

C6636042

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

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

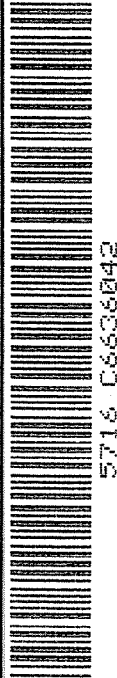
MODEL 700™ M24

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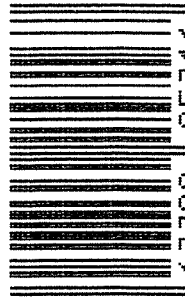
MADE IN ILLON, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636042

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636042

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		UCL
	Magnaflux Bolt	5 8 9 1		UCL
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-31-91	JA
	Apply Coating (Bolt)		5-31-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KA
	C) Inspect Ejector Hole for Chamfer		7/15/91	KA
	D) Oil Firing Pin Ass'y		7/15/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		7/17-91	KA

op.	BARBER - M24 0037019	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			7-17-91	JH
	G) Safety Off Force	4	4	4			7-17-91	JH
	H) Trigger Pull Test & Retainability						7-17-91	JH
	I) Firing Pin Indent	.022	.022	.022			7-17-91	JH
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-23-91	NH
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						7-22-91	NF
655	Final Inspection							
	A) Headspace						7-23-91	NH
	B) Trigger Pull	2.47	2.45	2.47	2.43	2.46	7-23-91	JH
	C) Function						7-23-91	NH
660	Pack						9-19-91	NF

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

SERIAL NO. C-6636042
DATE 7-17-91
TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.39	2.41	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.39	2.38	2.45	
PULL #3	2.36	2.50	2.40	2.47	
PULL #4	2.33	2.41	2.46	2.43	
PULL #5	2.33	2.45	2.48	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.39		
PULL #2	3.42	3.39		
PULL #3	3.41	3.41		
PULL #4	3.43	3.40		
PULL #5	3.38	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.53		4.61
PULL #2	4.53	4.58		4.60
PULL #3	4.50	4.30		4.58
PULL #4	4.52	4.58		4.58
PULL #5	4.54	4.60		4.60
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636042
22 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.141908
1 TO	2	.14803
1 TO	3	.522304
1 TO	4	.233636
1 TO	5	.216813

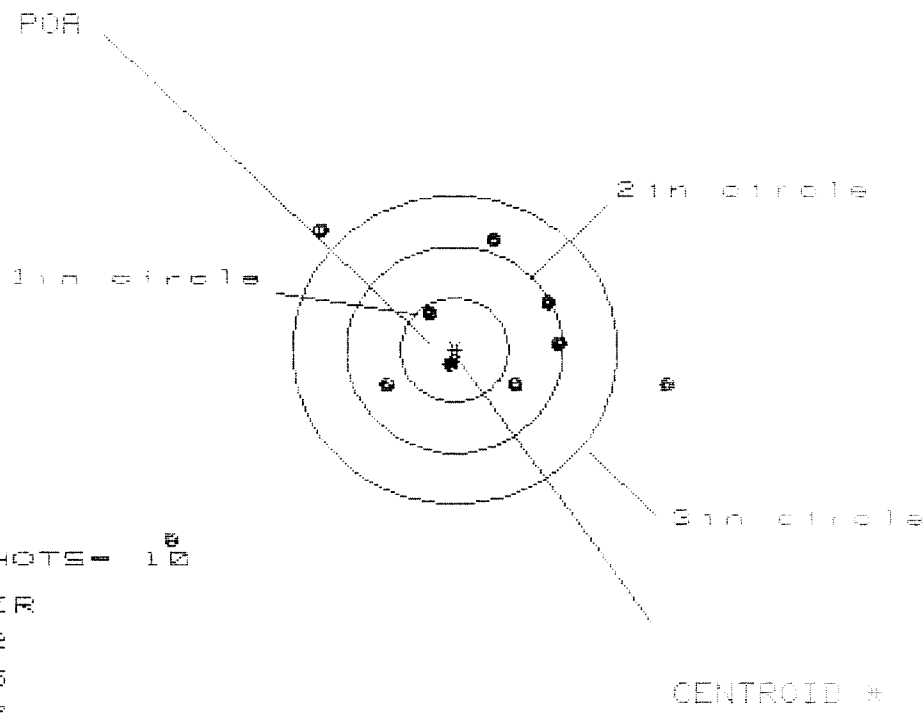
3.4 C----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0018
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0004
THE RESULTING AVERAGE PCI RADIUS FOR THIS RIFLE IS: .0018706
THE AMR FOR THIS RIFLE IS: 1.2

22 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08686042

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 4.566

VS = 2.954

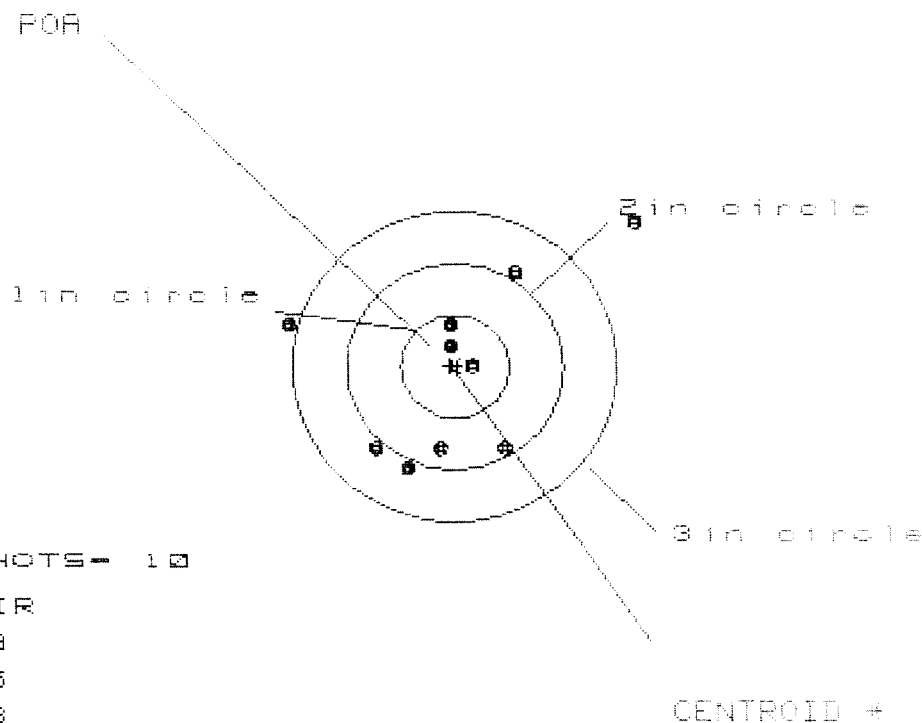
GS = 4.792

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.937	1.645	.869
MINIMUM X	:	-2.629	-1.498	-1.284
MAXIMUM Y	:	1.118	.914	.840
MINIMUM Y	:	-1.836	-.586	-.632
CENTROID X	:	.037	.329	.123
CENTROID Y	:	.137	.341	.414
POA TO CENTROID in.	:	.142	.474	.432
MIN RADIUS	:	.168	.477	.294
MEAN RADIUS	:	1.193	.940	.832
MAX RADIUS	:	3.207	1.748	1.535
HORIZONTAL SPREAD	:	4.566	3.135	2.153
VERTICAL SPREAD	:	2.954	1.500	1.473
EXTREME SPREAD	:	4.792	3.475	2.485
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

22 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 3.234

VS = 2.438

GS = 3.390

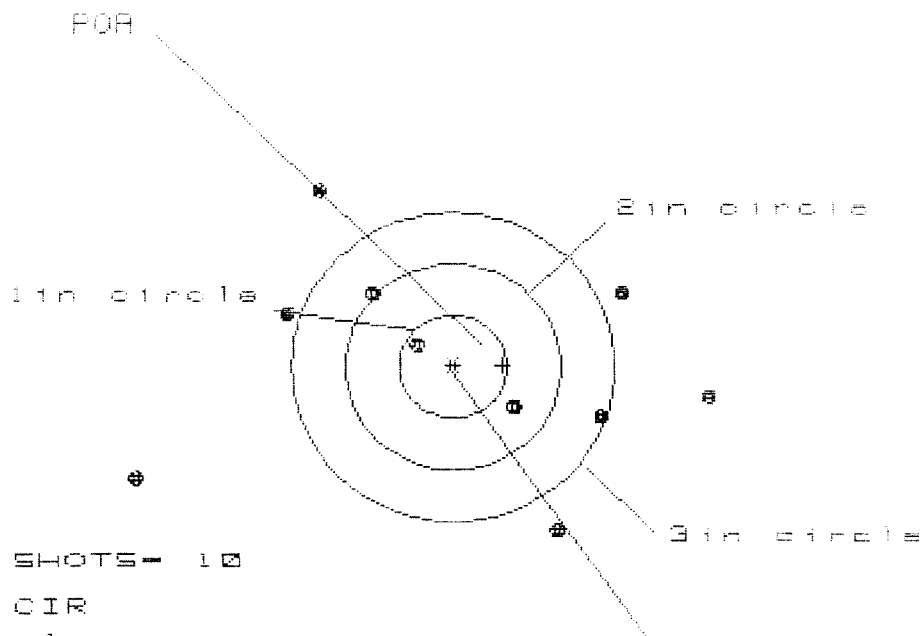
CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.672	.768	.596
MINIMUM X	:	-1.562	-1.376	-1.760
MAXIMUM Y	:	1.416	1.088	1.157
MINIMUM Y	:	-1.022	-.864	-.795
CENTROID X	:	.040	-.146	.026
CENTROID Y	:	-.011	-.168	-.237
POA TO CENTROID in.	:	.041	.223	.239
MIN RADIUS	:	.204	.404	.349
MEAN RADIUS	:	.964	.837	.733
MAX RADIUS	:	2.192	1.484	1.302
HORIZONTAL SPREAD	:	3.234	2.144	1.296
VERTICAL SPREAD	:	2.438	1.952	1.952
EXTREME SPREAD	:	3.390	2.343	2.210
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 4

HS = 5.241

VS = 3.249

GS = 5.303

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.332	2.009	1.481
MINIMUM X	:	-2.909	-1.857	-1.606
MAXIMUM Y	:	1.689	1.564	1.509
MINIMUM Y	:	-1.560	-1.685	-1.740
CENTROID X	:	-.463	-.140	-.391
CENTROID Y	:	-.014	.111	.166
POA TO CENTROID in.	:	.463	.179	.425
MIN RADIUS	:	.396	.652	.388
MEAN RADIUS	:	1.628	1.438	1.341
MAX RADIUS	:	3.118	2.235	2.021
HORIZONTAL SPREAD	:	5.241	3.866	3.097
VERTICAL SPREAD	:	3.249	3.249	3.249
EXTREME SPREAD	:	5.303	4.125	3.969
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		4	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 1.429

VS = 3.614

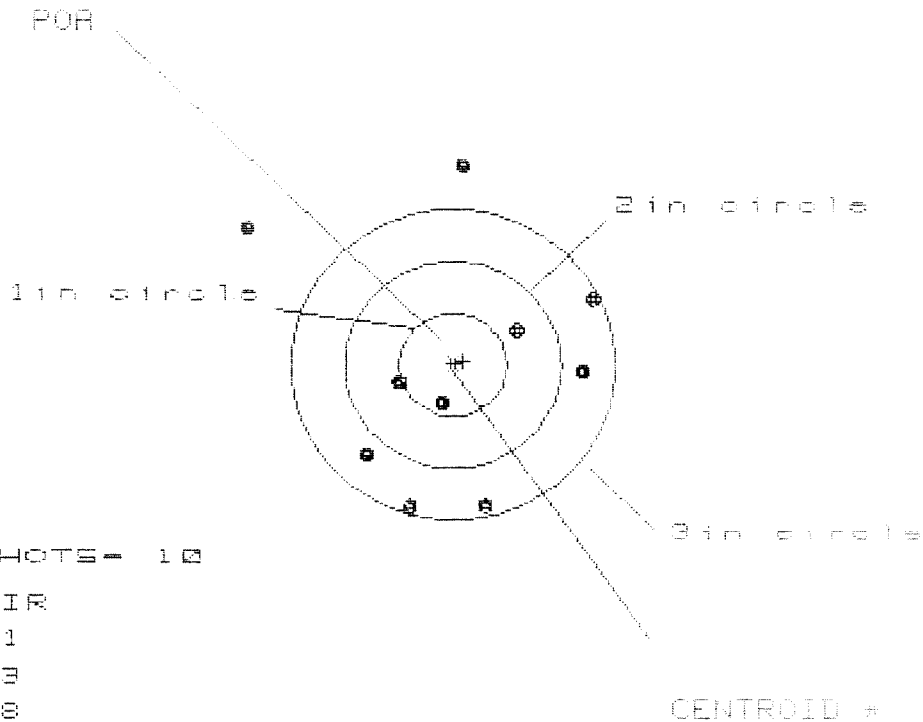
GS = 3.615

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.888	.847	.785
MINIMUM X	-.541	-.582	-.644
MAXIMUM Y	2.042	1.568	1.400
MINIMUM Y	-1.572	-1.345	-.543
CENTROID X	.072	.113	.175
CENTROID Y	-.094	-.321	-.153
POA TO CENTROID in.	.118	.340	.232
MIN RADIUS	.383	.326	.463
MEAN RADIUS	.959	.793	.719
MAX RADIUS	2.075	1.572	1.411
HORIZONTAL SPREAD	1.429	1.429	1.423
VERTICAL SPREAD	3.614	2.913	1.943
EXTREME SPREAD	3.615	2.937	1.998
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HE = 3.246

VS = 3.324

GS = 3.527

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.328
MINIMUM X	-1.918
MAXIMUM Y	1.961
MINIMUM Y	-1.363
CENTROID X	-0.095
CENTROID Y	-0.035
POR TO CENTROID in.	.101
MIN RADIUS	.339
MEAN RADIUS	1.256
MAX RADIUS	2.362
HORIZONTAL SPREAD	3.246
VERTICAL SPREAD	3.324
EXTREME SPREAD	3.527
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8