

C6636063

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

SERIAL NO.
C6636063

ORDER NO.
5716

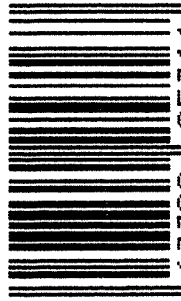
20

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



5716 C6636063

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636063

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	IC
615	Rollmark Caliber		APR 9 1991	LSI
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JH
	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		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-20-91	DH

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	6			5-21-91	DH
	G) Safety Off Force	3	4	3			5-21-91	DH
	H) Trigger Pull Test & Retainability						5-20-91	DH
	I) Firing Pin Indent	1.022	1.021	1.022			5-21-91	DH
	J) Assemble Stock						5/22/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/22/91	RW
	M) Iron Sight Alignment						5/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/22/91	RW
	O) Attach Scope to Rifle						5/22/91	RW
	P) Detach & Attach Scope 20 Times						5/22/91	RW
640	Gallery Target & Test						5/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/23/91	KT
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.37	2.32	2.38	2.30	2.35	6/1/91	GH
	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. C6636063DATE 5-20-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.24	2.51	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.20	2.59	2.32	
PULL #3	2.32	2.23	2.61	2.38	
PULL #4	2.34	2.25	2.49	2.30	
PULL #5	2.26	2.22	2.57	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.16		
PULL #2	3.15	3.04		
PULL #3	3.19	3.23		
PULL #4	3.28	3.13		
PULL #5	2.89	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.18		4.20
PULL #2	4.18	4.44		4.22
PULL #3	4.27	4.43		4.35
PULL #4	4.34	4.22		4.46
PULL #5	4.20	4.17		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636063
23 May 1991

CENTROIDAL DISTANCES

0 TO 1	.467388
1 TO 2	.356484
1 TO 3	.294165
1 TO 4	.697448
1 TO 5	.389166

 $\frac{1}{n} \sum_{i=1}^n x_i$

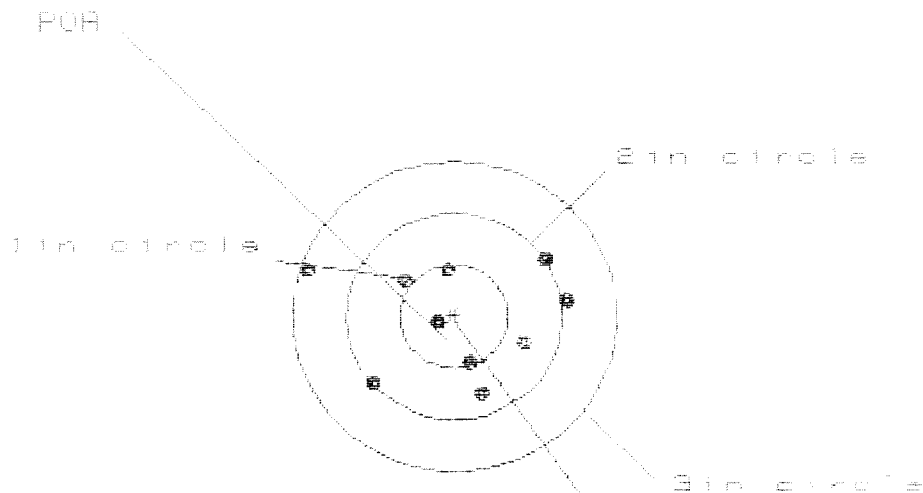
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0762
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2782
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .28692
THE AMR FOR THIS RIFLE IS: .912

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636063

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

GS = 2.409

SE = 1.218

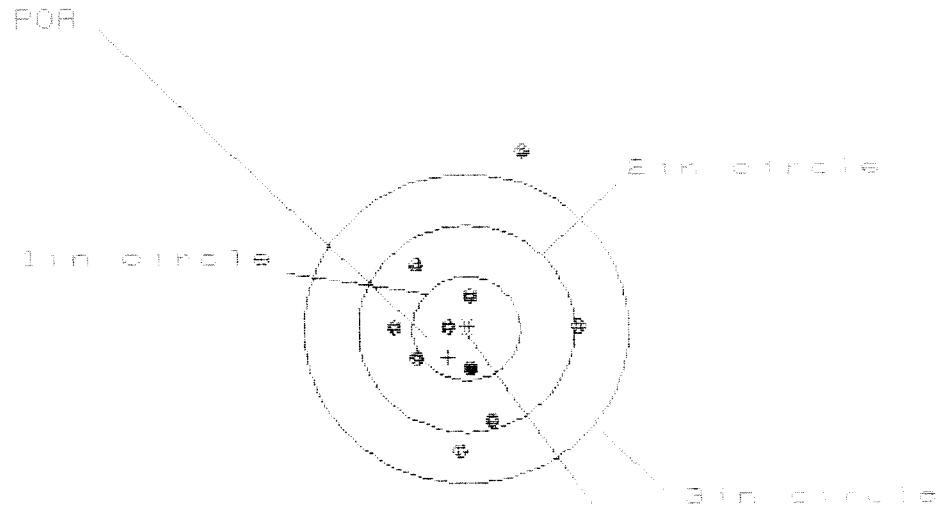
GS = 2.426

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.028	.875	.779
MINIMUM X	-1.381	-.907	-.798
MAXIMUM Y	.520	.574	.606
MINIMUM Y	-.698	-.644	-.612
CENTROID X	-.146	.007	-.102
CENTROID Y	.444	.390	.359
POA TO CENTROID in.	.468	.390	.373
MIN RADIUS	.129	.232	.183
MEAN RADIUS	.741	.658	.610
MAX RADIUS	1.464	1.067	.980
HORIZONTAL SPREAD	2.409	1.782	1.568
VERTICAL SPREAD	1.218	1.218	1.218
EXTREME SPREAD	2.426	1.960	1.936
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636063

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

ME = 1.692

VS = 2.860

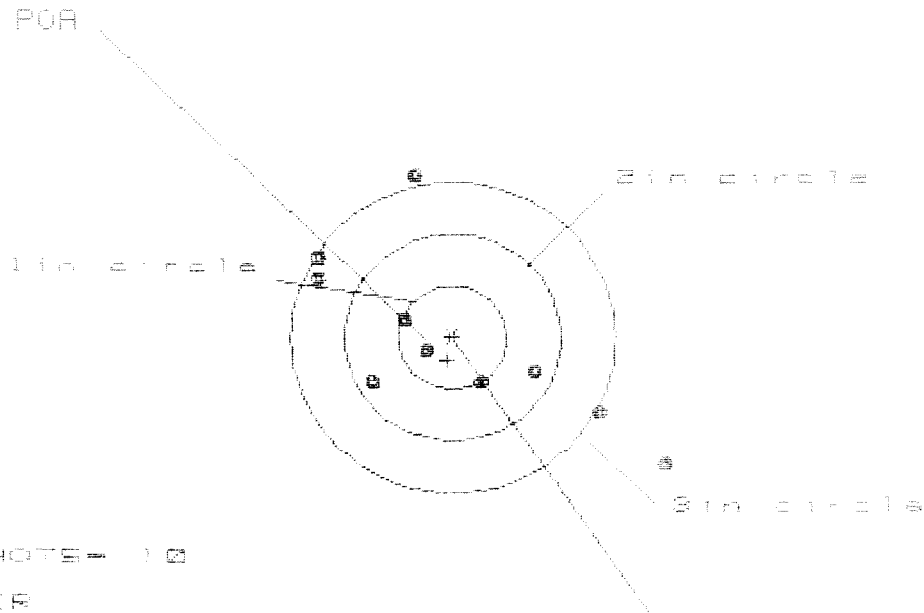
GS = 2.930

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.015	1.078	1.078
MINIMUM X	-1.677	-1.614	-1.615
MAXIMUM Y	1.716	.766	.647
MINIMUM Y	-1.144	-1.953	-1.845
CENTROID X	.170	.107	.107
CENTROID Y	.279	.088	.237
FOR TO CENTROID in.	.326	.138	.233
MIN RADIUS	.216	.185	.196
MEAN RADIUS	.769	.631	.578
MAX RADIUS	1.808	1.103	1.083
HORIZONTAL SPREAD	1.692	1.692	1.692
VERTICAL SPREAD	2.860	1.719	1.492
EXTREME SPREAD	2.930	1.761	1.693
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

23 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8636063

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 3.264

VS = 2.756

GS = 3.829

CENTROID

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.970	1.594	1.579
MINIMUM X	-1.294	-1.075	-1.090
MAXIMUM Y	1.578	1.447	.872
MINIMUM Y	-1.178	-.838	-.657
CENTROID X	.047	-.172	-.157
CENTROID Y	.222	.353	.172
POA TO CENTROID in.	.227	.393	.233
MIN RADIUS	.328	.198	.142
MEAN RADIUS	1.117	.953	.859
MAX RADIUS	2.296	1.861	1.711
HORIZONTAL SPREAD	3.264	2.669	2.669
VERTICAL SPREAD	2.756	2.285	1.530
EXTREME SPREAD	3.829	3.076	3.076
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS638063

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.208

VS = 2.192

GS = 2.865

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.089

1.203

1.077

MINIMUM X

:

-1.116

-1.002

-1.863

MAXIMUM Y

:

.680

.512

.414

MINIMUM Y

:

-1.512

-1.786

-1.734

CENTROID X

:

.099

-.015

.111

CENTROID Y

:

-.209

-.041

.057

POA TO CENTROID IN.

:

.232

.044

.124

MIN RADIUS

:

.226

.275

.264

MEAN RADIUS

:

.849

.700

.625

MAX RADIUS

:

1.826

1.273

1.085

HORIZONTAL SPREAD

:

2.285

2.205

1.940

VERTICAL SPREAD

:

2.192

1.296

1.148

EXTREME SPREAD

:

2.865

2.331

2.008

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636063

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 4

3 in - 7

HS - 2.870

VS - 2.528

GS - 3.267

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.618	1.710	1.512
MINIMUM X	:	-1.252	-1.160	-.946
MAXIMUM Y	:	1.535	.726	.791
MINIMUM Y	:	-.992	-.822	-.757
CENTROID X	:	.181	.089	-.125
CENTROID Y	:	.655	.485	.420
POA TO CENTROID in.	:	.680	.493	.438
MIN RADIUS	:	.261	.372	.186
MEAN RADIUS	:	1.084	.987	.851
MAX RADIUS	:	1.746	1.787	1.609
HORIZONTAL SPREAD	:	2.870	2.870	2.458
VERTICAL SPREAD	:	2.528	1.548	1.548
EXTREME SPREAD	:	3.267	3.163	2.779
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	