

C5611705

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

SERIAL NO.
C6611705

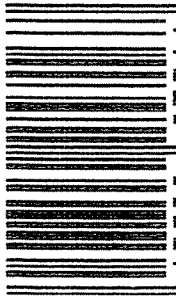
ORDER NO.
5716

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

5716 C6611705

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611705

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	YG
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake.		5/1/91	RL

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/1/91	JH
	G) Safety Off Force	4	4	4			5/1/91	JH
	H) Trigger Pull Test & Retainability						5/1/91	JH
	I) Firing Pin Indent	.0215	.0215	.0215			5/1/91	JH
	J) Assemble Stock						5/1/91	Rw
	K) Assemble Swivel Studs						5-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/1/91	Rw
	M) Iron Sight Alignment						5/1/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	Rw
	O) Attach Scope to Rifle						5/1/91	Rw
	P) Detach & Attach Scope 20 Times						5/1/91	Rw
640	Gallery Target & Test						5-1-91	D/H
	A) Time						5-1-91	D/H
	B) Malfunctions						5-1-91	D/H
	C) Pierced Primers						5-1-91	D/H
	D) Optical Clarity of Scope						5-1-91	D/H
645	Inspect for Live Ammo						5-1-90	D/H
655	Final Inspection							
	A) Headspace						5-13-91	D/H
	B) Trigger Pull	2.57	2.42	2.50	2.60	2.55	5/10/91	JCP
	C) Function						5-13-91	D/H
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611705

DATE 5/1/91

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.20	2.33	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.29	2.35	2.42	
PULL #3	2.45	2.23	2.40	2.50	
PULL #4	2.40	2.30	2.28	2.60	
PULL #5	2.56	2.44	2.36	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.30		
PULL #2	3.30	3.36		
PULL #3	3.50	3.38		
PULL #4	3.48	3.40		
PULL #5	3.40	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.42		4.63
PULL #2	4.35	4.43		4.30
PULL #3	4.33	4.41		4.63
PULL #4	4.29	4.40		4.46
PULL #5	4.23	4.41		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611705
1 May 1991

CENTROIDAL DISTANCES

0 TO 1	.280045
1 TO 2	.419981
1 TO 3	.39685
1 TO 4	.616536
1 TO 5	.28048

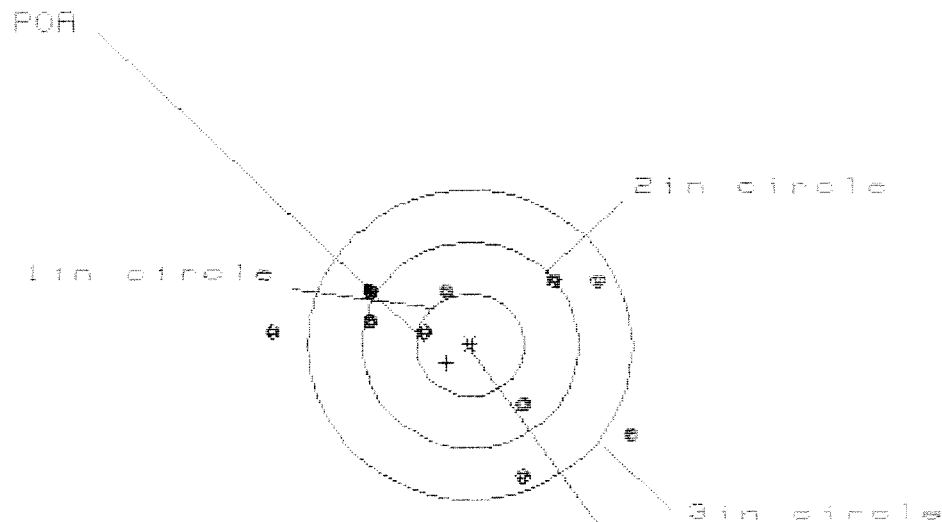
49.2 (----)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0178
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0526972
THE AMP FOR THIS RIFLE IS: .976

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611705

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 3.347

VS = 1.975

GS = 3.503

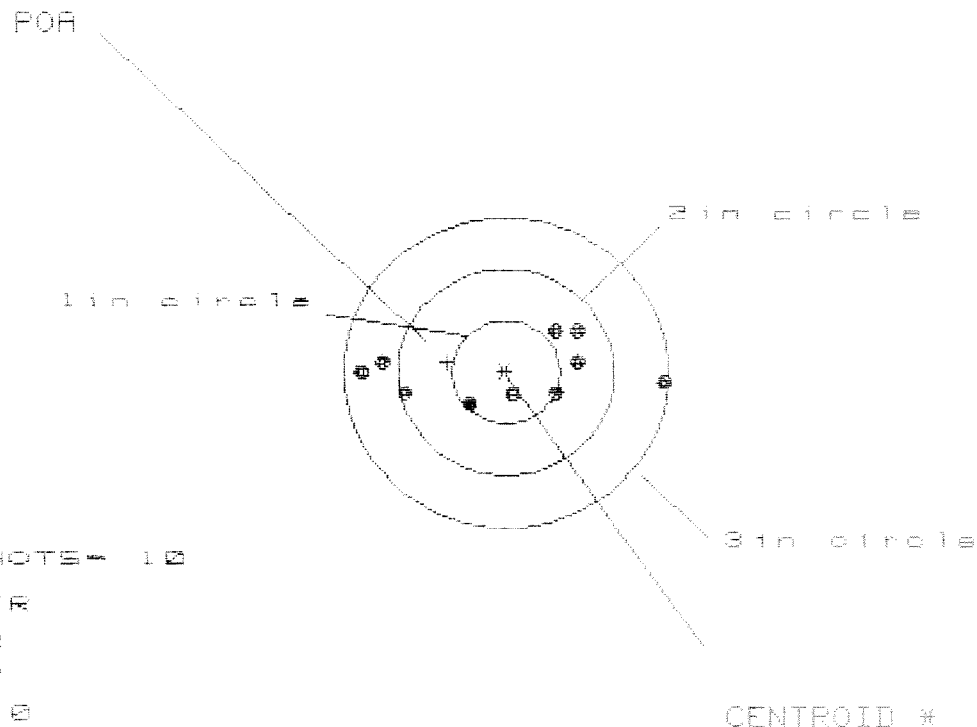
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.480	1.273	1.105
MINIMUM X	-1.867	-1.104	-0.945
MAXIMUM Y	.666	.681	.569
MINIMUM Y	-1.309	-1.294	-1.405
CENTROID X	.221	.428	.269
CENTROID Y	.172	.157	.269
POA TO CENTROID in.	.280	.456	.300
MIN RADIUS	.433	.613	.462
MEAN RADIUS	1.098	1.017	.915
MAX RADIUS	1.871	1.552	1.458
HORIZONTAL SPREAD	3.347	2.377	2.050
VERTICAL SPREAD	1.975	1.975	1.975
EXTREME SPREAD	3.503	2.750	2.230
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

1 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HG = 2.749

VS = .723

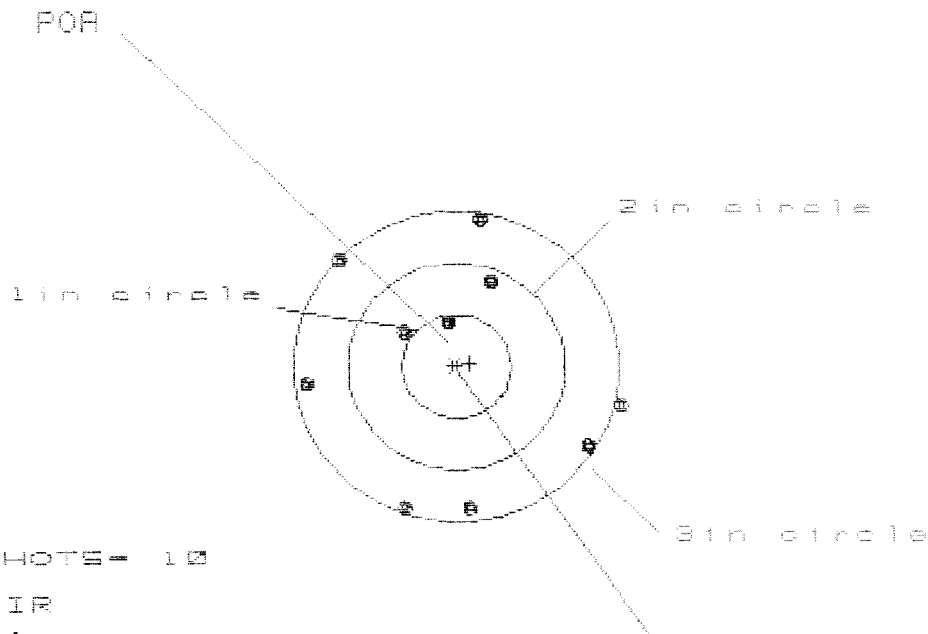
GS = 2.749

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.430	.794	.649
MINIMUM X	-1.319	-1.160	-1.130
MAXIMUM Y	.425	.417	.413
MINIMUM Y	-.298	-.386	-.310
CENTROID X	.541	.382	.527
CENTROID Y	-.100	-.092	-.088
POA TO CENTROID in.	.550	.393	.535
MIN RADIUS	.210	.322	.227
MEAN RADIUS	.806	.748	.666
MAX RADIUS	1.431	1.161	1.135
HORIZONTAL SPREAD	2.749	1.954	1.775
VERTICAL SPREAD	.723	.723	.723
EXTREME SPREAD	2.749	1.998	1.800
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.866

VS = 2.821

GS = 2.938

CENTROID *

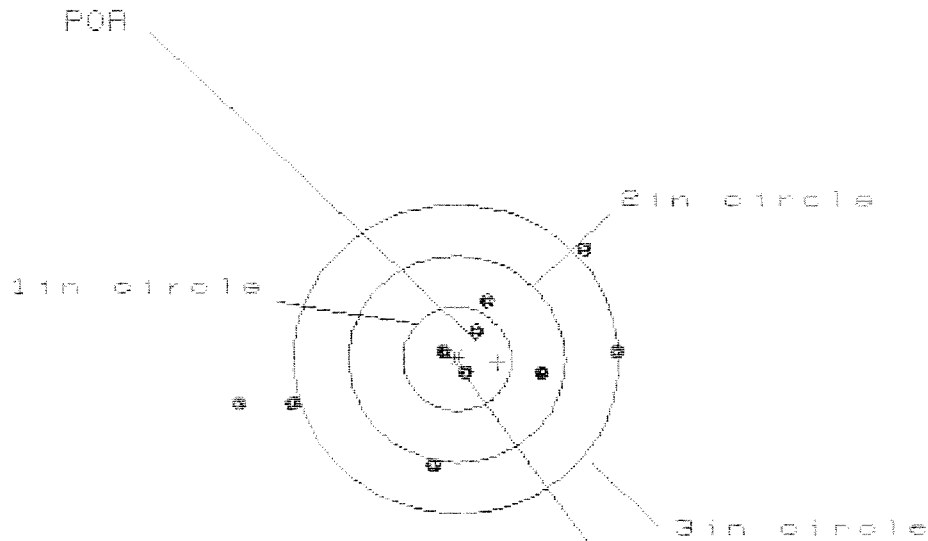
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.505
MINIMUM X	-1.361
MAXIMUM Y	1.419
MINIMUM Y	-1.482
CENTROID X	-0.120
CENTROID Y	-0.031
POA TO CENTROID in.	.124
MIN RADIUS	.413
MEAN RADIUS	1.202
MAX RADIUS	1.551
HORIZONTAL SPREAD	2.866
VERTICAL SPREAD	2.821
EXTREME SPREAD	2.938
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	8

1 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 6

HS = 3.500

VS = 2.070

GS = 3.534

CENTROID #

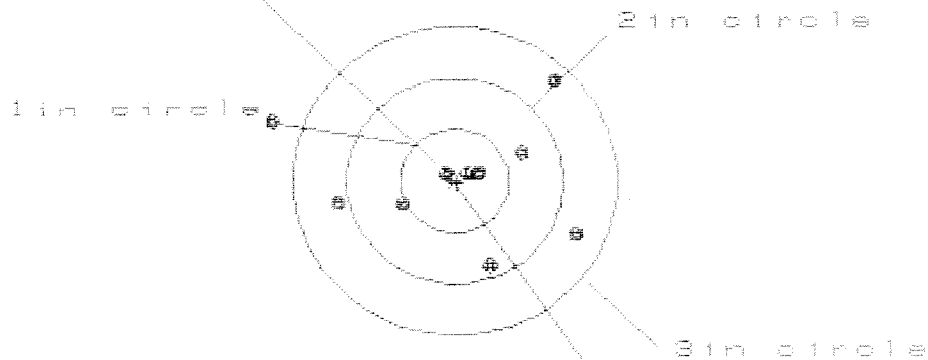
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.507	1.286	1.070
MINIMUM X	-1.993	-1.725	-1.702
MAXIMUM Y	1.050	1.008	.952
MINIMUM Y	-1.020	-1.062	-1.117
CENTROID X	-.370	-.157	.059
CENTROID Y	.026	.069	.124
POA TO CENTROID in.	.379	.171	.138
MIN RADIUS	.170	.208	.336
MEAN RADIUS	.976	.836	.724
MAX RADIUS	2.030	1.781	1.320
HORIZONTAL SPREAD	3.500	3.011	1.772
VERTICAL SPREAD	2.070	2.070	2.070
EXTREME SPREAD	3.534	3.052	2.585
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08B117B5

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 18

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.801

VS= 1.828

GS= 3.024

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.135
MINIMUM X	-1.666
MAXIMUM Y	.985
MINIMUM Y	-.843
CENTROID X	-.016
CENTROID Y	.022
POA TO CENTROID in.	.027
MIN RADIUS	.103
MEAN RADIUS	.798
MAX RADIUS	1.762
HORIZONTAL SPREAD	2.801
VERTICAL SPREAD	1.828
EXTREME SPREAD	3.024
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9