

C6636158

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

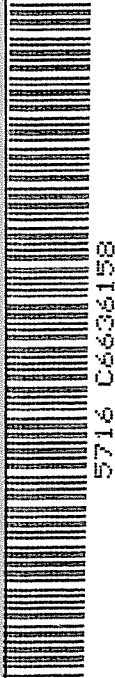
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6636158

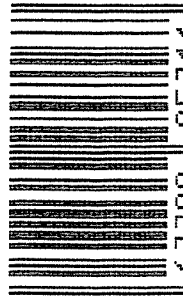
ORDER NO.
5716

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



5716 C6636158

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636158

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		Lcd
	Magnaflux Bolt	5 8 9 1		Lcd
615	Rollmark Caliber	5 8 9 1		GR.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		W.B.
620	Apply Coatings (Barrel Action)		5-31-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/11/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/11/91	KS
	C) Inspect Ejector Hole for Chamfer		4/11/91	KS
	D) Oil Firing Pin Ass'y		4/11/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/12-91	JA

op. #	BARBER M24 0038378	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-12-91	DH
	G) Safety Off Force	3	3	4			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-12-91	JH
	I) Firing Pin Indent	1.020	1.021	1.021			6-12-91	DH
	J) Assemble Stock						6-12-91	KS
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						4-12-91	KS
	M) Iron Sight Alignment						4-12-91	KS
	N) Detach Front & Rear Sights & place in numbered container						4-12-91	KS
	O) Attach Scope to Rifle						4-12-91	KS
	P) Detach & Attach Scope 20 Times						4-12-91	KS
640	Gallery Target & Test						6-13-91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						4-13-91	KT
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.28	2.49	2.35	2.28	2.39	6-14-91	JH
	C) Function						6-14-91	JH
660	Pack						6-20-91	VF

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

SERIAL NO. C6636158DATE 6-12-91TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.60	2.44	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.68	2.59	2.49	
PULL #3	2.48	2.47	2.55	2.35	
PULL #4	2.57	2.58	2.57	2.28	
PULL #5	2.61	2.53	2.50	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.44		
PULL #2	3.57	3.57		
PULL #3	3.34	3.60		
PULL #4	3.48	3.40		
PULL #5	3.47	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.62	4.24		4.36
PULL #2	4.26	4.25		4.18
PULL #3	4.21	4.23		4.46
PULL #4	4.22	4.28		4.31
PULL #5	4.33	4.38		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636158
13 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.156371
1 TO	2	.675298
1 TO	3	.278045
1 TO	4	.333862
1 TO	5	.174771

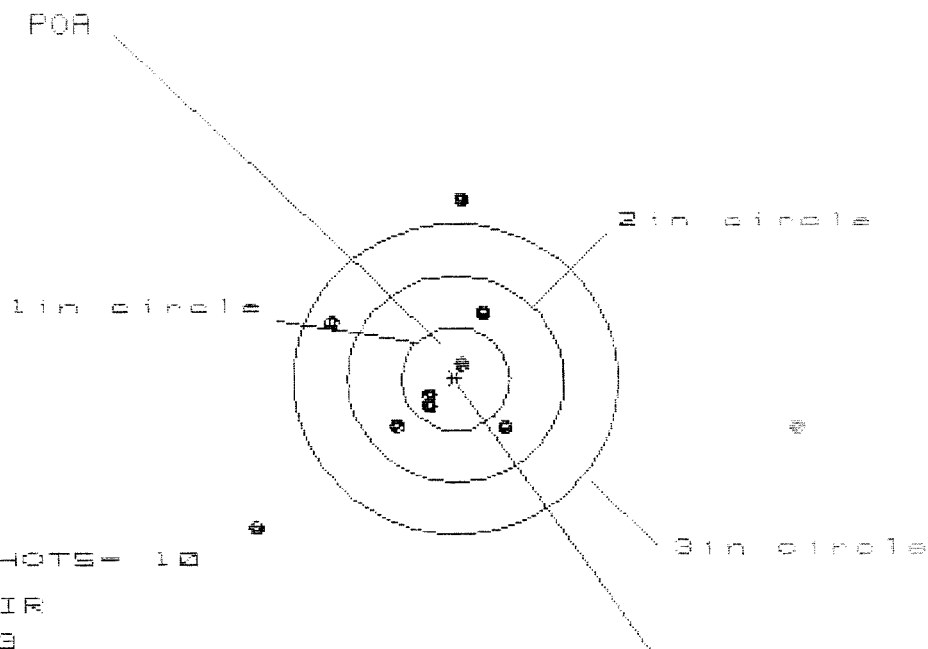
3rd <----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0018
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1548
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .175084
THE AMR FOR THIS RIFLE IS: 1.06

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6838158

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 4.997

VS = 3.244

GS = 5.109

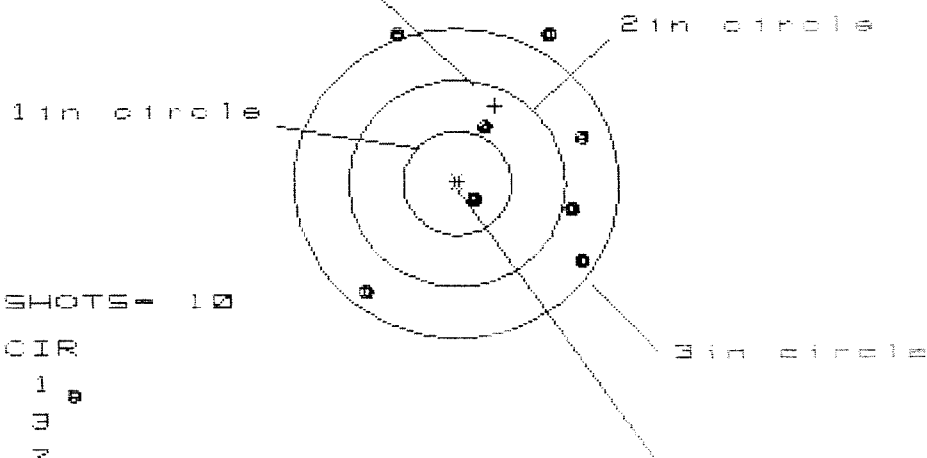
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	3.138	.830	.641
MINIMUM X	-1.859	-1.511	-.954
MAXIMUM Y	1.774	1.729	1.539
MINIMUM Y	-1.470	-1.515	-.733
CENTROID X	-.056	-.404	-.215
CENTROID Y	-.146	-.101	.088
POA TO CENTROID in.	.156	.417	.233
MIN RADIUS	.169	.193	.196
MEAN RADIUS	1.143	.906	.746
MAX RADIUS	3.164	2.140	1.561
HORIZONTAL SPREAD	4.997	2.341	1.595
VERTICAL SPREAD	3.244	3.244	2.272
EXTREME SPREAD	5.109	3.788	2.360
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6538158

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 4.754

VS= 3.497

GS= 5.642

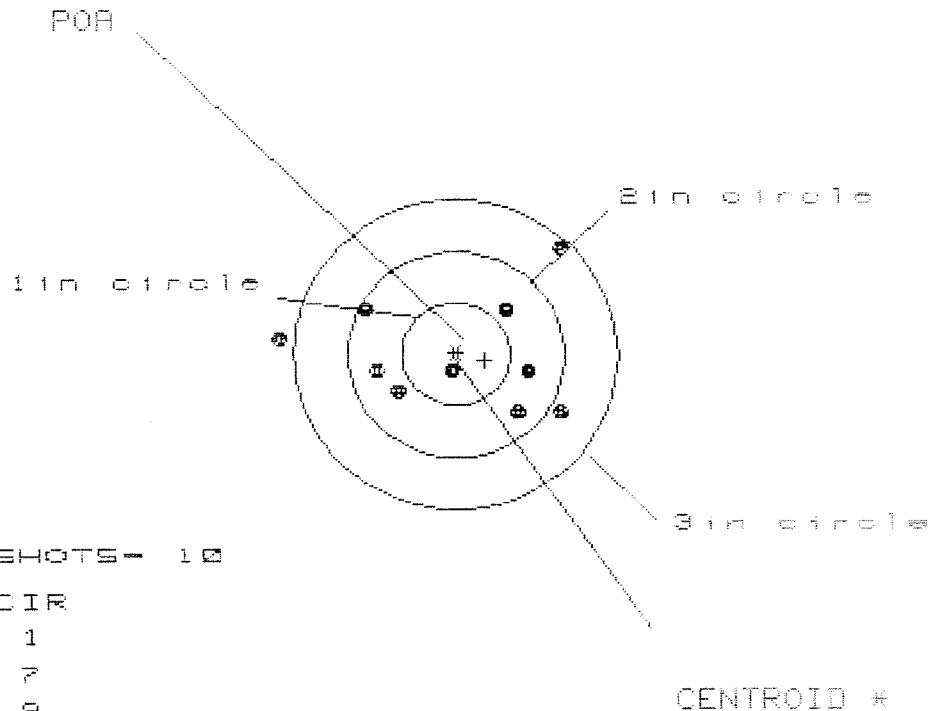
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.205	.810	.872
MINIMUM X	:	-3.549	-1.233	-1.171
MAXIMUM Y	:	1.425	1.195	1.343
MINIMUM Y	:	-2.072	-1.304	-1.156
CENTROID X	:	-.356	.039	-.023
CENTROID Y	:	-.751	-.521	-.669
POA TO CENTROID in.	:	.831	.522	.669
MIN RADIUS	:	.238	.298	.288
MEAN RADIUS	:	1.381	.952	.915
MAX RADIUS	:	4.110	1.795	1.646
HORIZONTAL SPREAD	:	4.754	2.043	2.043
VERTICAL SPREAD	:	3.497	2.499	2.499
EXTREME SPREAD	:	5.642	3.029	2.806
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



HS= 2.589

VS= 1.615

GS= 2.726

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	.824	.925
MINIMUM X	:	-1.588	-1.020	-.919
MAXIMUM Y	:	1.011	1.023	.617
MINIMUM Y	:	-.604	-.592	-.464
CENTROID X	:	-.264	-.087	-.188
CENTROID Y	:	.057	.045	-.083
POA TO CENTROID in.	:	.270	.098	.206
MIN RADIUS	:	.149	.268	.137
MEAN RADIUS	:	.884	.798	.713
MAX RADIUS	:	1.592	1.303	1.107
HORIZONTAL SPREAD	:	2.589	1.844	1.844
VERTICAL SPREAD	:	1.615	1.615	1.081
EXTREME SPREAD	:	2.726	2.133	2.133
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.746

VS = 2.840

GS = 3.070

CENTROID #

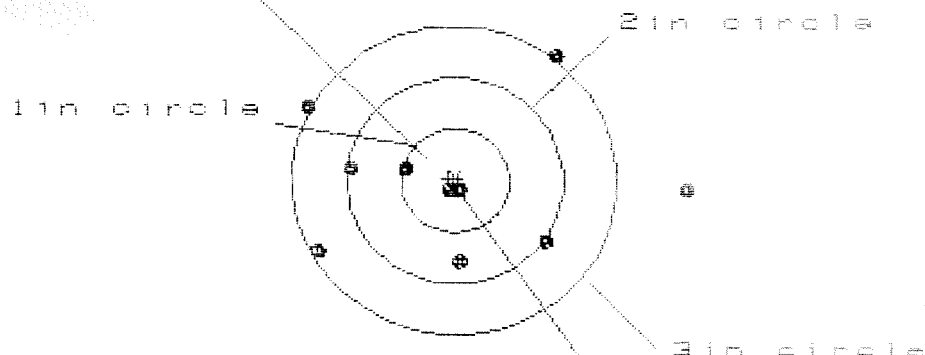
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.711	1.596	.758
MINIMUM X	:	-1.035	-.789	-.589
MAXIMUM Y	:	1.417	.989	1.014
MINIMUM Y	:	-1.423	-1.266	-1.241
CENTROID X	:	.186	.301	.101
CENTROID Y	:	.084	-.073	-.098
POA TO CENTROID in.	:	.204	.310	.141
MIN RADIUS	:	.223	.291	.227
MEAN RADIUS	:	.895	.801	.569
MAX RADIUS	:	1.754	1.609	1.241
HORIZONTAL SPREAD	:	2.746	2.385	1.347
VERTICAL SPREAD	:	2.840	2.255	2.255
EXTREME SPREAD	:	3.070	2.444	2.255
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POR



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 3.513

VS= 1.920

GS= 3.602

CENTROID #

PATTERN #	5	6	7
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.142	1.187	1.045
MINIMUM X	-1.371	-1.133	-1.133
MAXIMUM Y	1.172	1.168	1.263
MINIMUM Y	-0.748	-0.752	-0.657
CENTROID X	.063	-0.175	-0.033
CENTROID Y	-0.018	-0.014	-0.109
POR TO CENTROID in.	.066	.175	.114
MIN RADIUS	.066	.209	.058
MEAN RADIUS	.998	.859	.770
MAX RADIUS	2.142	1.665	1.639
HORIZONTAL SPREAD	3.513	2.320	2.178
VERTICAL SPREAD	1.920	1.920	1.920
EXTREME SPREAD	3.602	2.877	2.877
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		