

FORM

UPC



C6636236

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24
ORDER NO. 5716

Remington

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

MODEL 700™ M24**SERIAL NO.**

C6636236

ORDER NO.**5716**

20

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



5716 C6636236

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636236**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KH
600	Proof		6/27/91	KH
607	Check Headspace		6/27/91	KH
610	Dis-assemble Gun		6/27/91	KH
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		8-10-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/91	KH
	C) Inspect Ejector Hole for Chamfer		10/30/91	KH
	D) Oil Firing Pin Ass'y		10/30/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/91	HA

op. #	OP. NAME	BARBER - M24 0032056					READINGS	DATE	INIT
625 cont.	F) Safety On Force		5		5		5	10/31/91	JK
	G) Safety Off Force		3		3		3	10/31/91	JK
	H) Trigger Pull Test & Retainability							10/31/91	JK
	I) Firing Pin Indent		1021		10205		10205	10/31/91	JK
	J) Assemble Stock							10/31/91	JK
	K) Assemble Swivel Studs							11-12-91	AC
	L) Attach Front and Rear Sight Assemblies							10/31/91	JK
	M) Iron Sight Alignment							10/31/91	JK
	N) Detach Front & Rear Sights & place in numbered container							10/31/91	JK
	O) Attach Scope to Rifle							10/31/91	JK
	P) Detach & Attach Scope 20 Times							10/31/91	JK
640	Gallery Target & Test							11-1-91	DH
	A) Time							11-1-91	DH
	B) Malfunctions							11-1-91	DH
	C) Pierced Primers							11-1-91	DH
	D) Optical Clarity of Scope							11-1-91	DH
645	Inspect for Live Ammo							11-1-91	DH
655	Final Inspection								
	A) Headspace							11-12-91	AC
	B) Trigger Pull		232	221	219	220	217	11-5-91	DH
	C) Function							11-12-91	AC
660	Pack							12-20-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636236DATE 10/31/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.34	2.36	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.33	2.23	2.21	
PULL #3	2.35	2.38	2.33	2.19	
PULL #4	2.33	2.32	2.36	2.20	
PULL #5	2.34	2.29	2.30	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.14		
PULL #2	3.20	3.36		
PULL #3	3.46	3.35		
PULL #4	3.38	3.26		
PULL #5	3.38	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.58		4.16
PULL #2	4.47	4.57		4.44
PULL #3	4.56	4.45		4.23
PULL #4	4.59	4.53		4.39
PULL #5	4.43	4.29		4.24
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636236
1 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.53188
1 TO	2	.468471
1 TO	3	1.17913
1 TO	4	.508932
1 TO	5	.635442

1
12 4 ←---POA
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4434
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.9254
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .444127
THE AMR FOR THIS RIFLE IS: .9994

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636236

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.503

VS= 1.785

GS= 2.721

CENTROID +

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.407	.823	.734
MINIMUM X	-1.096	-.940	-1.029
MAXIMUM Y	.875	.806	.796
MINIMUM Y	-.910	-.979	-.878
CENTROID X	.260	.104	.193
CENTROID Y	.464	.533	.432
POR TO CENTROID in.	.532	.543	.473
MIN RADIUS	.111	.147	.039
MEAN RADIUS	.769	.677	.603
MAX RADIUS	1.537	1.075	1.036
HORIZONTAL SPREAD	2.503	1.763	1.768
VERTICAL SPREAD	1.785	1.785	1.674
EXTREME SPREAD	2.721	1.928	1.928
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06090236

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 8

HS = 2.278

VS = 2.814

GS = 3.007

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.985

1.088

1.083

MINIMUM X

-1.293

-1.190

-1.195

MAXIMUM Y

1.537

1.396

.890

MINIMUM Y

-1.277

-1.127

-.953

CENTROID X

.239

.136

.141

CENTROID Y

-.004

.137

-.037

POA TO CENTROID in.

.239

.194

.146

MIN RADIUS

.592

.643

.502

MEAN RADIUS

1.131

1.070

1.016

MAX RADIUS

1.574

1.566

1.443

HORIZONTAL SPREAD

2.278

2.278

2.278

VERTICAL SPREAD

2.814

2.523

1.843

EXTREME SPREAD

3.007

2.825

2.825

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

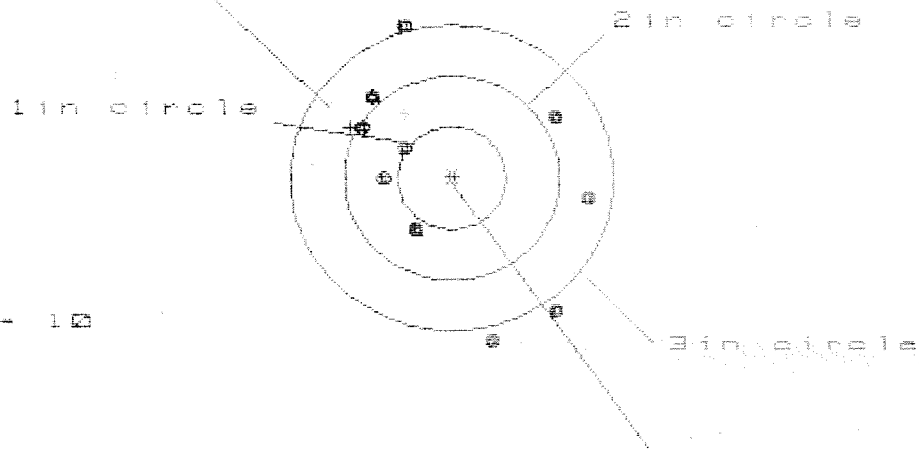
8

1 May 1991

FILE: \PATTERNING\CENTERFIRE_PATT\0863B238

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 2.054

VS = 3.042

GS = 3.140

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.255	1.291	1.415
MINIMUM X	:	-1.809	-1.773	-1.649
MAXIMUM Y	:	1.458	1.282	1.100
MINIMUM Y	:	-1.584	-1.455	-1.862
CENTROID X	:	.939	.903	.779
CENTROID Y	:	-.500	-.324	-.142
POA TO CENTROID in.	:	1.064	.960	.792
MIN RADIUS	:	.543	.428	.282
MEAN RADIUS	:	1.096	1.013	.872
MAX RADIUS	:	1.617	1.761	1.539
HORIZONTAL SPREAD	:	2.064	2.064	2.064
VERTICAL SPREAD	:	3.042	2.737	1.962
EXTREME SPREAD	:	3.140	3.079	2.415
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

1 Nov 1991

FILE://PATTERNING/CENTERFIRE_PATT/C883B236

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 10

HS = 1.851

VS = 2.187

GS = 2.533

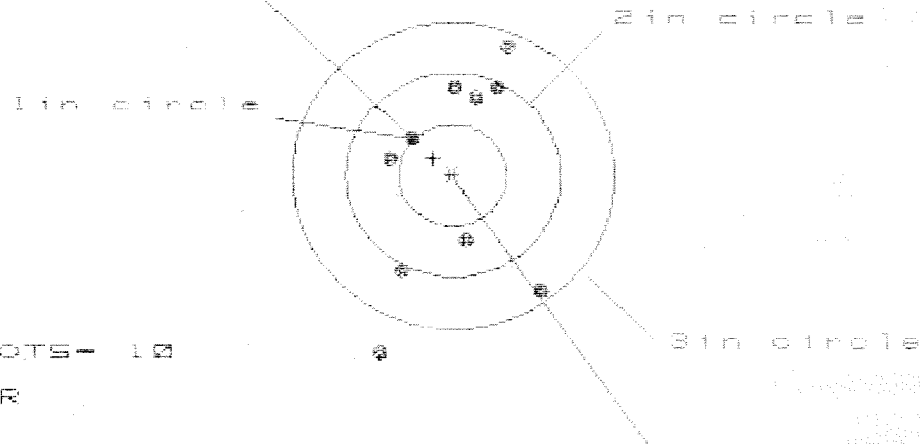
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.816	.722	.792
MINIMUM X	:	-1.035	-1.129	-1.059
MAXIMUM Y	:	1.032	.916	.757
MINIMUM Y	:	-1.155	-1.271	-1.226
CENTROID X	:	.594	.688	.619
CENTROID Y	:	.080	.196	.355
POA TO CENTROID in.	:	.599	.715	.713
MIN RADIUS	:	.225	.239	.412
MEAN RADIUS	:	.999	.955	.985
MAX RADIUS	:	1.343	1.388	1.238
HORIZONTAL SPREAD	:	1.851	1.851	1.851
VERTICAL SPREAD	:	2.187	2.187	1.983
EXTREME SPREAD	:	2.533	2.530	2.102
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636236

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 1.493

VS= 2.956

GS= 3.208

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.807
MINIMUM X	-.686
MAXIMUM Y	1.267
MINIMUM Y	-1.689
CENTROID X	.185
CENTROID Y	-.167
POA TO CENTROID in.	.249
MIN RADIUS	.538
MEAN RADIUS	1.002
MAX RADIUS	1.923
HORIZONTAL SPREAD	1.493
VERTICAL SPREAD	2.956
EXTREME SPREAD	3.208
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9