

C6536047

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.

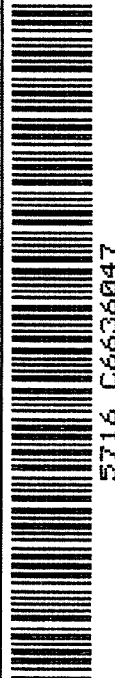
MODEL 700™ M24

SERIAL NO.
C6636047

ORDER NO.
5716

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

20



5716 C6636047

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636047

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		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GS.
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	LB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/5/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/5/91	KS
	C) Inspect Ejector Hole for Chamfer		4/5/91	KS
	D) Oil Firing Pin Ass'y		4/5/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-6-91	SL

op. NAME	BARBER - M240037074	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-6-91	JH
	G) Safety Off Force	3	3	3			6-6-91	JH
	H) Trigger Pull Test & Retainability						6-6-91	JH
	I) Firing Pin Indent	.0225	.022	.022			6-6-91	JH
	J) Assemble Stock						6/6/91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/6/91	KS
	M) Iron Sight Alignment						6/6/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/6/91	KS
	O) Attach Scope to Rifle						6/6/91	KS
	P) Detach & Attach Scope 20 Times						6/6/91	KS
640	Gallery Target & Test						6-7-91	DH
	A) Time						6-7-91	DH
	B) Malfunctions						6-7-91	DH
	C) Pierced Primers						6-7-91	DH
	D) Optical Clarity of Scope						6-7-91	DH
645	Inspect for Live Ammo						6-7-91	DH
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.70	2.72	2.76	2.70	2.60	6-13-91	JH
	C) Function						6-13-91	A
660	Pack						6-19-91	VF

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

SERIAL NO. C6636047DATE 6-6-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.41	2.48	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.31	2.46	2.72	
PULL #3	2.40	2.48	2.36	2.76	
PULL #4	2.40	2.29	2.44	2.70	
PULL #5	2.48	2.45	2.34	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.28		
PULL #2	3.60	3.36		
PULL #3	3.64	3.25		
PULL #4	3.32	3.25		
PULL #5	3.23	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.32		4.55
PULL #2	4.56	4.60		4.55
PULL #3	4.46	4.38		4.57
PULL #4	4.22	4.44		4.46
PULL #5	4.60	4.21		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636047
7 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.293549
1 TO	2	.147313
1 TO	3	.655134
1 TO	4	.266895
1 TO	5	.101005

4.1 (----)POA

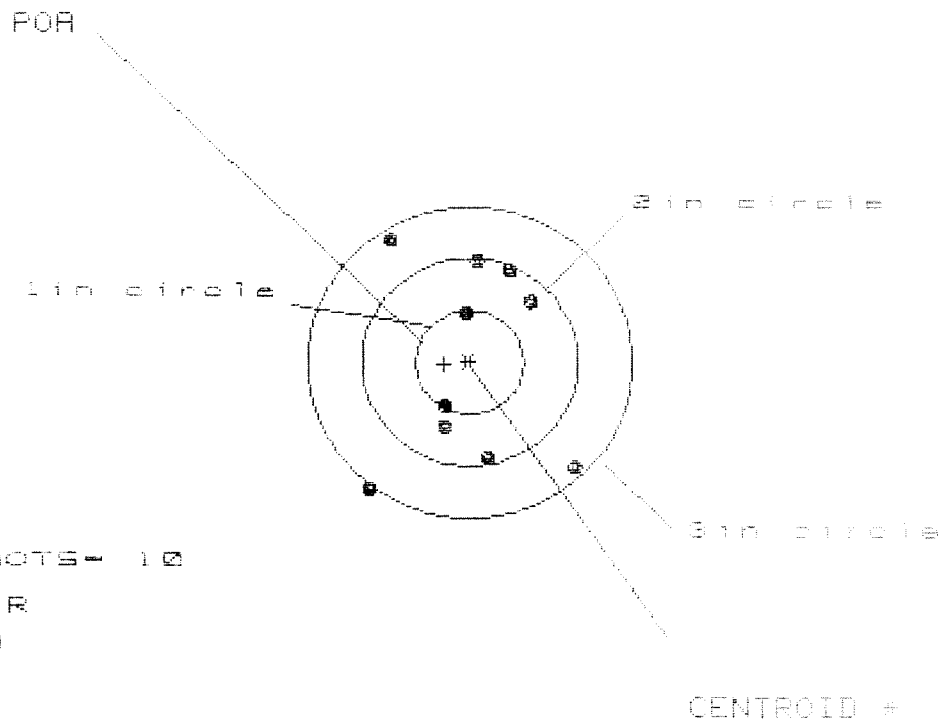
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0642
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0806644

THE AMR FOR THIS RIFLE IS: .9174

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C863804?

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 1.929

VS= 2.390

GS= 2.701

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.947	.838	.735
MINIMUM X	-.982	-.823	-.415
MAXIMUM Y	1.158	1.022	.993
MINIMUM Y	-1.232	-1.108	-.981
CENTROID X	.233	.342	.445
CENTROID Y	.016	.152	.025
POR TO CENTROID in.	.233	.374	.445
MIN RADIUS	.504	.407	.563
MEAN RADIUS	.971	.887	.837
MAX RADIUS	1.575	1.390	1.226
HORIZONTAL SPREAD	1.929	1.661	1.150
VERTICAL SPREAD	2.390	2.130	1.974
EXTREME SPREAD	2.701	2.701	2.154
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

7 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06036047

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 10

HS= 1.466

VS= 1.962

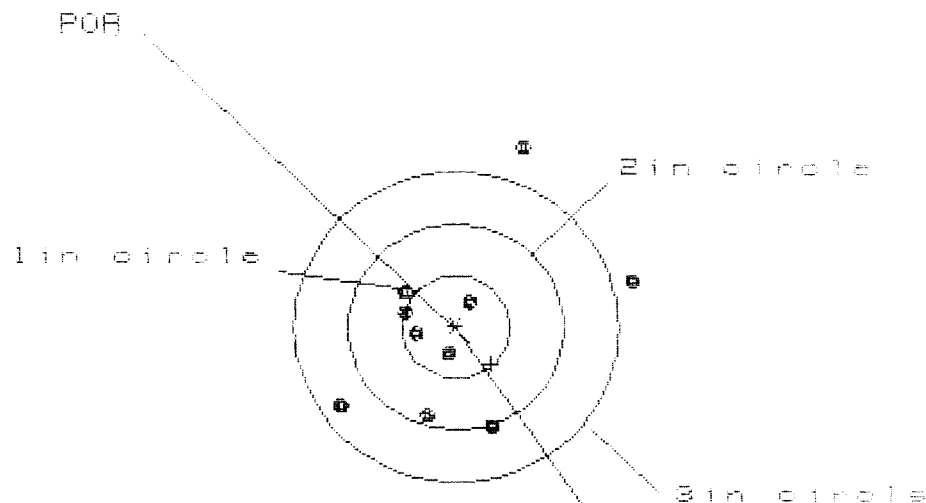
GS= 1.981

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.670
MINIMUM X	:	-.796
MAXIMUM Y	:	1.155
MINIMUM Y	:	-.808
CENTROID X	:	.207
CENTROID Y	:	-.129
POA TO CENTROID in.	:	.243
MIN RADIUS	:	.497
MEAN RADIUS	:	.744
MAX RADIUS	:	1.165
HORIZONTAL SPREAD	:	1.466
VERTICAL SPREAD	:	1.962
EXTREME SPREAD	:	1.981
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	9
NUMBER IN THREE INCH CIRCLE	=	10

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636047

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.653

VS= 2.653

GS= 2.963

CENTROID #

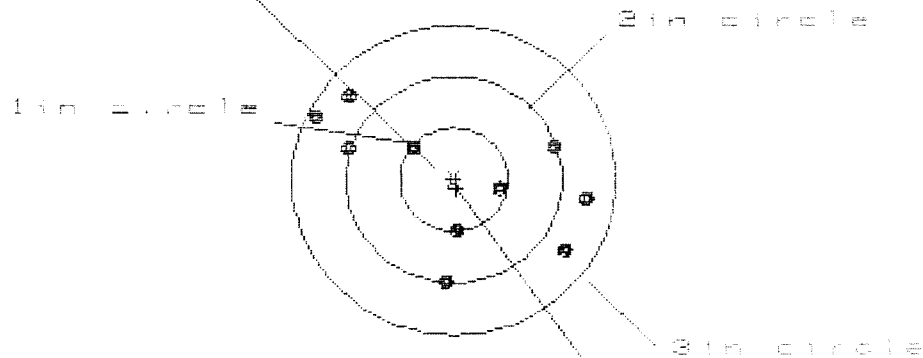
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.584	1.651	.638
MINIMUM X	-1.069	-1.002	-.795
MAXIMUM Y	1.695	.658	.591
MINIMUM Y	-.964	-.776	-.694
CENTROID X	-.327	-.394	-.601
CENTROID Y	.356	.168	.086
POA TO CENTROID in.	.484	.429	.607
MIN RADIUS	.289	.091	.196
MEAN RADIUS	.868	.729	.575
MAX RADIUS	1.799	1.778	.943
HORIZONTAL SPREAD	2.653	2.653	1.433
VERTICAL SPREAD	2.653	1.434	1.285
EXTREME SPREAD	2.963	2.920	1.598
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06535047

CENTERFIRE PATTERNS # 4

POR



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 10

HS = 2.508

VS = 1.834

GS = 2.644

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.272	1.134	1.059
MINIMUM X	:	-1.236	-1.142	-1.000
MAXIMUM Y	:	.816	.887	.876
MINIMUM Y	:	-1.018	-.947	-.959
CENTROID X	:	-.024	.114	-.028
CENTROID Y	:	.088	.017	.028
POR TO CENTROID in.	:	.091	.115	.048
MIN RADIUS	:	.397	.251	.388
MEAN RADIUS	:	.959	.888	.859
MAX RADIUS	:	1.390	1.430	1.314
HORIZONTAL SPREAD	:	2.508	2.276	2.059
VERTICAL SPREAD	:	1.834	1.834	1.834
EXTREME SPREAD	:	2.644	2.532	2.532
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Jun 1991

FILE:\PATTERNING\CENTERFIRE_PATT\08838047

CENTERFIRE PATTERNS # 5

FOR

1in circle

2in circle

3in circle

CENTROID +

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 10

HS = 2.403

VSR = 1.953

GS = 2.758

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.160	1.022	1.092
MINIMUM X	-1.243	-1.133	-1.063
MAXIMUM Y	.801	.799	.866
MINIMUM Y	-1.152	-1.063	-1.052
CENTROID X	.232	.370	.300
CENTROID Y	-.085	-.174	-.041
POA TO CENTROID in.	.247	.403	.302
MIN RADIUS	.626	.713	.578
MEAN RADIUS	1.045	.989	.947
MAX RADIUS	1.479	1.204	1.172
HORIZONTAL SPREAD	2.403	2.155	2.155
VERTICAL SPREAD	1.953	1.862	1.718
EXTREME SPREAD	2.758	2.280	2.263
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	