

C6636161

MODEL 700TM M24

Model **SMS** TM

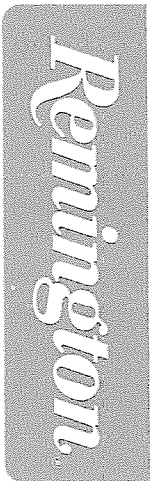
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

Remington®

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

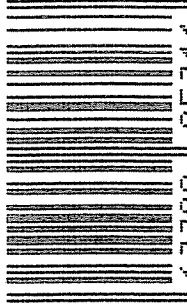
MODEL 700™ M24

SERIAL NO. C6636161

ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6636161

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636161

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Ked
	Magnaflux Bolt	5 8 9 1		Ked
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		KB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-31-91	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/17/91	KS
	C) Inspect Ejector Hole for Chamfer		7/17/91	KS
	D) Oil Firing Pin Ass'y		7/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-14-91	JS

op. #	BARBER M24 0038411	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-19-91	SM
	G) Safety Off Force	4	4	4			7-19-91	SM
	H) Trigger Pull Test & Retainability						7-19-91	SM
	I) Firing Pin Indent	.0215	.022	.022			7-19-91	SM
	J) Assemble Stock						7/22/91	KS
	K) Assemble Swivel Studs						7-24-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/22/91	KS
	M) Iron Sight Alignment						7/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	KS
	O) Attach Scope to Rifle						7/22/91	KS
	P) Detach & Attach Scope 20 Times						7/22/91	KS
640	Gallery Target & Test						7/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						7/23/91	KT
655	Final Inspection							
	A) Headspace						7-24-91	D/H
	B) Trigger Pull	2.57	2.56	2.50	2.48	2.46	7-24-91	SM
	C) Function						7-24-91	D/H
660	Pack						9-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-663461

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.16	2.57	2.54	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.69	2.60	2.56	
PULL #3	2.48	2.52	2.48	2.50	
PULL #4	2.52	2.53	2.55	2.48	
PULL #5	2.47	2.60	2.50	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.27		
PULL #2	3.27	3.38		
PULL #3	3.48	3.20		
PULL #4	3.26	3.42		
PULL #5	3.40	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.35		4.21
PULL #2	4.41	4.43		4.53
PULL #3	4.11	4.36		4.50
PULL #4	4.60	4.45		4.54
PULL #5	4.46	4.41		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 08036118
23 Jul 1991 6141

CENTROIDAL DISTANCES

0 TO	1	.361448
1 TO	2	.537306
1 TO	3	.752012
1 TO	4	.311448
1 TO	5	.425192

$\frac{1}{5}$ <----POA

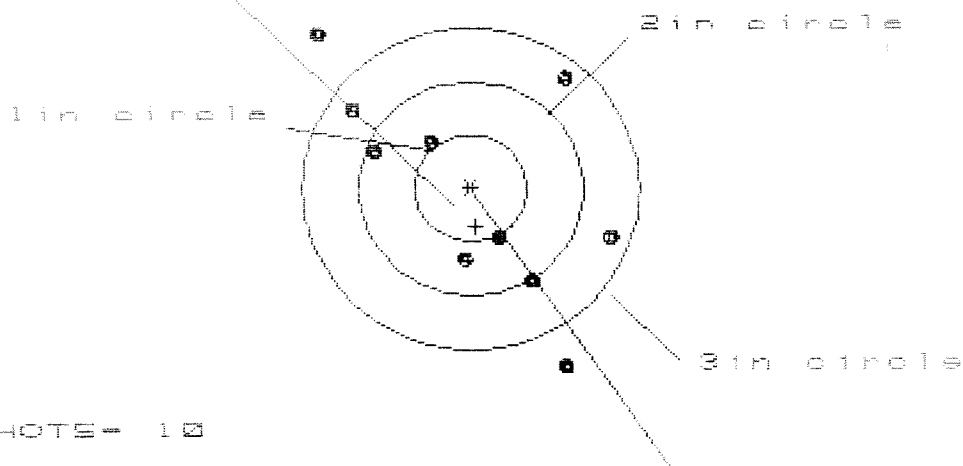
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0892
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0900304
THE AMR FOR THIS RIFLE IS: .8768

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636161

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 4

3 in = 2

HS = 2.578

VS = 3.043

GS = 3.735

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.222	1.071	1.154
MINIMUM X	-1.356	-1.226	-1.143
MAXIMUM Y	1.416	1.206	1.022
MINIMUM Y	-1.627	-1.469	-1.890
CENTROID X	-.042	.109	.026
CENTROID Y	.359	.201	.385
POA TO CENTROID in.	.361	.229	.386
MIN RADIUS	.533	.322	.523
MEAN RADIUS	1.147	1.027	.963
MAX RADIUS	1.961	1.610	1.329
HORIZONTAL SPREAD	2.578	2.297	2.297
VERTICAL SPREAD	3.043	2.675	1.912
EXTREME SPREAD	3.735	2.997	2.553
NUMBER IN ONE INCH CIRCLE =	4	4	4
NUMBER IN TWO INCH CIRCLE =	8	8	8
NUMBER IN THREE INCH CIRCLE =	10	9	8

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636161

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.473

VS= 4.250

GS= 4.255

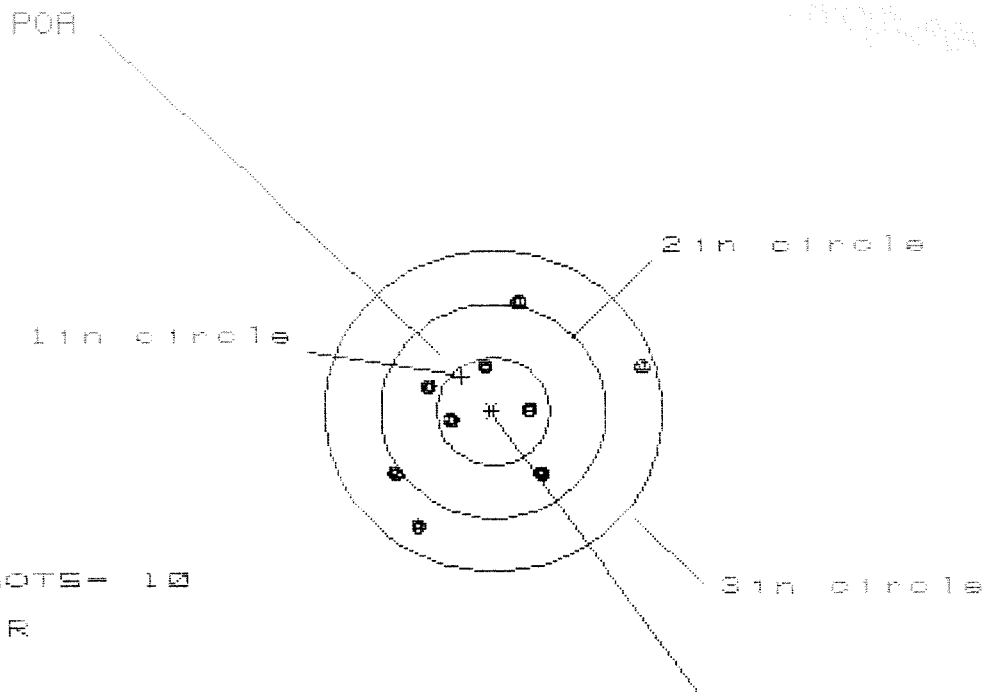
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.697	.723	.730
MINIMUM X	:	-.776	-.750	-.743
MAXIMUM Y	:	1.548	1.248	.673
MINIMUM Y	:	-2.702	-1.176	-1.020
CENTROID X	:	.185	.159	.152
CENTROID Y	:	-.128	.172	.016
POA TO CENTROID in.	:	.225	.234	.153
MIN RADIUS	:	.226	.324	.348
MEAN RADIUS	:	.983	.755	.686
MAX RADIUS	:	2.712	1.381	1.254
HORIZONTAL SPREAD	:	1.473	1.473	1.473
VERTICAL SPREAD	:	4.250	2.424	1.693
EXTREME SPREAD	:	4.255	2.515	2.206
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.223

VS= 2.074

GS= 2.492

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.329	.521	.459
MINIMUM X	-.894	-.747	-.809
MAXIMUM Y	1.009	1.059	.932
MINIMUM Y	-1.065	-1.015	-.645
CENTROID X	.277	.130	.192
CENTROID Y	-.322	-.372	-.245
POA TO CENTROID in.	.425	.394	.311
MIN RADIUS	.300	.271	.377
MEAN RADIUS	.750	.677	.601
MAX RADIUS	1.403	1.132	1.035
HORIZONTAL SPREAD	2.223	1.268	1.268
VERTICAL SPREAD	2.074	2.074	1.577
EXTREME SPREAD	2.492	2.252	1.935
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 10

HS = 1.940

VS = 1.123

GS = 1.963

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.902	.787	.855
MINIMUM X	:	-1.038	-.805	-.737
MAXIMUM Y	:	.674	.645	.287
MINIMUM Y	:	-.449	-.478	-.397
CENTROID X	:	.120	.235	.167
CENTROID Y	:	.093	.122	.042
POA TO CENTROID in.	:	.152	.265	.172
MIN RADIUS	:	.067	.112	.008
MEAN RADIUS	:	.587	.519	.474
MAX RADIUS	:	1.071	.908	.859
HORIZONTAL SPREAD	:	1.940	1.592	1.592
VERTICAL SPREAD	:	1.123	1.123	.684
EXTREME SPREAD	:	1.963	1.718	1.647
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Jul 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.184

VS = 2.381

GS = 2.546

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.017	1.087	1.214
MINIMUM X	:	-1.167	-1.097	-.970
MAXIMUM Y	:	1.413	.875	.773
MINIMUM Y	:	-.968	-.811	-.737
CENTROID X	:	-.094	-.164	-.291
CENTROID Y	:	-.063	-.220	-.118
POA TO CENTROID in.	:	.113	.274	.314
MIN RADIUS	:	.455	.323	.267
MEAN RADIUS	:	.917	.817	.724
MAX RADIUS	:	1.549	1.299	1.363
HORIZONTAL SPREAD	:	2.184	2.184	2.184
VERTICAL SPREAD	:	2.381	1.686	1.510
EXTREME SPREAD	:	2.546	2.546	2.459
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	