

C6636111

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.

MODEL 700™ H24

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

DUPONT

SERIAL NO.
C6636111

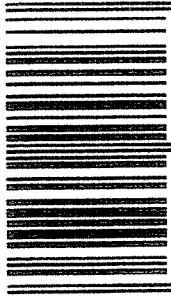
ORDER NO.
5716

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

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636111

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		CB
617	Drill and Tap Sight Holes	5 15 9 1		CB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/29/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/1/91	WB

op. #	BARBER M24 0037835	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/2			6/1/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			6/1/91	WB
	H) Trigger Pull Test & Retainability						6/1/91	WB
	I) Firing Pin Indent	.020	.0215	.021			6/1/91	WB
	J) Assemble Stock						6/3/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/3/91	RW
	M) Iron Sight Alignment						6/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	RW
	O) Attach Scope to Rifle						6/3/91	RW
	P) Detach & Attach Scope 20 Times						6/3/91	RW
640	Gallery Target & Test						6/3/91	KT
	A) Time							KT
	B) Malfunctions						6/3/91	KT
	C) Pierced Primers						6/3/91	KT
	D) Optical Clarity of Scope						6/3/91	KT
645	Inspect for Live Ammo						6/3/91	KT
655	Final Inspection						6-8-91	DH
	A) Headspace						6-8-91	82
	B) Trigger Pull	2.28	2.20	2.18	2.16	2.19	6-8-91	DH
	C) Function						6-8-91	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. C 6636111DATE 6/1/91TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.23	2.25	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.27	2.34	2.20	
PULL #3	2.33	2.22	2.26	2.18	
PULL #4	2.29	2.13	2.32	2.16	
PULL #5	2.34	2.32	2.41	2.19	
TOTAL	11.58	11.17	11.58		
AVG.	2.31	2.23	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.10		
PULL #2	3.46	3.10		
PULL #3	3.20	3.09		
PULL #4	3.21	3.12		
PULL #5	3.17	3.08		
TOTAL	15.93	15.49		
AVG.	3.19	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	3.95		4.29
PULL #2	4.03	4.07		4.26
PULL #3	4.04	4.04		4.38
PULL #4	4.06	3.95		4.29
PULL #5	4.03	3.95		4.38
TOTAL	20.20	19.96		21.50
AVG.	4.04	3.99		4.30

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636111
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.108046
1 TO	2	.300668
1 TO	3	.0693542
1 TO	4	.303442
1 TO	5	.027313

Fig. 1 POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0468
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0476957

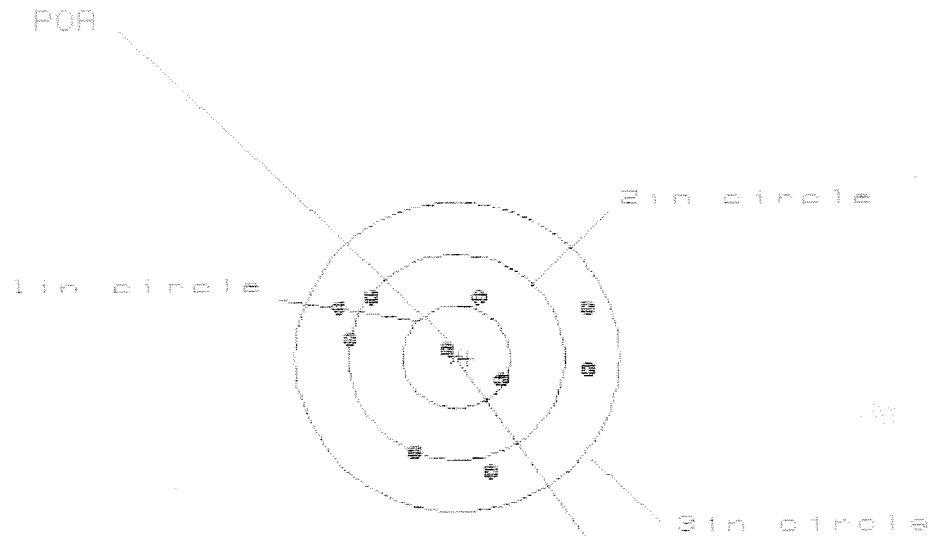
THE AMR FOR THIS RIFLE IS: 1.066

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB36/11

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.311

VS= 1.708

GS= 2.313

CENTROID #

PATTERN #

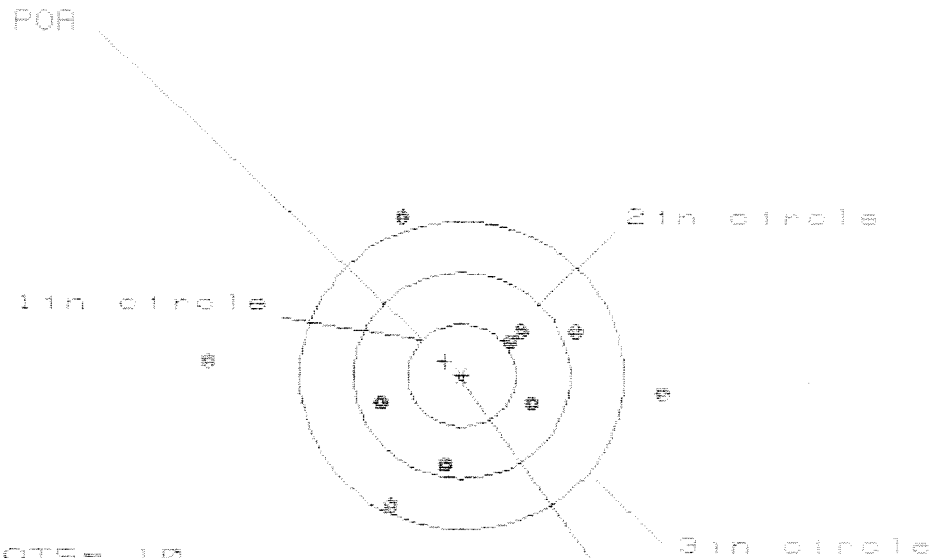
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	-1.238	-1.305	-.700
MINIMUM X	-1.073	-.936	-.772
MAXIMUM Y	.539	.658	.653
MINIMUM Y	-1.109	-1.050	-1.055
CENTROID X	-.107	-.244	-.408
CENTROID Y	.015	-.044	-.039
POA TO CENTROID in.	.108	.248	.409
MIN RADIUS	.116	.129	.235
MEAN RADIUS	.893	.837	.776
MAX RADIUS	1.347	1.306	1.196
HORIZONTAL SPREAD	2.311	2.241	1.472
VERTICAL SPREAD	1.708	1.708	1.708
EXTREME SPREAD	2.313	2.306	2.047
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536111

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 6

2in = 5

3in = 7

HS- 4.239

VS- 2.746

GS- 4.251

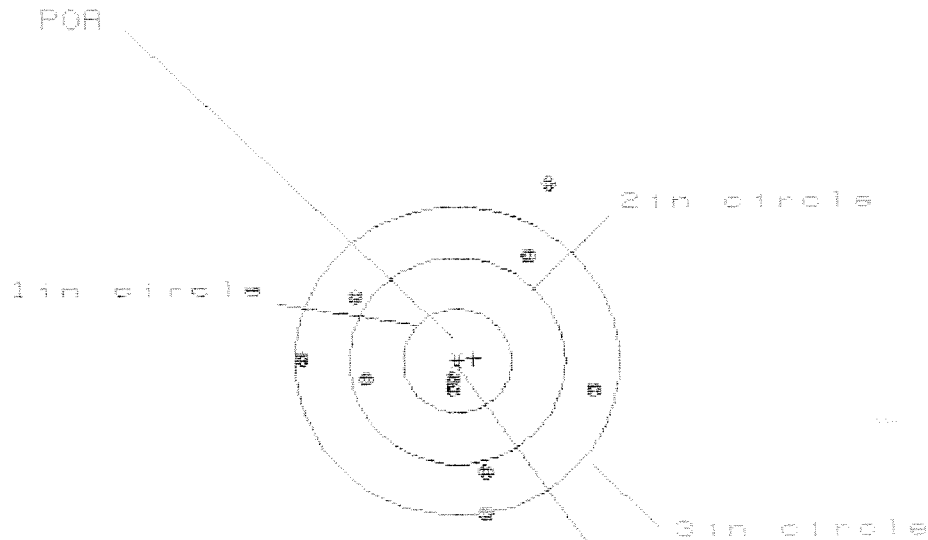
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.848	1.583	.982
MINIMUM X	-2.391	-1.029	-.832
MAXIMUM Y	1.495	1.589	1.487
MINIMUM Y	-1.251	-1.237	-1.259
CENTROID X	.153	.418	.221
CENTROID Y	-.136	-.150	-.128
POA TO CENTROID in.	.205	.445	.255
MIN RADIUS	.534	.381	.470
MEAN RADIUS	1.205	1.017	.963
MAX RADIUS	2.394	1.719	1.613
HORIZONTAL SPREAD	4.239	2.612	1.814
VERTICAL SPREAD	2.746	2.746	2.746
EXTREME SPREAD	4.251	2.938	2.749
NUMBER IN ONE INCH CIRCLE =	6	5	7
NUMBER IN TWO INCH CIRCLE =	6	5	7
NUMBER IN THREE INCH CIRCLE =	6	5	7

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FILE:/PATTERNING/CENTERFIRE_PATT/C8696111

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS = 2.751

VS = 3.225

GS = 3.281

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.304	1.403	1.451
MINIMUM X	-1.447	-1.348	-1.300
MAXIMUM Y	1.745	1.211	1.051
MINIMUM Y	-1.480	-1.286	-1.027
CENTROID X	-.158	-.257	-.305
CENTROID Y	-.023	-.217	-.057
POA TO CENTROID in.	.160	.336	.310
MIN RADIUS	.187	.031	.146
MEAN RADIUS	1.103	.951	.922
MAX RADIUS	1.959	1.426	1.476
HORIZONTAL SPREAD	2.751	2.751	2.751
VERTICAL SPREAD	3.225	2.497	2.078
EXTREME SPREAD	3.281	2.767	2.767
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636111

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 4.0669

VS= 2.417

GS= 4.088

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

-1.649

-1.381

.577

MINIMUM X

-2.420

-1.419

-1.247

MAXIMUM Y

1.481

1.421

1.296

MINIMUM Y

-.936

-.996

-1.071

CENTROID X

.184

.452

.280

CENTROID Y

-.071

-.011

.114

POA TO CENTROID in.

.197

.453

.382

MIN RADIUS

.268

.138

.300

MEAN RADIUS

1.069

.826

.755

MAX RADIUS

2.479

1.702

1.306

HORIZONTAL SPREAD

4.069

2.800

1.824

VERTICAL SPREAD

2.417

2.417

2.367

EXTREME SPREAD

4.088

3.115

2.467

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

7

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636111

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.001

VS= 1.943

GS= 3.300

PATTERN #	1	5	9
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.871	1.545	1.429
MINIMUM X	-1.130	-.922	-.858
MAXIMUM Y	1.056	1.111	1.006
MINIMUM Y	-.887	-.832	-.759
CENTROID X	-.118	-.326	-.210
CENTROID Y	-.010	-.065	.040
POB TO CENTROID in.	.118	.332	.214
MIN RADIUS	.210	.404	.314
MEAN RADIUS	1.060	.945	.905
MAX RADIUS	1.933	1.584	1.501
HORIZONTAL SPREAD	3.001	2.467	2.327
VERTICAL SPREAD	1.943	1.943	1.766
EXTREME SPREAD	3.300	2.542	2.542
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	