

C6636012

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 700™ M24

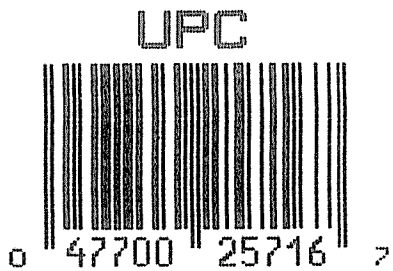
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

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SERIAL NO.	C6636012
ORDER NO.	5716



5716 C6636012



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636012

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	9 1	RW
600	Proof	4 8	9 1	RW
607	Check Headspace	4 8		RW
610	Dis-assemble Gun		3 1	RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	q
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 19 1991	LS
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/16/91	KR
	D) Oil Firing Pin Ass'y		5/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/91	RU

op. #	BARBER - M24 0036661	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/25/91	JH
	G) Safety Off Force	4	4	4			5/25/91	JH
	H) Trigger Pull Test & Retainability						5/25/91	JH
	I) Firing Pin Indent	.0205	.021	.021			5/25/91	JH
	J) Assemble Stock						5/25/91	RW
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	RW
	M) Iron Sight Alignment						5/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	RW
	O) Attach Scope to Rifle						5/25/91	RW
	P) Detach & Attach Scope 20 Times						5/25/91	RW
640	Gallery Target & Test						5-29-91	AC
	A) Time						5-29-91	AC
	B) Malfunctions						5-29-91	AC
	C) Pierced Primers						5-29-91	AC
	D) Optical Clarity of Scope						5-29-91	AC
645	Inspect for Live Ammo						5-29-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.48	2.50	2.47	2.29	2.40	6/1/91	JH
	C) Function						6-1-91	D/H
660	Pack						6-20-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636012

DATE 5/25/91

TESTER JR.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.32	2.51	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.23	2.38	2.50	
PULL #3	2.46	2.28	2.44	2.47	
PULL #4	2.47	2.34	2.38	2.29	
PULL #5	2.43	2.57	2.36	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.58		
PULL #2	3.48	3.58		
PULL #3	3.44	3.46		
PULL #4	3.44	3.45		
PULL #5	3.40	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.37		4.41
PULL #2	4.10	4.21		4.53
PULL #3	4.28	4.47		4.38
PULL #4	4.34	4.33		4.30
PULL #5	4.51	4.38		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636012
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.407767
1 TO	2	.789734
1 TO	3	.858742
1 TO	4	.377414
1 TO	5	.0588727

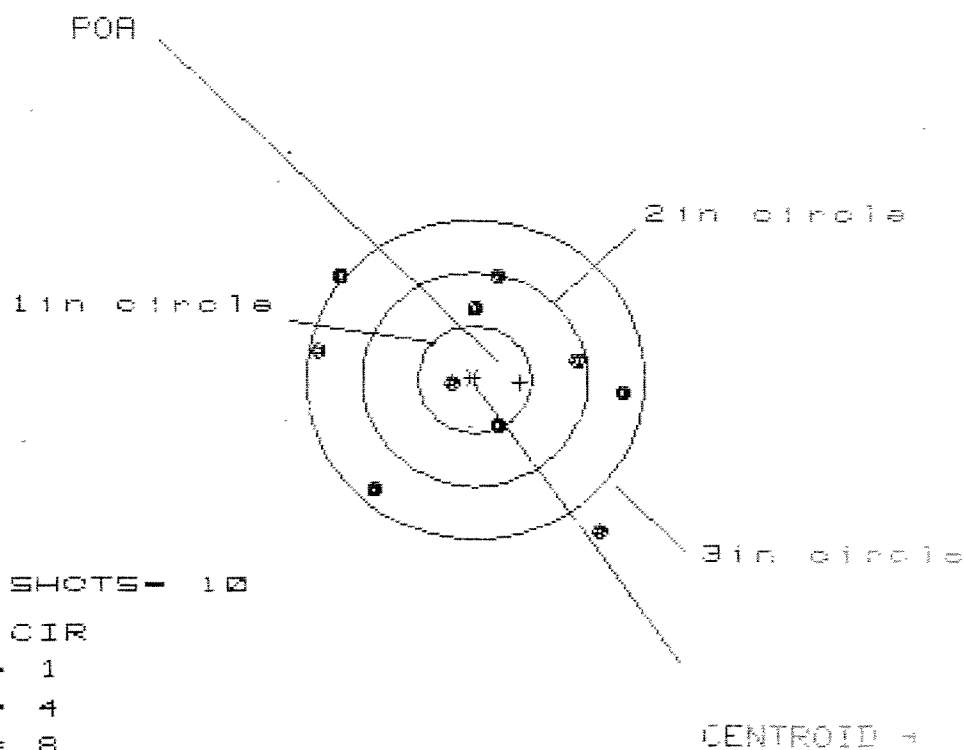
3
2
1 + <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2696
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2324
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .355941
THE AMR FOR THIS RIFLE IS: .9124

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636012

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.776

VS= 2.432

GS= 3.317

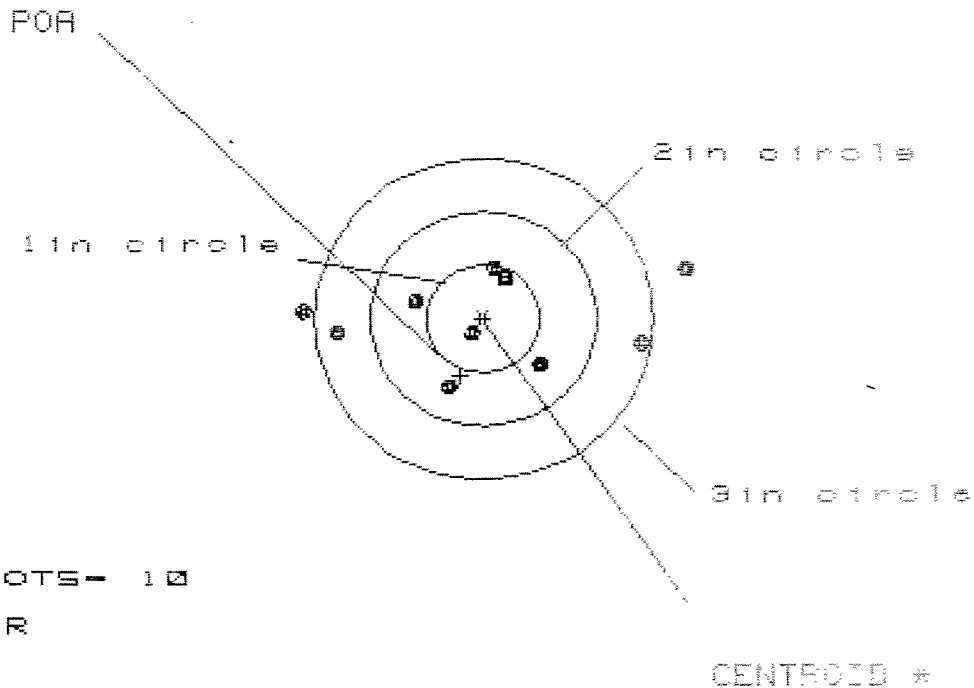
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.341	1.459	1.324
MINIMUM X	-1.435	-1.317	-1.453
MAXIMUM Y	1.008	.849	.954
MINIMUM Y	-1.424	-1.230	-1.125
CENTROID X	-.407	-.525	-.389
CENTROID Y	.025	.184	.079
POA TO CENTROID in.	.407	.556	.397
MIN RADIUS	.184	.211	.219
MEAN RADIUS	1.083	.997	.935
MAX RADIUS	1.779	1.492	1.475
HORIZONTAL SPREAD	2.776	2.776	2.776
VERTICAL SPREAD	2.432	2.079	2.079
EXTREME SPREAD	3.317	2.814	2.814
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

25 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.440

VS= 1.096

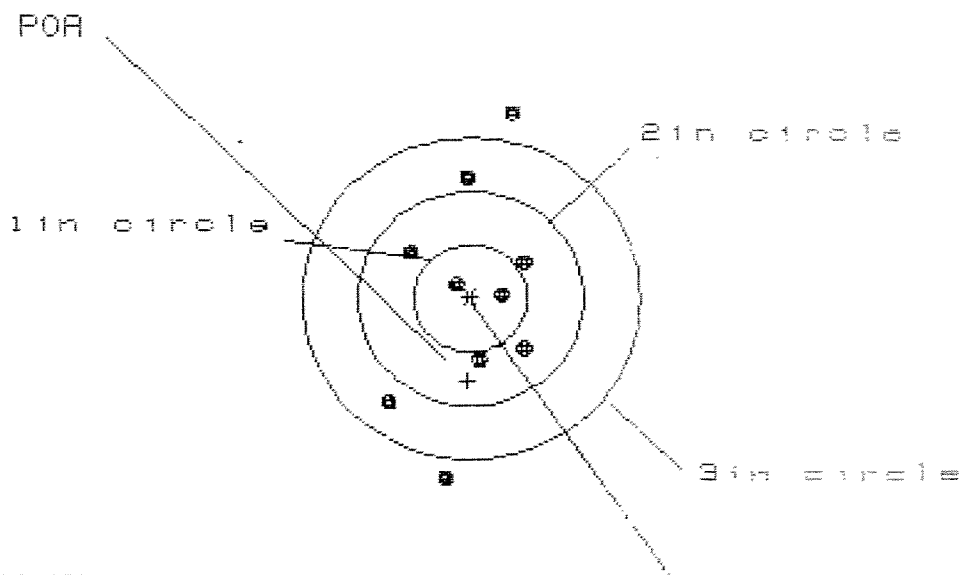
GS= 3.461

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.790	1.584	1.402
MINIMUM X	:	-1.650	-1.451	-1.274
MAXIMUM Y	:	.467	.487	.505
MINIMUM Y	:	-.629	-.577	-.559
CENTROID X	:	.201	.002	.184
CENTROID Y	:	.529	.477	.439
POA TO CENTROID in.	:	.566	.477	.496
MIN RADIUS	:	.138	.111	.085
MEAN RADIUS	:	.924	.810	.715
MAX RADIUS	:	1.850	1.597	1.415
HORIZONTAL SPREAD	:	3.440	3.035	2.676
VERTICAL SPREAD	:	1.096	1.064	1.064
EXTREME SPREAD	:	3.461	3.055	2.680
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

29 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.191

VS= 3.368

GS= 3.416

CENTROID *

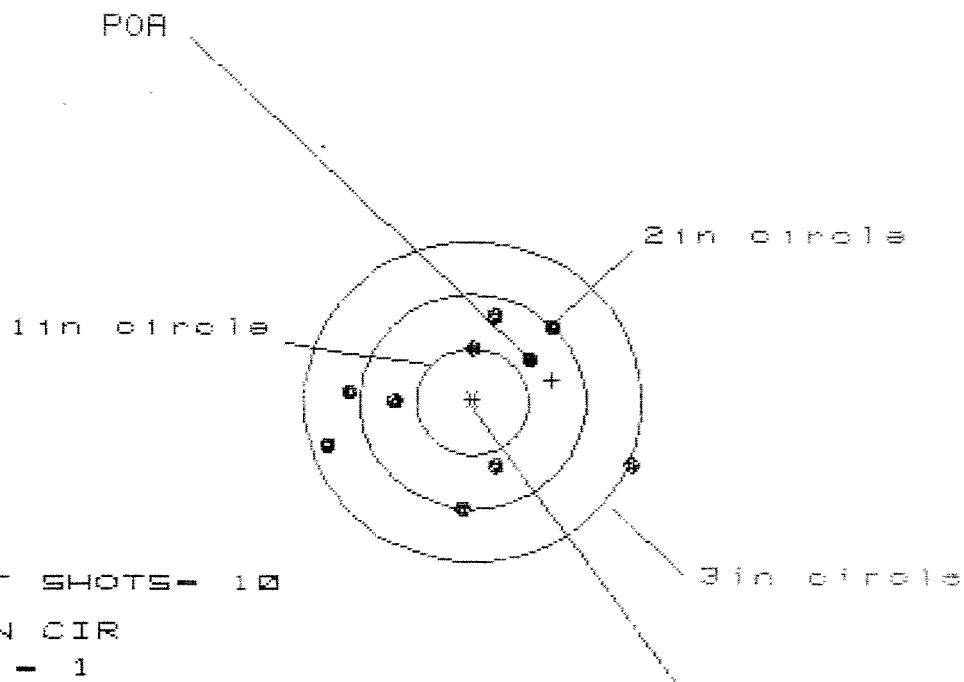
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.513	.551	.527
MINIMUM X	:	-.678	-.640	-.664
MAXIMUM Y	:	1.735	1.316	1.136
MINIMUM Y	:	-1.632	-1.440	-1.984
CENTROID X	:	.027	-.011	.013
CENTROID Y	:	.766	.574	.754
POA TO CENTROID in.	:	.767	.574	.754
MIN RADIUS	:	.195	.315	.190
MEAN RADIUS	:	.873	.777	.606
MAX RADIUS	:	1.768	1.452	1.187
HORIZONTAL SPREAD	:	1.191	1.191	1.191
VERTICAL SPREAD	:	3.368	2.756	2.120
EXTREME SPREAD	:	3.416	2.765	2.223
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

29 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.718

VS= 1.745

GS= 2.725

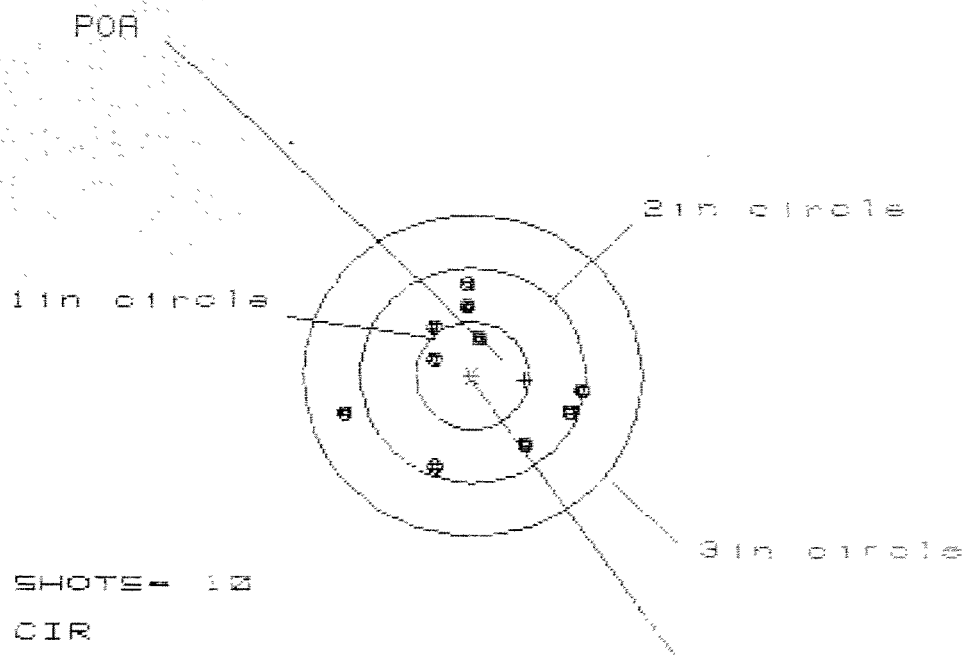
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.436	.838	.538
MINIMUM X	:	-1.282	-1.123	-1.028
MAXIMUM Y	:	.771	.707	.651
MINIMUM Y	:	-.974	-1.038	-1.034
CENTROID X	:	-.707	-.866	-.726
CENTROID Y	:	-.204	-.140	-.034
POA TO CENTROID in.	:	.736	.878	.731
MIN RADIUS	:	.497	.469	.379
MEAN RADIUS	:	.929	.847	.792
MAX RADIUS	:	1.548	1.208	1.099
HORIZONTAL SPREAD	:	2.718	1.961	1.728
VERTICAL SPREAD	:	1.745	1.745	1.745
EXTREME SPREAD	:	2.725	2.230	1.838
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERN # 5



OF SHOTS - 12

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS = 2.081

VS = 1.653

GS = 2.096

CENTROID

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.943
MINIMUM X	-1.138
MAXIMUM Y	.833
MINIMUM Y	-.820
CENTROID X	-.462
CENTROID Y	.046
POA TO CENTROID in.	.465
MIN RADIUS	.345
MEAN RADIUS	.753
MAX RADIUS	1.204
HORIZONTAL SPREAD	2.081
VERTICAL SPREAD	1.653
EXTREME SPREAD	2.096
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10