

06636253

MODEL 700TH M24

Model **SMS** TH

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

DU PONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6636253

ORDER NO.
5716

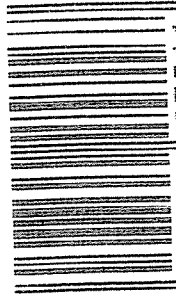
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MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee



5716 C6636253

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636253**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KE
600	Proof		6/24/91	KE
607	Check Headspace		6/24/91	KE
610	Dis-assemble Gun		6/24/91	KE
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	SS
617	Drill and Tap Sight Holes	JUL	1 1991	KB
618	Polish Barrel	JUL	2 1991	KB
620	Apply Coatings (Barrel Action)		7-23-91	KS
	Apply Coating (Bolt)			KS
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-31-91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	7	7			7-31-91	DH
	G) Safety Off Force	4	4	4			7-31-91	DH
	H) Trigger Pull Test & Retainability						7/31/91	SH
	I) Firing Pin Indent	.022	.021	.027			7-31-91	DH
	J) Assemble Stock						7/31/91	K8
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/31/91	KL
	M) Iron Sight Alignment						7/31/91	TS
	N) Detach Front & Rear Sights & place in numbered container						7/31/91	TS
	O) Attach Scope to Rifle						7/31/91	TS
	P) Detach & Attach Scope 20 Times						7/31/91	TS
640	Gallery Target & Test						8-1-91	DH
	A) Time						8-1-91	DH
	B) Malfunctions						8-1-91	DH
	C) Pierced Primers						8-1-91	DH
	D) Optical Clarity of Scope						8-1-91	DH
645	Inspect for Live Ammo						8-1-91	DH
655	Final Inspection							
	A) Headspace						8-5-91	AE
	B) Trigger Pull	2.45	2.20	2.55	2.48	2.50	8-5-91	SH
	C) Function						8-5-91	AE
660	Pack						9-11-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636253

DATE 7-31-91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.56	2.52	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.36	2.55	2.20	
PULL #3	2.43	2.56	2.49	2.55	
PULL #4	2.56	2.51	2.55	2.48	
PULL #5	2.41	2.56	2.55	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.54		
PULL #2	3.49	3.60		
PULL #3	3.49	3.56		
PULL #4	3.49	3.62		
PULL #5	3.48	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.27		4.37
PULL #2	4.19	4.34		4.41
PULL #3	4.29	4.34		4.37
PULL #4	4.35	4.35		4.31
PULL #5	4.23	4.32		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636253
1 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.123329
1 TO 2	.370871
1 TO 3	.663871
1 TO 4	.528573
1 TO 5	.0349857

3
2 <----POB
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0924
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155122
THE AMR FOR THIS RIFLE IS: .9108

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB836253

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.930

VS= 1.942

GS= 2.932

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.240	1.052	.733
MINIMUM X	-1.690	-1.314	-1.182
MAXIMUM Y	.866	.866	.880
MINIMUM Y	-1.076	-1.076	-1.062
CENTROID X	-.039	.149	.017
CENTROID Y	.117	.117	.103
POA TO CENTROID in.	.123	.189	.104
MIN RADIUS	.227	.152	.200
MEAN RADIUS	.953	.846	.822
MAX RADIUS	1.690	1.314	1.182
HORIZONTAL SPREAD	2.930	2.366	1.915
VERTICAL SPREAD	1.942	1.942	1.942
EXTREME SPREAD	2.932	2.371	2.242
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6836253

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 9

HS = 2.588

VS = 2.760

GS = 2.760

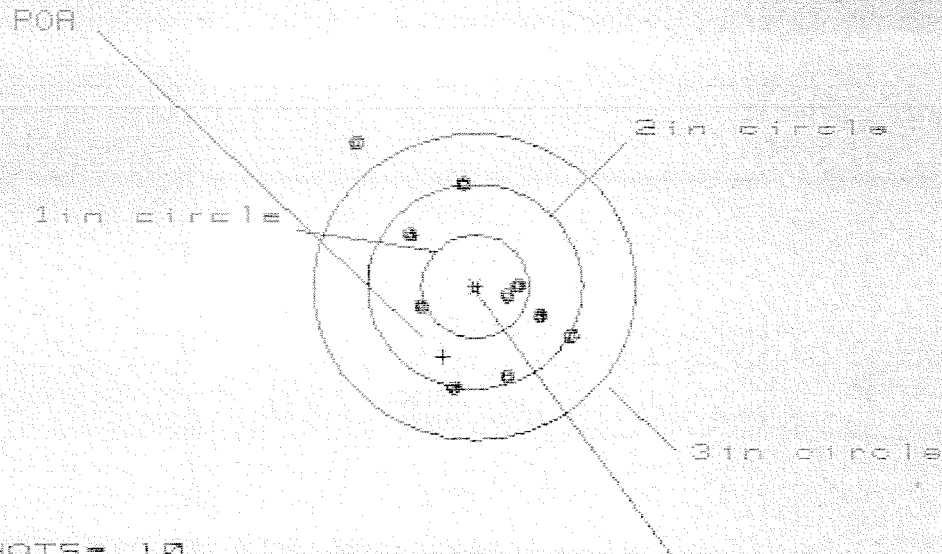
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.101
MINIMUM X	-1.487
MAXIMUM Y	1.384
MINIMUM Y	-1.376
CENTROID X	.297
CENTROID Y	-.040
POA TO CENTROID in.	.300
MIN RADIUS	.510
MEAN RADIUS	.974
MAX RADIUS	1.534
HORIZONTAL SPREAD	2.588
VERTICAL SPREAD	2.760
EXTREME SPREAD	2.760
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6636253

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 2.079

VS = 2.398

GS = 2.868

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.944	.818	.622
MINIMUM X	-1.135	-.691	-.589
MAXIMUM Y	1.451	1.135	1.090
MINIMUM Y	-.947	-.786	-.831
CENTROID X	.303	.429	.327
CENTROID Y	.686	.525	.570
POA TO CENTROID in.	.750	.678	.657
MIN RADIUS	.278	.135	.229
MEAN RADIUS	.854	.699	.686
MAX RADIUS	1.842	1.164	1.101
HORIZONTAL SPREAD	2.079	1.509	1.211
VERTICAL SPREAD	2.398	1.921	1.921
EXTREME SPREAD	2.868	1.923	1.923
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB636253

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 3.021

VS= 2.166

GS= 3.231

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

5

8

MAXIMUM X

1.267

1.072

.921

MINIMUM X

-1.754

-.984

-.050

MAXIMUM Y

1.215

1.237

1.121

MINIMUM Y

-.951

-.929

-.971

CENTROID X

.071

.266

.132

CENTROID Y

-.400

-.422

-.306

POA TO CENTROID in.

.407

.499

.333

MIN RADIUS

.068

.254

.122

MEAN RADIUS

.883

.813

.700

MAX RADIUS

1.765

1.581

1.407

HORIZONTAL SPREAD

3.021

2.056

1.771

VERTICAL SPREAD

2.166

2.166

2.092

EXTREME SPREAD

3.231

2.986

2.711

NUMBER IN ONE

INCH CIRCLE

=

4

NUMBER IN TWO

INCH CIRCLE

=

5

NUMBER IN THREE

INCH CIRCLE

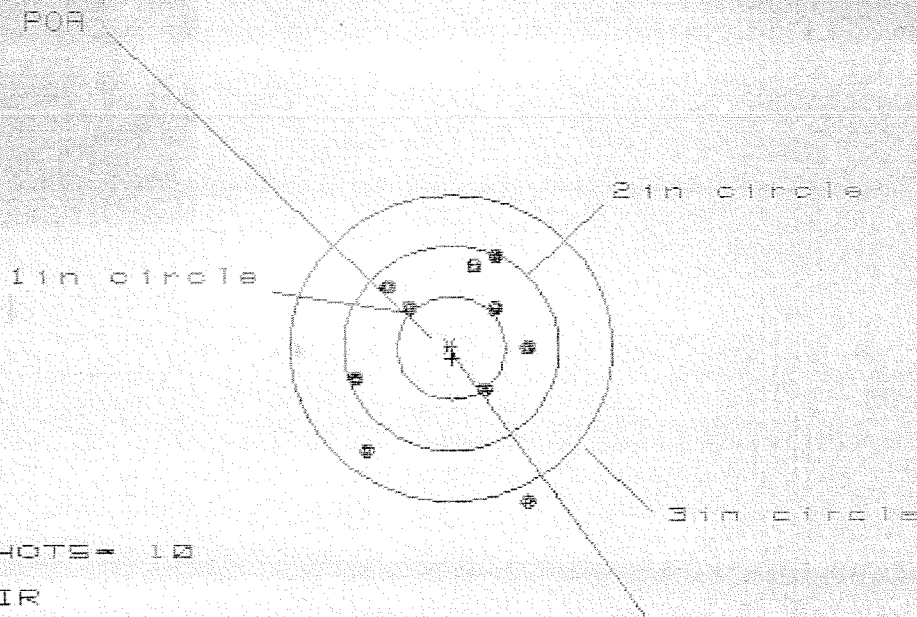
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1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB836253

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 9

HS = 1.557

VS = 2.476

GS = 2.521

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.685
MINIMUM X	-.872
MAXIMUM Y	.949
MINIMUM Y	-1.527
CENTROID X	-.009
CENTROID Y	.099
POA TO CENTROID in.	.099
MIN RADIUS	.514
MEAN RADIUS	.890
MAX RADIUS	1.674
HORIZONTAL SPREAD	1.557
VERTICAL SPREAD	2.476
EXTREME SPREAD	2.521
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	9