	-.593	-.537
CENTROID X	:	.099	.109	.244
CENTROID Y	:	-.023	.112	.056
POA TO CENTROID in.	:	.102	.157	.250
MIN RADIUS	:	.277	.156	.171
MEAN RADIUS	:	.677	.599	.496
MAX RADIUS	:	1.221	1.164	.947
HORIZONTAL SPREAD	:	2.011	2.011	1.584
VERTICAL SPREAD	:	1.803	1.043	.991
EXTREME SPREAD	:	2.047	2.016	1.819
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.028

VS= .559

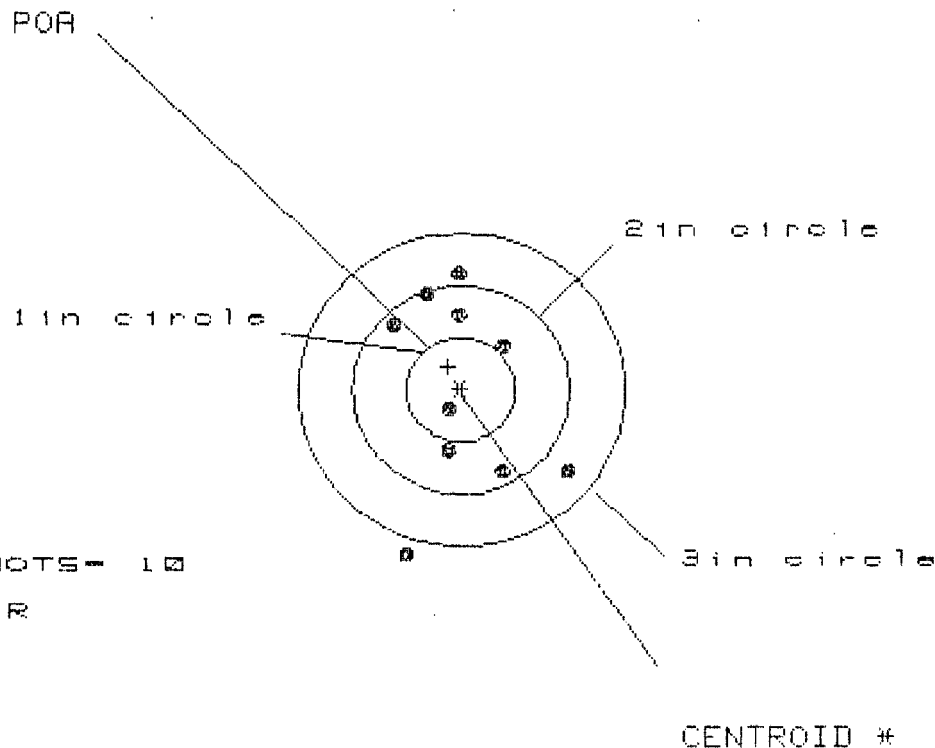
GS= 2.034

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.011	.891	.778
MINIMUM X	:	-1.017	-.904	-.609
MAXIMUM Y	:	.225	.207	.205
MINIMUM Y	:	-.334	-.352	-.354
CENTROID X	:	.125	.012	.125
CENTROID Y	:	.132	.150	.152
POA TO CENTROID in.	:	.182	.151	.197
MIN RADIUS	:	.226	.207	.230
MEAN RADIUS	:	.579	.528	.467
MAX RADIUS	:	1.024	.905	.778
HORIZONTAL SPREAD	:	2.028	1.795	1.387
VERTICAL SPREAD	:	.559	.559	.559
EXTREME SPREAD	:	2.034	1.795	1.404
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.676

VS= 2.739

GS= 2.801

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10 / 9 8
MAXIMUM X	1.016 .955 .467
MINIMUM X	-.660 -.721 -.602
MAXIMUM Y	1.160 .985 .868
MINIMUM Y	-1.579 -.938 -1.045
CENTROID X	.118 .179 .060
CENTROID Y	-.219 -.044 .073
POA TO CENTROID in.	.249 .184 .095
MIN RADIUS	.166 .349 .377
MEAN RADIUS	.881 .780 .689
MAX RADIUS	1.673 1.339 1.145
HORIZONTAL SPREAD	1.676 1.676 1.069
VERTICAL SPREAD	2.739 1.923 1.913
EXTREME SPREAD	2.801 2.189 1.950
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9