

C6636044

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.

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

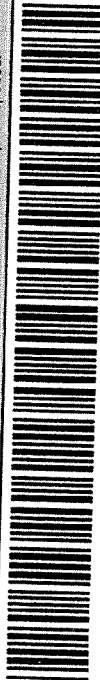
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

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

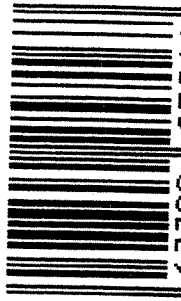
SERIAL NO. C6636044	ORDER NO. 5716
-------------------------------	--------------------------

20



5716 C6636044

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636044

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	4 8 91		RW
607	Check Headspace	4 8 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action	APR	9 1991	KR
	Magnaflux Bolt	APR	9 1991	U
615	Rollmark Caliber	APR	9 1991	LS
617	Drill and Tap Sight Holes	APR	1 9 1991	FB
618	Polish Barrel	APR	1 9 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/91	SM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-29-91	DH
	G) Safety Off Force	3	3	3			5-29-91	DH
	H) Trigger Pull Test & Retainability						5/29/91	JU
	I) Firing Pin Indent	.020	.020	.020			5-29-91	DH
	J) Assemble Stock						5/30/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/30/91	RW
	M) Iron Sight Alignment						5/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/30/91	RW
	O) Attach Scope to Rifle						5/30/91	RW
	P) Detach & Attach Scope 20 Times						5/30/91	RW
640	Gallery Target & Test						5-31-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-31-91	NF
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.25	2.35	2.40	2.57	2.50	6/1/91	JU
	C) Function						6-1-91	DH
660	Pack						6-20-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6636044

DATE 5/29/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.55	2.49	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.50	2.56	2.35	
PULL #3	2.30	2.43	2.50	2.40	
PULL #4	2.49	2.47	2.48	2.51	
PULL #5	2.47	2.51	2.55	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.42		
PULL #2	3.29	3.41		
PULL #3	3.31	3.34		
PULL #4	3.30	3.44		
PULL #5	3.44	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.23		4.15
PULL #2	4.37	4.30		4.22
PULL #3	4.23	4.35		4.33
PULL #4	4.26	4.24		4.24
PULL #5	4.26	4.25		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636844
1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.334607
1 TO	2	.357001
1 TO	3	.299202
1 TO	4	.245018
1 TO	5	.346003

* <----FOR

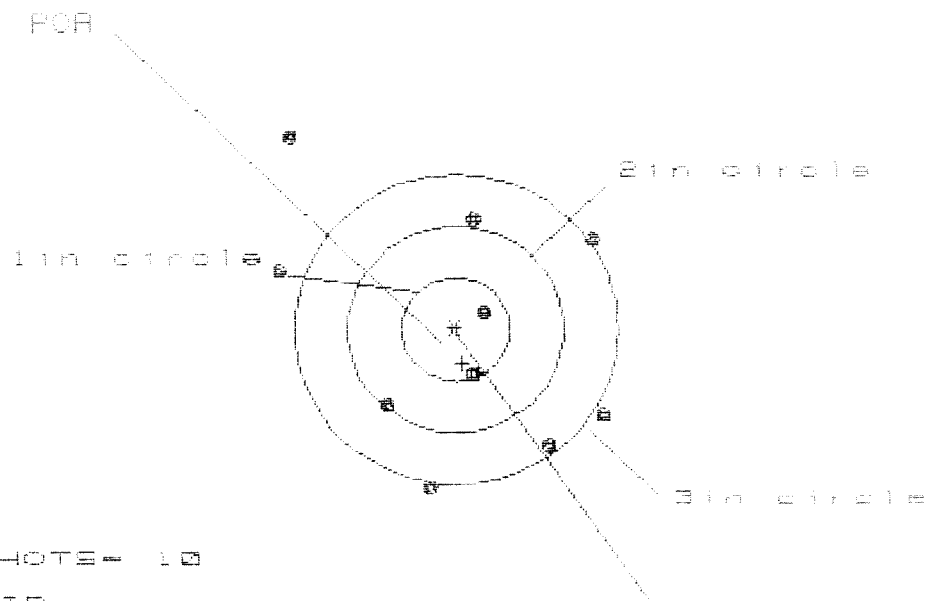
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0358
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .186
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111880

THE AMR FOR THIS RIFLE IS: .9182

1 Jun 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08636044

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 5

HS = 3.0000

VS = 3.4299

GS = 3.0000

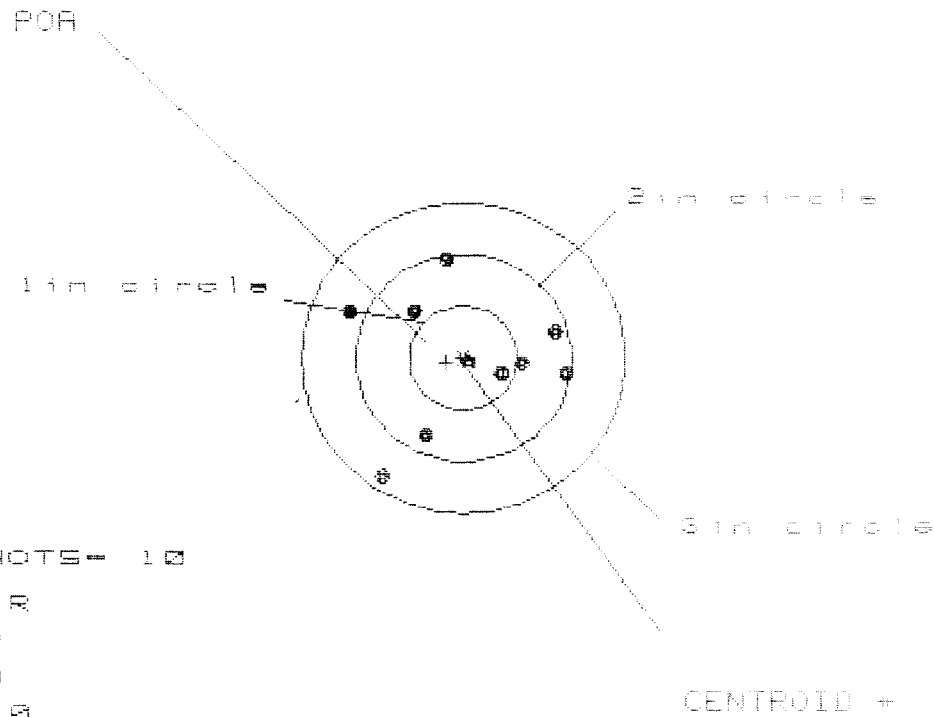
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.357	1.188	1.957
MINIMUM X	-1.675	-1.844	-1.008
MAXIMUM Y	1.883	1.292	1.385
MINIMUM Y	-1.546	-1.337	-1.244
CENTROID X	-1.061	.108	.339
CENTROID Y	.329	.120	.027
POR TO CENTROID in.	.335	.151	.340
MIN RADIUS	.319	.282	.292
MEAN RADIUS	1.306	1.135	1.020
MAX RADIUS	2.424	1.986	1.507
HORIZONTAL SPREAD	3.032	3.032	1.965
VERTICAL SPREAD	3.429	2.629	2.629
EXTREME SPREAD	3.925	3.302	2.875
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/00596044

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.241

VS = 2.056

GS = 2.144

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.918	.832	.694
MINIMUM X	-1.023	-1.109	-1.630
MAXIMUM Y	.961	.839	.881
MINIMUM Y	-1.095	-1.886	-1.844
CENTROID X	.154	.240	.378
CENTROID Y	.044	.166	.124
POA TO CENTROID in.	.160	.292	.390
MIN RADIUS	.073	.148	.188
MEAN RADIUS	.777	.704	.617
MAX RADIUS	1.342	1.158	1.023
HORIZONTAL SPREAD	1.941	1.941	1.374
VERTICAL SPREAD	2.056	1.725	1.725
EXTREME SPREAD	2.144	2.020	1.730
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636044

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.179

VS = 2.995

ES = 3.122

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.006	.947	.847
MINIMUM X	-1.173	-1.232	-1.114
MAXIMUM Y	1.980	.981	1.093
MINIMUM Y	-1.015	-.795	-.683
CENTROID X	.070	.129	.011
CENTROID Y	.060	-.180	-.272
POA TO CENTROID in.	.092	.206	.272
MIN RADIUS	.603	.476	.314
MEAN RADIUS	1.072	.923	.852
MAX RADIUS	2.051	1.306	1.172
HORIZONTAL SPREAD	2.179	2.179	1.961
VERTICAL SPREAD	2.995	1.776	1.776
EXTREME SPREAD	3.122	2.348	2.066
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08836044

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.069

VS = 1.783

GS = 2.549

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.986

.884

.682

MINIMUM X

-1.083

-1.185

-1.074

MAXIMUM Y

.774

.670

.753

MINIMUM Y

-1.009

-1.113

-1.030

CENTROID X

-.064

.038

-.073

CENTROID Y

.084

.188

.165

POA TO CENTROID in.

.105

.192

.128

MIN RADIUS

.099

.167

.120

MEAN RADIUS

.806

.731

.688

MAX RADIUS

1.306

1.210

1.189

HORIZONTAL SPREAD

2.069

2.069

1.636

VERTICAL SPREAD

1.783

1.783

1.783

EXTREME SPREAD

2.549

2.141

2.141

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836044

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 5

2in = 8

3in = 10

HE = 1.870

VE = 1.653

GE = 2.292

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.017	.585	.573
MINIMUM X	-.853	-.740	-.762
MAXIMUM Y	.691	.598	.466
MINIMUM Y	-.962	-1.055	-.405
CENTROID X	.088	-.033	-.021
CENTROID Y	.013	.106	.238
POA TO CENTROID in.	.091	.111	.239
MIN RADIUS	.130	.176	.118
MEAN RADIUS	.630	.538	.466
MAX RADIUS	1.316	1.059	.797
HORIZONTAL SPREAD	1.870	1.325	1.325
VERTICAL SPREAD	1.653	1.653	.871
EXTREME SPREAD	2.292	1.787	1.390
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	