

C6636267

MODEL 700TM M24

Model **SMS** TM

Action

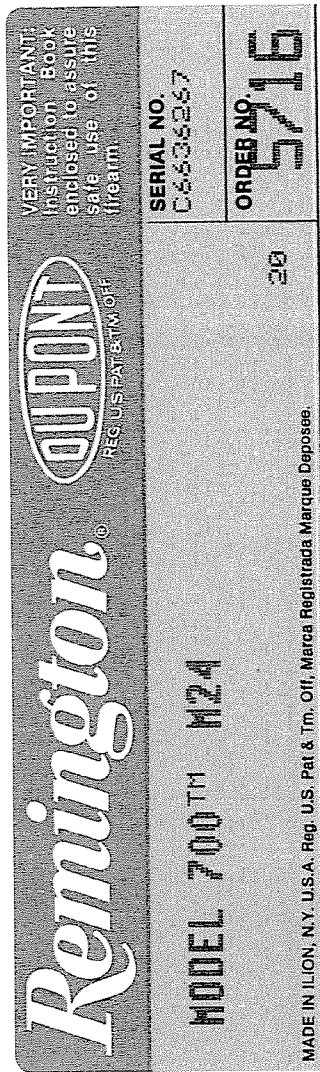
Barrel Length

Capacity

Order No. **5716**

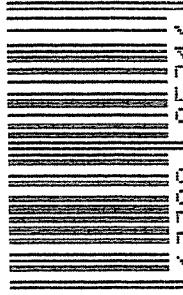
*Includes 1 in chamber.

Remington



5716 C6636267

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636267

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
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	KB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	KB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/91	KL
	C) Inspect Ejector Hole for Chamfer		8/13/91	KL
	D) Oil Firing Pin Ass'y		8/13/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/14/91	WB

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-14-91	DH
	G) Safety Off Force	2	2	2			8-14-91	DH
	H) Trigger Pull Test & Retainability						8-14-91	WB
	I) Firing Pin Indent	.023	.022	.021			8-14-91	DH
	J) Assemble Stock						8-15-91	KA
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8-15-91	KA
	M) Iron Sight Alignment						8-15-91	KA
	N) Detach Front & Rear Sights & place in numbered container						8-15-91	KA
	O) Attach Scope to Rifle						8-15-91	KA
	P) Detach & Attach Scope 20 Times						8-15-91	KA
640	Gallery Target & Test						8-15-91	KT
	A) Time						-1	KS
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8-15-91	KT
655	Final Inspection							
	A) Headspace						8-17-91	DH
	B) Trigger Pull	220	221	221	221	230	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-19-91	VF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636267
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0427551
1 TO	2	.0626498
1 TO	3	.538057
1 TO	4	.16985
1 TO	5	.0636946

POA <-----

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1142
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0262
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117167
THE AMR FOR THIS RIFLE IS: 1.023

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636267

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 1.659

VS= 3.031

GS= 3.116

CENTROID *

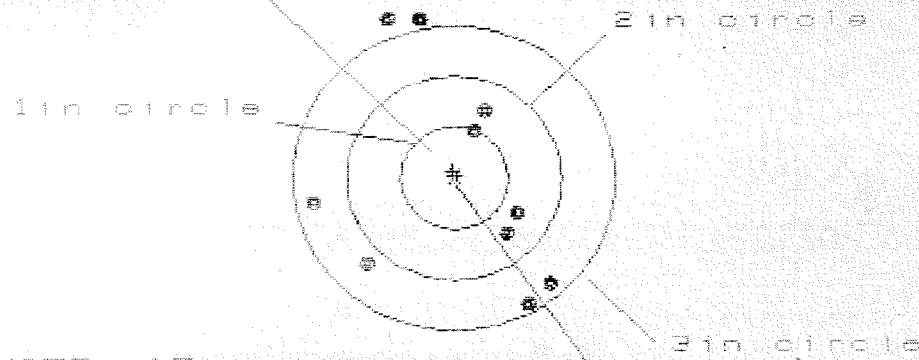
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.991	1.063	.475
MINIMUM X	-.668	-.596	-.464
MAXIMUM Y	1.426	1.248	1.068
MINIMUM Y	-1.605	-1.436	-1.058
CENTROID X	.042	-.030	-.162
CENTROID Y	-.008	.170	.350
POR TO CENTROID in.	.043	.173	.386
MIN RADIUS	.364	.217	.023
MEAN RADIUS	.967	.854	.703
MAX RADIUS	1.730	1.787	1.088
HORIZONTAL SPREAD	1.659	1.659	.939
VERTICAL SPREAD	3.031	2.684	2.126
EXTREME SPREAD	3.116	2.888	2.160
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636267

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.224

VS = 2.808

GS = 3.107

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.888

.819

.773

MINIMUM X

-1.336

-1.405

-1.451

MAXIMUM Y

1.602

1.705

1.020

MINIMUM Y

-1.206

-1.028

-.814

CENTROID X

.016

.085

.131

CENTROID Y

-.065

-.243

-.457

POA TO CENTROID in.

.067

.258

.475

MIN RADIUS

.473

.545

.420

MEAN RADIUS

1.116

1.028

.912

MAX RADIUS

1.719

1.745

1.462

HORIZONTAL SPREAD

2.224

2.224

2.224

VERTICAL SPREAD

2.808

2.733

1.834

EXTREME SPREAD

3.107

2.913

2.368

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

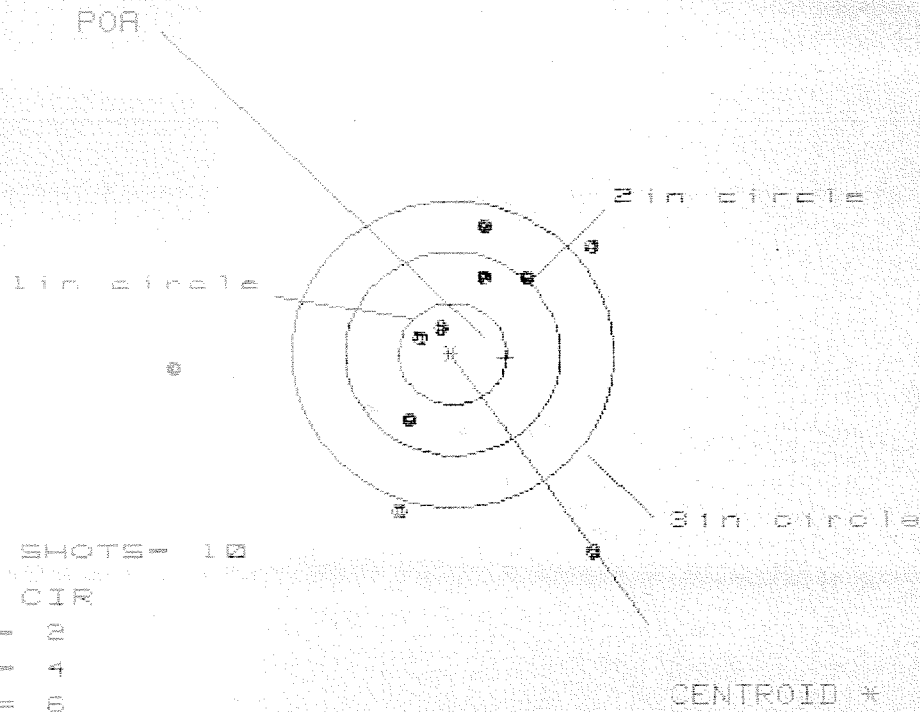
NUMBER IN THREE INCH CIRCLE =

8

23 Aug 1937

FILE:/PATTERNING/CENTERFIRE_PATT/C6636257

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 3.946

VS= 3.202

GS= 4.322

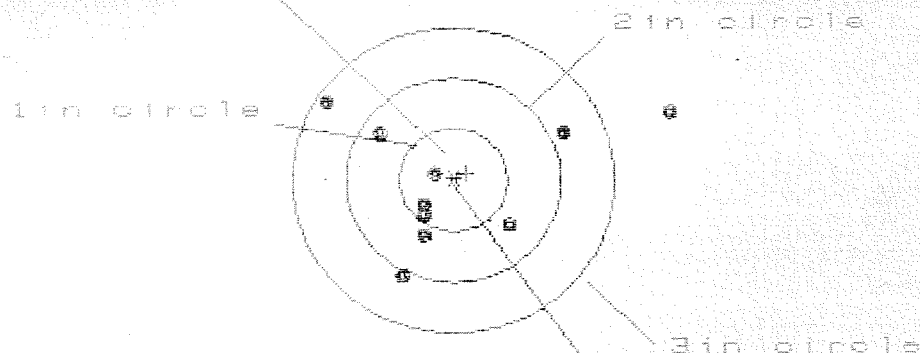
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.326	1.035	1.123
MINIMUM X	-2.620	-1.803	-1.673
MAXIMUM Y	1.279	1.261	1.019
MINIMUM Y	-1.923	-1.941	-1.795
CENTROID X	-.494	-.203	-.333
CENTROID Y	.039	.057	.299
POA TO CENTROID in.	.496	.211	.447
MIN RADIUS	.276	.492	.317
MEAN RADIUS	1.284	1.148	.936
MAX RADIUS	2.624	2.199	1.917
HORIZONTAL SPREAD	3.946	1.838	1.796
VERTICAL SPREAD	3.202	3.202	2.814
EXTREME SPREAD	4.322	3.373	3.163
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36267

CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 3.242

VS= 1.777

GS= 3.247

CENTROID *

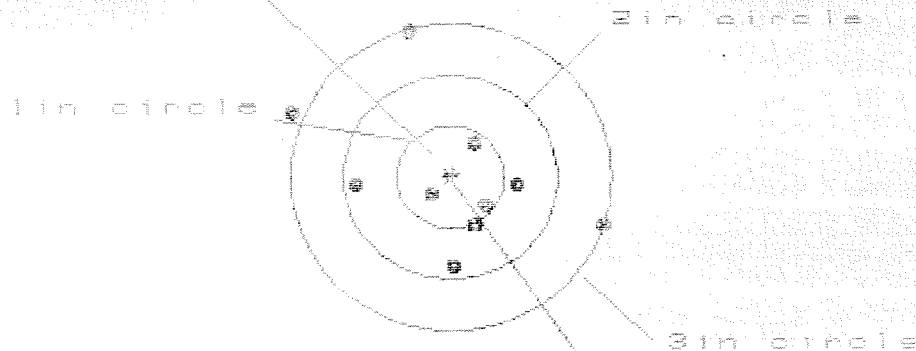
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.017	1.202	1.076
MINIMUM X	-1.226	-1.001	-0.622
MAXIMUM Y	.800	.869	.688
MINIMUM Y	-.977	-.908	-1.000
CENTROID X	-.118	-.342	-.216
CENTROID Y	-.065	-.134	-.242
POA TO CENTROID in.	.134	.367	.325
MIN RADIUS	.219	.107	.201
MEAN RADIUS	.892	.684	.604
MAX RADIUS	2.109	1.334	1.278
HORIZONTAL SPREAD	3.242	2.203	1.698
VERTICAL SPREAD	1.777	1.777	1.488
EXTREME SPREAD	3.247	2.222	2.097
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636267

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

CENTROID #

HS= 2.858

VS= 2.355

CS= 3.073

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.400

1.238

.613

MINIMUM X

-1.453

-1.018

-.863

MAXIMUM Y

1.442

1.513

1.460

MINIMUM Y

-.913

-.842

-.825

CENTROID X

-.017

.145

-.010

CENTROID Y

-.032

-.103

-.050

POA TO CENTROID in.

.036

.177

.051

MIN RADIUS

.216

.274

.213

MEAN RADIUS

.658

.745

.684

MAX RADIUS

1.590

1.594

1.500

HORIZONTAL SPREAD

2.858

2.256

1.475

VERTICAL SPREAD

2.355

2.355

2.355

EXTREME SPREAD

3.073

2.603

2.378

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

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

SERIAL NO. C-6636267DATE 8-14-91TESTER JU WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.21	2.33	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.20	2.30	2.21	
PULL #3	2.20	2.15	2.19	2.21	
PULL #4	2.20	2.15	2.24	2.30	
PULL #5	2.19	2.30	2.27	2.21	
TOTAL	11.10	11.01	11.33		
AVG.	2.22	2.20	2.27		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.12		
PULL #2	3.44	3.06		
PULL #3	3.43	3.02		
PULL #4	3.15	3.00		
PULL #5	3.00	3.03		
TOTAL	15.56	15.23		
AVG.	3.11	3.05		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.21		4.09
PULL #2	4.13	4.23		4.42
PULL #3	3.85	4.13		4.39
PULL #4	4.08	4.11		4.17
PULL #5	4.17	4.15		4.31
TOTAL	20.46	20.83		21.38
AVG.	4.09	4.17		4.28