

C6611675

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		SERIAL NO. C6611675
20		ORDER NO. 5716



5716 C6611675



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611675

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		KCR
	Magnaflux Bolt	5 6 91		KCR
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		LB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	AM

op. #	BARBER - M24 0034172	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-10-91	JH
	G) Safety Off Force	4	4	4			6-10-91	JH
	H) Trigger Pull Test & Retainability						6-10-91	JH
	I) Firing Pin Indent	.021	.0225	.0225			6-10-91	JH
	J) Assemble Stock						6/10/91	RW
	K) Assemble Swivel Studs						6-13-91	AC
	L) Attach Front and Rear Sight Assemblies						6/10/91	RW
	M) Iron Sight Alignment						6/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/10/91	RW
	O) Attach Scope to Rifle						6/10/91	RW
	P) Detach & Attach Scope 20 Times						6/10/91	RW
640	Gallery Target & Test						6-11-91	DH
	A) Time						6-11-91	DH
	B) Malfunctions						6-11-91	DH
	C) Pierced Primers						6-11-91	DH
	D) Optical Clarity of Scope						6-11-91	DH
645	Inspect for Live Ammo						6-11-91	DH
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.52	2.54	2.57	2.58	2.60	2-13-91	JH
	C) Function						6-13-91	AC
660	Pack						6-20-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611675DATE 6-10-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.36	2.40	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.39	2.22	2.54	
PULL #3	2.38	2.35	2.20	2.57	
PULL #4	2.36	2.35	2.38	2.58	
PULL #5	2.40	2.35	2.38	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.50		
PULL #2	3.42	3.56		
PULL #3	3.46	3.50		
PULL #4	3.45	3.54		
PULL #5	3.35	3.54		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.41		4.43
PULL #2	4.21	4.48		4.62
PULL #3	4.14	4.49		4.36
PULL #4	4.14	4.44		4.49
PULL #5	4.60	4.40		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611675
11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.485891
1 TO	2	.418475
1 TO	3	.442404
1 TO	4	.531015
1 TO	5	.638694

1
4 <----POA

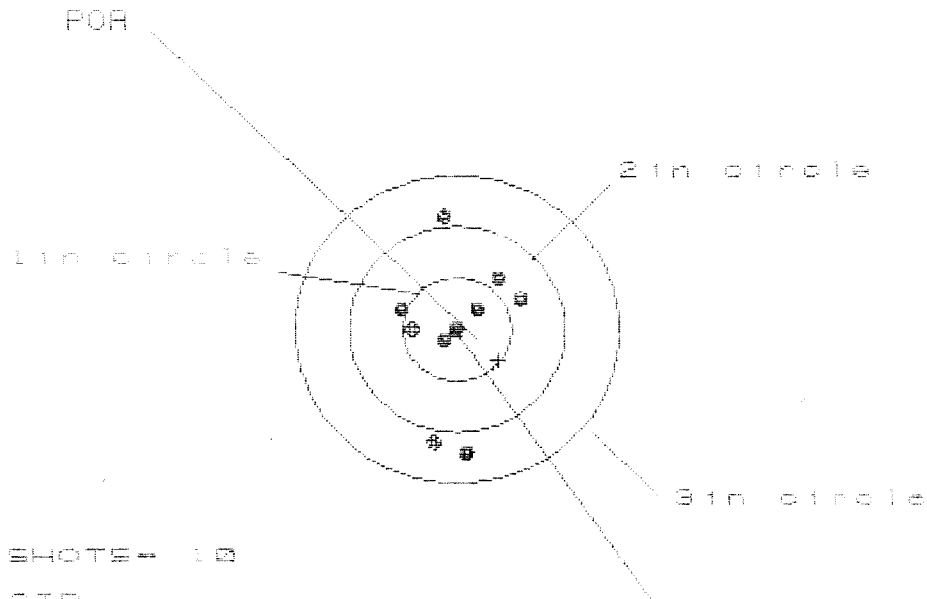
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1682
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0384
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .172528

THE AMR FOR THIS RIFLE IS: .809

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611675

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.014

VS= 2.313

GS= 2.322

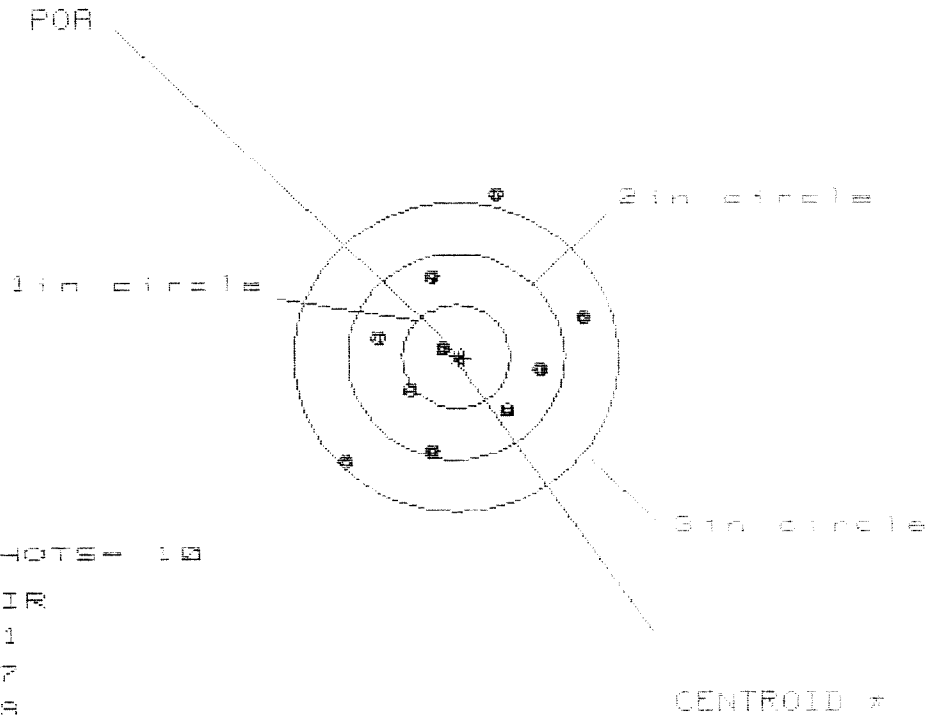
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.536	.547	.519
MINIMUM X	-.478	-.467	-.495
MAXIMUM Y	1.138	1.008	.850
MINIMUM Y	-1.175	-1.262	-.392
CENTROID X	-.383	-.394	-.366
CENTROID Y	.299	.429	.587
POR TO CENTROID in.	.486	.582	.692
MIN RADIUS	.056	.091	.235
MEAN RADIUS	.618	.546	.466
MAX RADIUS	1.179	1.282	.859
HORIZONTAL SPREAD	1.014	1.014	1.014
VERTICAL SPREAD	2.313	2.270	1.242
EXTREME SPREAD	2.322	2.273	1.242
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611675

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.126

VC = 2.615

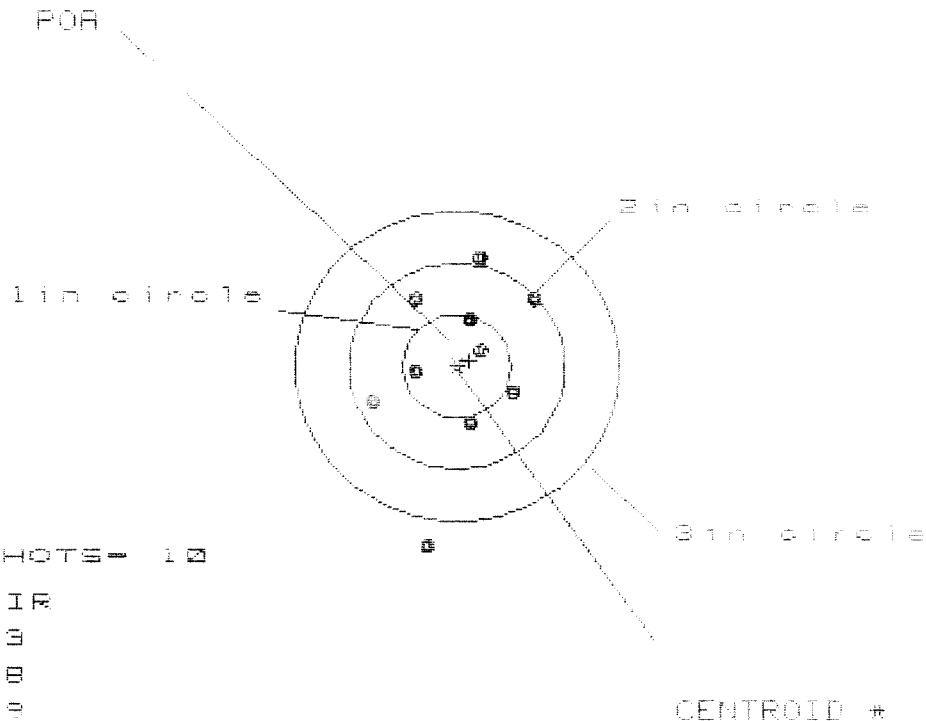
GS = 2.932

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.125	1.161	1.041
MINIMUM X	:	-1.001	-.965	-.792
MAXIMUM Y	:	1.584	.998	.892
MINIMUM Y	:	-1.031	-.855	-.854
CENTROID X	:	-.072	-.108	.012
CENTROID Y	:	.019	-.157	-.051
POA TO CENTROID in.	:	.075	.191	.052
MIN RADIUS	:	.172	.261	.276
MEAN RADIUS	:	.892	.796	.736
MAX RADIUS	:	1.617	1.289	1.116
HORIZONTAL SPREAD	:	2.126	2.126	1.833
VERTICAL SPREAD	:	2.615	1.853	1.746
EXTREME SPREAD	:	2.932	2.526	1.844
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611675

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.456

VS= 2.843

GS= 2.886

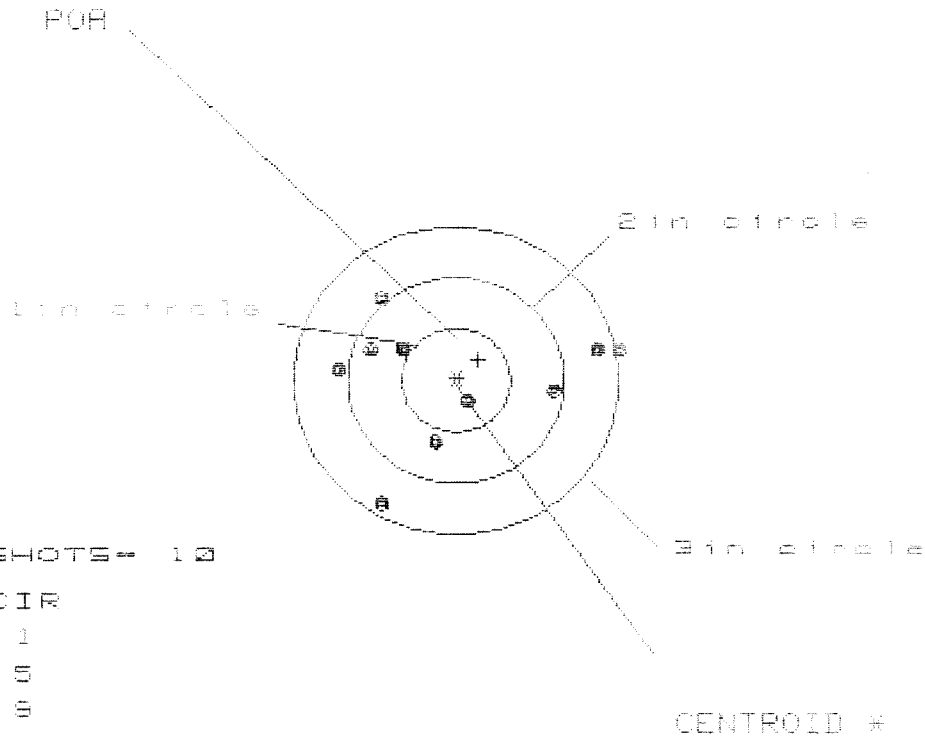
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.687
MINIMUM X	-.769
MAXIMUM Y	1.066
MINIMUM Y	-1.777
CENTROID X	-.119
CENTROID Y	-.056
POA TO CENTROID in.	.131
MIN RADIUS	.256
MEAN RADIUS	.770
MAX RADIUS	1.795
HORIZONTAL SPREAD	1.456
VERTICAL SPREAD	2.843
EXTREME SPREAD	2.886
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08811675

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.567

VS= 2.057

GS= 2.750

CENTROID #

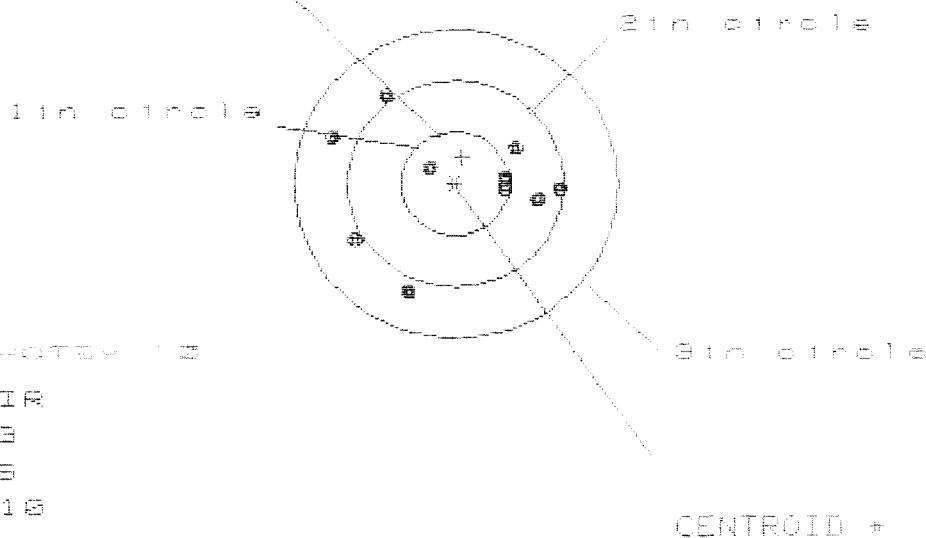
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.521	1.500	1.429
MINIMUM X	-1.046	-0.877	-0.948
MAXIMUM Y	.838	.877	.730
MINIMUM Y	-1.219	-1.180	-0.680
CENTROID X	-.207	-.376	-.385
CENTROID Y	-.202	-.241	-.094
POB TO CENTROID in.	.289	.446	.319
MIN RADIUS	.219	.311	.363
MEAN RADIUS	.963	.871	.820
MAX RADIUS	1.561	1.531	1.438
HORIZONTAL SPREAD	2.567	2.377	2.377
VERTICAL SPREAD	2.057	2.057	1.410
EXTREME SPREAD	2.750	2.548	2.386
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/Q8811875

CENTERFIRE PATTERNS # 5

POB



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.290

VS= 1.897

GS= 2.137

CENTROID +

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.990	.867	.801
MINIMUM X	-1.101	-1.025	-1.091
MAXIMUM Y	.839	.885	.758
MINIMUM Y	-1.058	-1.012	-.846
CENTROID X	-.060	.062	.128
CENTROID Y	-.252	-.298	-.171
POB TO CENTROID	.259	.304	.214
MIN RADIUS	.237	.354	.259
MEAN RADIUS	.302	.736	.853
MAX RADIUS	1.175	1.165	1.268
HORIZONTAL SPREAD	2.090	1.892	1.892
VERTICAL SPREAD	1.897	1.897	1.405
EXTREME SPREAD	2.137	1.965	1.965
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	