

06648923

MODEL 700TM M24

Model S&STM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

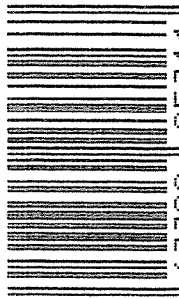
Remington

Remington REG. U.S. PAT. & TM. OFF.		DUPONT REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700TM M24		SERIAL NO. C6648923		ORDER NO. 5716	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.					



5716 C6648923

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648923

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	28
	Magnaflux Bolt		JUL 22 1991	28
615	Rollmark Caliber		JUL 22 1991	FB
617	Drill and Tap Sight Holes		JUL 22 1991	WB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	W

op. #	BARBER - M24 0033378 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-19-91	JU
	G) Safety Off Force	3	3	3			8-19-91	JU
	H) Trigger Pull Test & Retainability						8-19-91	JU
	I) Firing Pin Indent	.023	.023	.022			8-19-91	JU
	J) Assemble Stock						8/20/91	RW
	K) Assemble Swivel Studs						8-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/20/91	RW
	M) Iron Sight Alignment						8/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	RW
	O) Attach Scope to Rifle						8/20/91	RW
	P) Detach & Attach Scope 20 Times						8/20/91	RW
640	Gallery Target & Test						8-21-91	AC
	A) Time						8-21-91	AC
	B) Malfunctions						8-21-91	AC
	C) Pierced Primers						8-21-91	AC
	D) Optical Clarity of Scope						8-21-91	AC
645	Inspect for Live Ammo						8-21-91	AC
655	Final Inspection							
	A) Headspace						8-22-91	D/H
	B) Trigger Pull	220	223	224	225	230	8-21-91	DH
	C) Function						8-22-91	D/H
660	Pack						9-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6648923DATE 8-19-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.66	2.55	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.63	2.60	2.23	
PULL #3	2.65	2.62	2.65	2.24	
PULL #4	2.67	2.70	2.53	2.25	
PULL #5	2.61	2.67	2.44	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.24		
PULL #2	3.29	3.25		
PULL #3	3.52	3.37		
PULL #4	3.27	3.21		
PULL #5	3.24	3.36		
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	4.55		4.58
PULL #2	4.42	4.59		4.58
PULL #3	4.25	4.53		4.49
PULL #4	4.51	4.54		4.50
PULL #5	4.56	4.44		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648923
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0537587
1 TO	2	.228215
1 TO	3	.317824
1 TO	4	.16456
1 TO	5	.26414

35
27

-----FOR

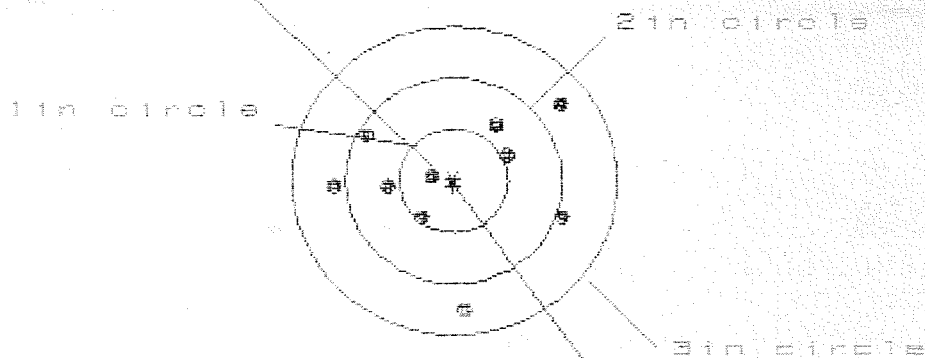
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1342
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0742
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153347
THE AMP FOR THIS RIFLE IS: .868

22 Aug 1991

FILE: \PATTERNING\CENTERFIRE_PATT\0864B923

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.128

VS = 2.069

GS = 2.289

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.031

1.104

1.129

MINIMUM X

-1.097

-1.983

-.959

MAXIMUM Y

.790

.665

.516

MINIMUM Y

-1.279

-1.191

-.405

CENTROID X

.009

-.105

-.130

CENTROID Y

.053

-.035

.114

POA TO CENTROID in.

.054

.111

.172

MIN RADIUS

.235

.176

.094

MEAN RADIUS

.822

.748

.671

MAX RADIUS

1.299

1.207

1.199

HORIZONTAL SPREAD

2.128

2.087

2.087

VERTICAL SPREAD

2.069

1.856

.921

EXTREME SPREAD

2.289

2.107

2.107

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

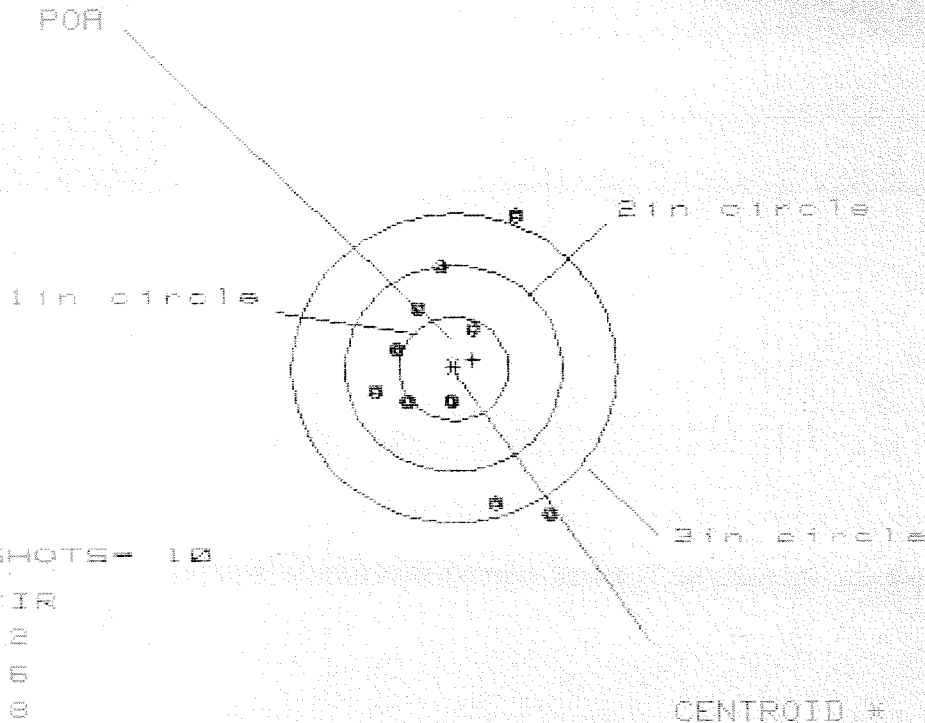
NUMBER IN THREE INCH CIRCLE =

10

22 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6648923

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.671

VS= 2.864

CS= 2.878

CENTROID *

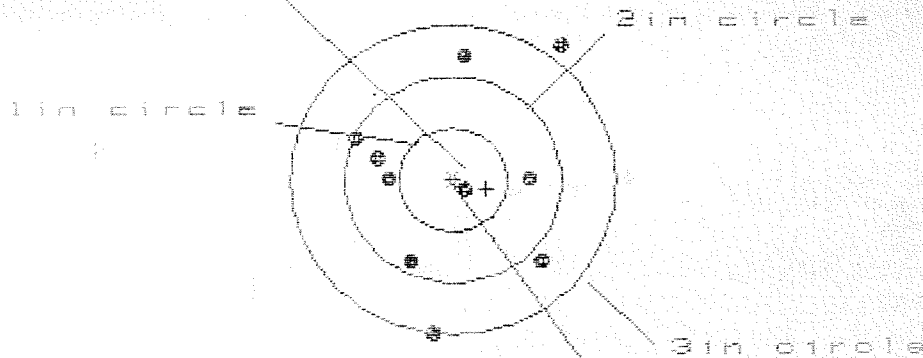
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.982	.715	.574
MINIMUM X	-.769	-.669	-.579
MAXIMUM Y	1.443	1.285	1.016
MINIMUM Y	-1.421	-1.495	-1.334
CENTROID X	-.172	-.272	-.362
CENTROID Y	-.086	.072	-.089
POA TO CENTROID in.	.192	.282	.372
MIN RADIUS	.284	.361	.346
MEAN RADIUS	.892	.775	.670
MAX RADIUS	1.683	1.571	1.452
HORIZONTAL SPREAD	1.671	1.384	1.153
VERTICAL SPREAD	2.864	2.780	2.350
EXTREME SPREAD	2.878	2.790	2.404
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6645923

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 1.915

VS = 2.800

GS = 3.038

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.017

.902

.895

MINIMUM X

-.898

-.785

-.792

MAXIMUM Y

1.273

1.374

1.201

MINIMUM Y

-1.527

-1.386

-.855

CENTROID X

-.307

-.420

-.414

CENTROID Y

.087

-.054

.119

POA TO CENTROID in.

.319

.423

.430

MIN RADIUS

.091

.219

.202

MEAN RADIUS

.945

.860

.781

MAX RADIUS

1.629

1.392

1.226

HORIZONTAL SPREAD

1.915

1.687

1.697

VERTICAL SPREAD

2.800

2.760

2.056

EXTREME SPREAD

3.038

2.773

2.149

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

8

22 Aug 1991

FILE: \PATTERNING\CENTERFIRE_PATT\0664B923

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

LS = 2.422

VS = 1.487

GS = 2.427

CENTROID #.

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.026

.871

.737

MINIMUM X

-1.396

-1.072

-.736

MAXIMUM Y

.834

.862

.717

MINIMUM Y

-.663

-.635

-.527

CENTROID X

-.149

.006

.140

CENTROID Y

.007

-.021

-.129

POA TO CENTROID in.

.149

.022

.190

MIN RADIUS

.195

.256

.205

MEAN RADIUS

.786

.691

.588

MAX RADIUS

1.419

1.376

.985

HORIZONTAL SPREAD

2.422

1.943

1.473

VERTICAL SPREAD

1.497

1.497

1.244

EXTREME SPREAD

2.427

2.075

1.662

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

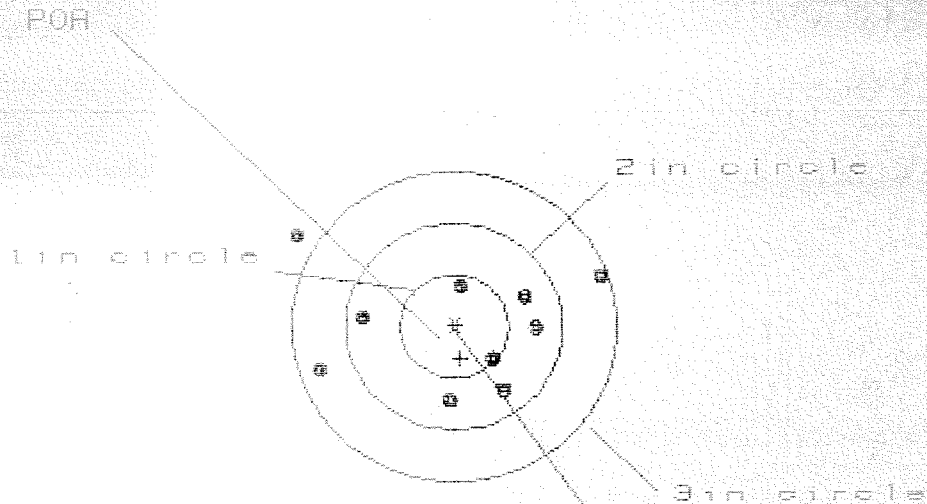
NUMBER IN THREE INCH CIRCLE =

10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B323

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

CENTROID #

HS= 2.733

VS= 1.569

GS= 2.758

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.307

1.149

.699

MINIMUM X

-1.426

-1.394

-1.250

MAXIMUM Y

.888

.618

.518

MINIMUM Y

-.681

-.582

-.505

CENTROID X

-.052

.106

-.038

CENTROID Y

.310

.211

.134

POA TO CENTROID in.

.314

.297

.139

MIN RADIUS

.345

.294

.364

MEAN RADIUS

.895

.767

.711

MAX RADIUS

1.679

1.435

1.278

HORIZONTAL SPREAD

2.733

2.543

1.949

VERTICAL SPREAD

1.569

1.200

1.023

EXTREME SPREAD

2.758

2.717

2.036

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9