

C6636285

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]

MODEL 700TM M24

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

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

SERIAL NO.
C6636285

ORDER NO.
5716

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

0.5

5716 C6636285

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636285

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	5 8 0 1		KCH
	Magnaflux Bolt	5 8 9 1		KCH
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	AS
	Apply Coating (Bolt)			AS
625	Final Assembly A) Clean inside of Bolt Assembly		4/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	KS
	C) Inspect Ejector Hole for Chamfer		4/4/91	KS
	D) Oil Firing Pin Ass'y		4/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	JS

op. #	BARBER - M24 0032615	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-11-91	SH
	G) Safety Off Force	3	3	3			6-11-91	SH
	H) Trigger Pull Test & Retainability						6-11-91	SH
	I) Firing Pin Indent	1022	1022.5	1022.5			6-11-91	SH
	J) Assemble Stock						6/11/91	KS
	K) Assemble Swivel Studs						6-14-91	
	L) Attach Front and Rear Sight Assemblies						6/11/91	KS
	M) Iron Sight Alignment						6/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/11/91	KS
	O) Attach Scope to Rifle						6/11/91	KS
	P) Detach & Attach Scope 20 Times						6/11/91	KS
640	Gallery Target & Test						6-11-91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						6/13/91	KT
655	Final Inspection							
	A) Headspace						6-14-91	
	B) Trigger Pull	2.29	2.31	2.38	2.38	2.44	6-14-91	SH
	C) Function						6-14-91	SH
660	Pack						6-20-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636285

DATE 6-11-91

TESTER JCL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.23	2.35	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.28	2.38	2.31	
PULL #3	2.66	2.32	2.30	2.38	
PULL #4	2.68	2.31	2.36	2.38	
PULL #5	2.58	2.31	2.36	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.27		
PULL #2	3.34	3.25		
PULL #3	3.39	3.22		
PULL #4	3.37	3.23		
PULL #5	3.31	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.65		4.14
PULL #2	4.36	4.64		4.53
PULL #3	4.36	4.67		4.70
PULL #4	4.18	4.65		4.68
PULL #5	4.64	4.63		4.66
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636285
13 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.291625
1 TO	2	.0990051
1 TO	3	.147628
1 TO	4	.163132
1 TO	5	.606427

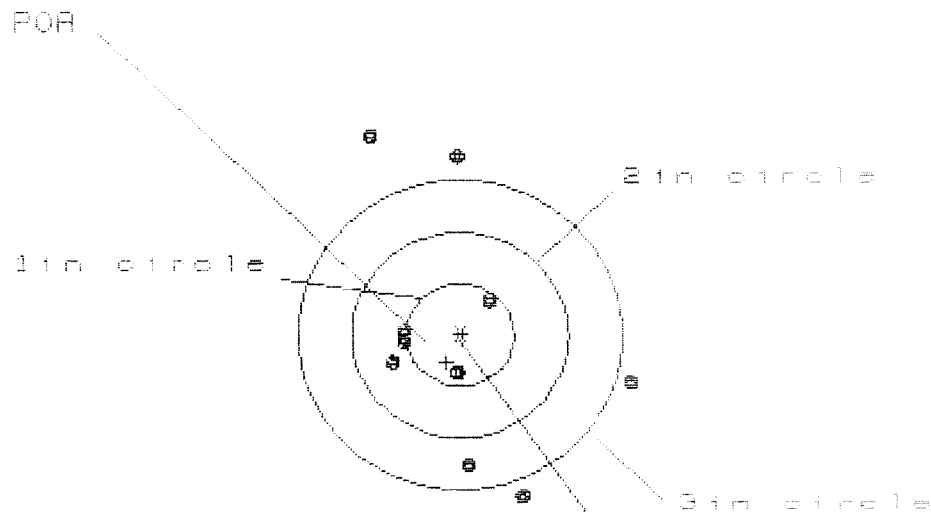
5' <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0114
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116957
THE AMR FOR THIS RIFLE IS: 1.052

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06836285

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

EM = 0.3997

VM = 0.546

GM = 0.813

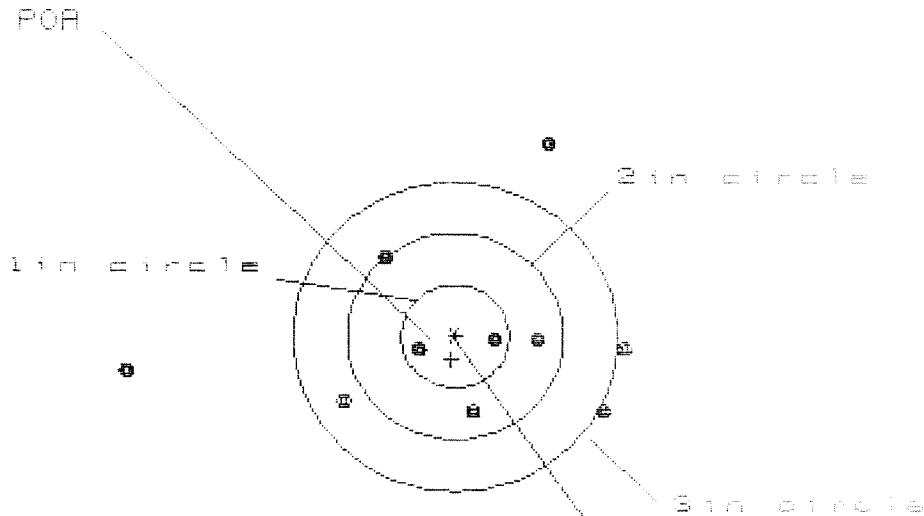
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.578	1.487	1.468
MINIMUM X	-0.819	-0.669	-0.688
MAXIMUM Y	1.979	1.922	1.837
MINIMUM Y	-1.567	-1.347	-1.187
CENTROID X	.126	.217	.236
CENTROID Y	.263	.043	-0.197
POA TO CENTROID in.	.292	.222	.308
MIN RADIUS	.399	.198	.121
MEAN RADIUS	1.107	.974	.845
MAX RADIUS	2.142	1.928	1.468
HORIZONTAL SPREAD	2.397	2.156	2.156
VERTICAL SPREAD	3.546	3.269	1.944
EXTREME SPREAD	3.813	3.332	2.178
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

13 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS= 4.543

VS= 2.610

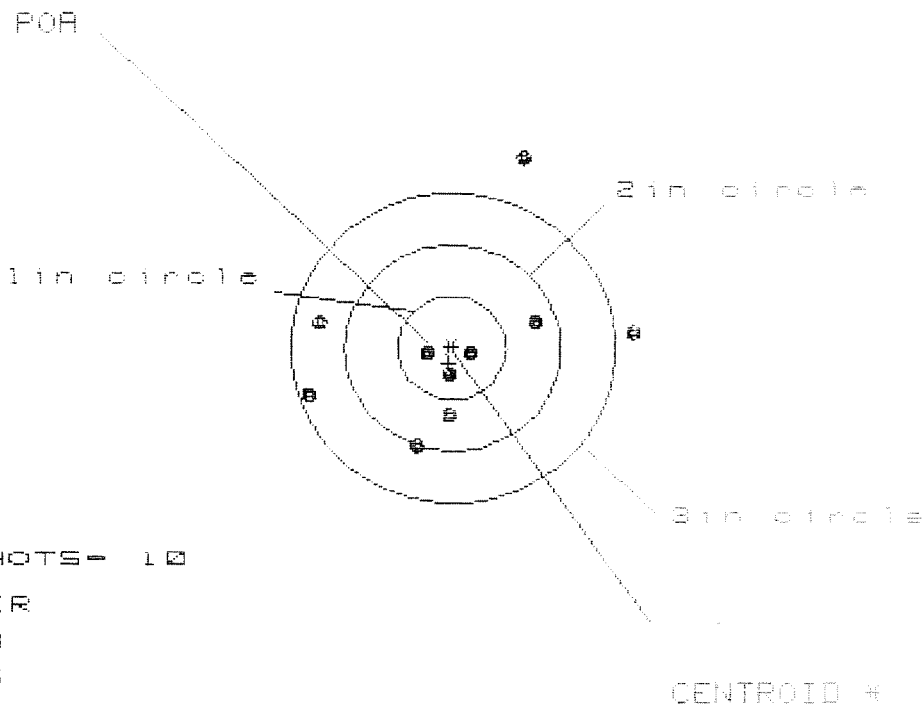
GS= 4.547

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.526	1.190	1.258
MINIMUM X	:	-3.017	-1.386	-1.318
MAXIMUM Y	:	1.867	1.832	.964
MINIMUM Y	:	-1.743	-1.778	-1.549
CENTROID X	:	.035	.371	.303
CENTROID Y	:	.224	.259	.030
POA TO CENTROID in.	:	.227	.452	.305
MIN RADIUS	:	.325	.099	.141
MEAN RADIUS	:	1.259	1.015	.879
MAX RADIUS	:	3.033	1.910	1.374
HORIZONTAL SPREAD	:	4.543	2.576	2.576
VERTICAL SPREAD	:	2.610	2.610	1.513
EXTREME SPREAD	:	4.547	3.114	2.616
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.961

VS= 2.803

GS= 3.067

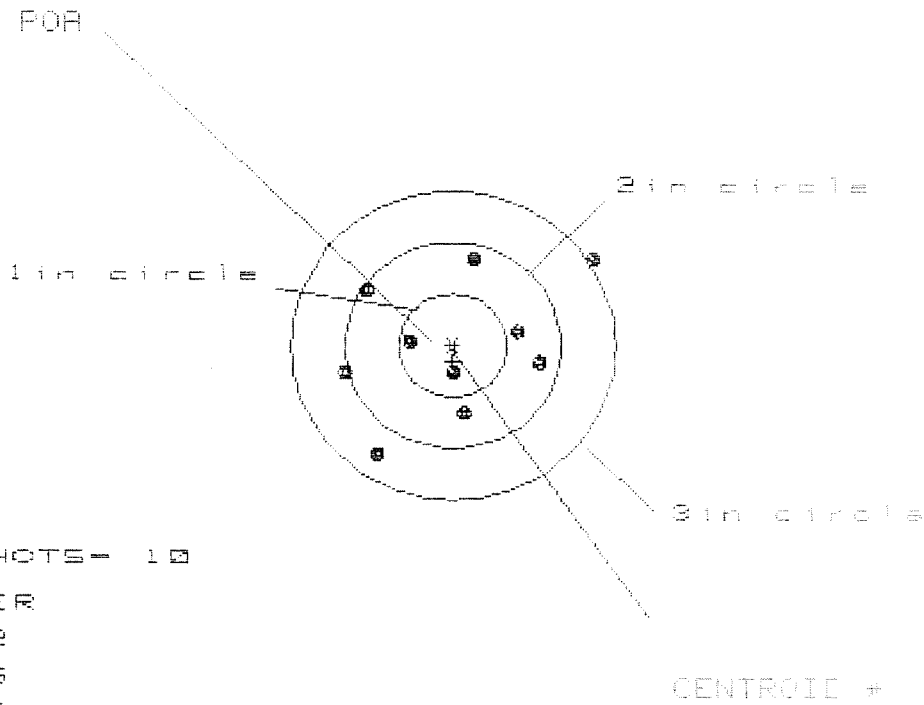
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.627	1.704	1.048
MINIMUM X	-1.334	-1.257	-1.043
MAXIMUM Y	1.879	.434	.478
MINIMUM Y	-.924	-.715	-.671
CENTROID X	.031	-.046	-.260
CENTROID Y	.150	-.059	-.103
POA TO CENTROID in.	.153	.075	.279
MIN RADIUS	.188	.108	.214
MEAN RADIUS	.947	.782	.681
MAX RADIUS	2.005	1.741	1.142
HORIZONTAL SPREAD	2.961	2.961	2.091
VERTICAL SPREAD	2.803	1.149	1.149
EXTREME SPREAD	3.067	3.015	2.181
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.269

VS= 1.864

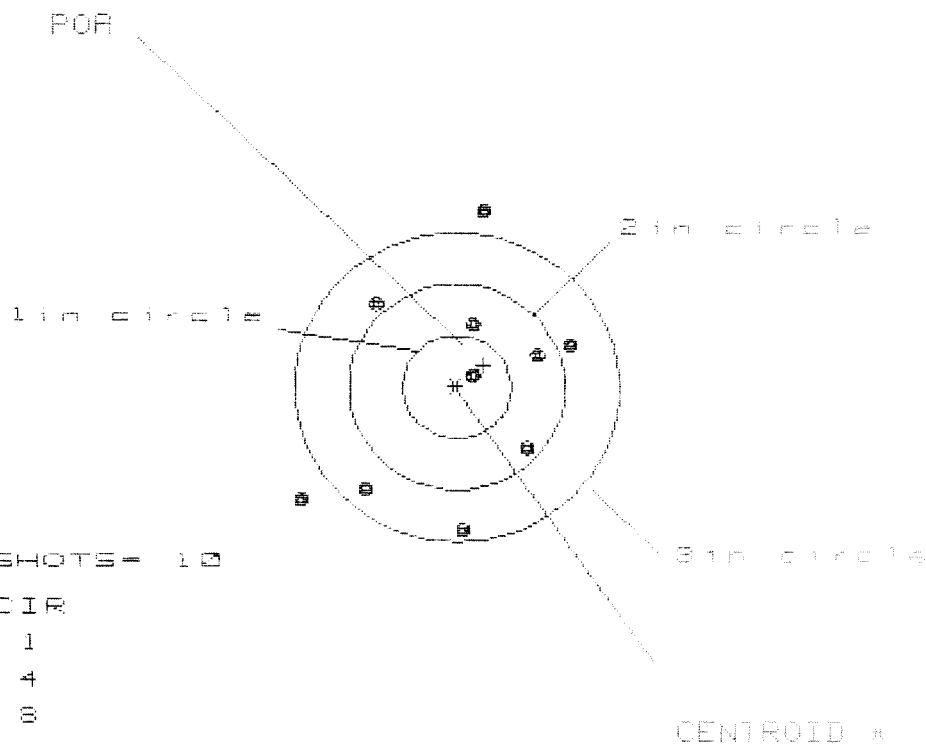
GS= 2.738

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	.987	.913
MINIMUM X	:	-.994	-.852	-.926
MAXIMUM Y	:	.826	.908	.796
MINIMUM Y	:	-1.038	-.946	-.729
CENTROID X	:	.002	-.140	-.066
CENTROID Y	:	.157	.065	.183
POA TO CENTROID in.	:	.157	.154	.195
MIN RADIUS	:	.306	.230	.322
MEAN RADIUS	:	.855	.762	.719
MAX RADIUS	:	1.519	1.114	.974
HORIZONTAL SPREAD	:	2.269	1.839	1.839
VERTICAL SPREAD	:	1.864	1.854	1.519
EXTREME SPREAD	:	2.738	2.056	1.844
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.418

VS = 3.067

GS = 3.312

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.006	1.850	1.865
MINIMUM X	-1.412	-1.029	-1.014
MAXIMUM Y	1.721	1.595	1.909
MINIMUM Y	-1.346	-1.472	-1.272
CENTROID X	-.251	-.095	-.110
CENTROID Y	-.212	-.086	-.266
POA TO CENTROID in.	.329	.128	.356
MIN RADIUS	.190	.011	.195
MEAN RADIUS	1.091	.956	.901
MAX RADIUS	1.807	1.600	1.365
HORIZONTAL SPREAD	2.418	1.879	1.879
VERTICAL SPREAD	3.067	3.067	2.181
EXTREME SPREAD	3.312	3.075	2.330
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		