

C6636166

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

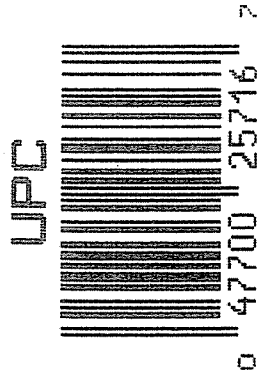
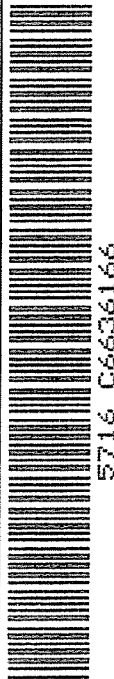
DUPONT
REG. U.S. PAT. & TM. OFF.

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

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

SERIAL NO.
 C6636166

ORDER NO.
5716



Stock
Repaired

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636166

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 6 9 1		KCD
	Magnaflux Bolt	5 6 9 1		KCD
615	Rollmark Caliber	5 6 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		KB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/91	KS
	C) Inspect Ejector Hole for Chamfer		6/4/91	KS
	D) Oil Firing Pin Ass'y		6/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	SL

op. #	BARBER - M24 0038476	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-10-91	SH
	G) Safety Off Force	3	3	3			6-10-91	SH
	H) Trigger Pull Test & Retainability						6-10-91	SH
	I) Firing Pin Indent	1022	1022	1022			6-10-91	SH
	J) Assemble Stock						6/10/91	KS
	K) Assemble Swivel Studs						6-13-91	AC
	L) Attach Front and Rear Sight Assemblies						6/10/91	KS
	M) Iron Sight Alignment						6/10/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/10/91	KS
	O) Attach Scope to Rifle						6/10/91	KS
	P) Detach & Attach Scope 20 Times						6/10/91	KS
640	Gallery Target & Test						6/11/91	KT
	A) Time						6/11/91	KT
	B) Malfunctions						6/11/91	KT
	C) Pierced Primers						6/11/91	KT
	D) Optical Clarity of Scope						6/11/91	KT
645	Inspect for Live Ammo						6/11/91	KT
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.34	2.39	2.41	2.40	2.44	6-13-91	SH
	C) Function						6-13-91	AC
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. C-6636166

DATE 6-10-91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.32	2.59	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.54	2.54	2.39	
PULL #3	2.56	2.60	2.50	2.41	
PULL #4	2.51	2.48	2.43	2.40	
PULL #5	2.59	2.53	2.43	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.50		
PULL #2	3.44	3.40		
PULL #3	3.33	3.35		
PULL #4	3.30	3.38		
PULL #5	3.30	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.37		4.30
PULL #2	4.23	4.35		4.19
PULL #3	4.29	4.26		4.31
PULL #4	4.30	4.32		4.24
PULL #5	4.31	4.41		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636166
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.204805
1 TO	2	.475937
1 TO	3	.225788
1 TO	4	.300262
1 TO	5	.251829

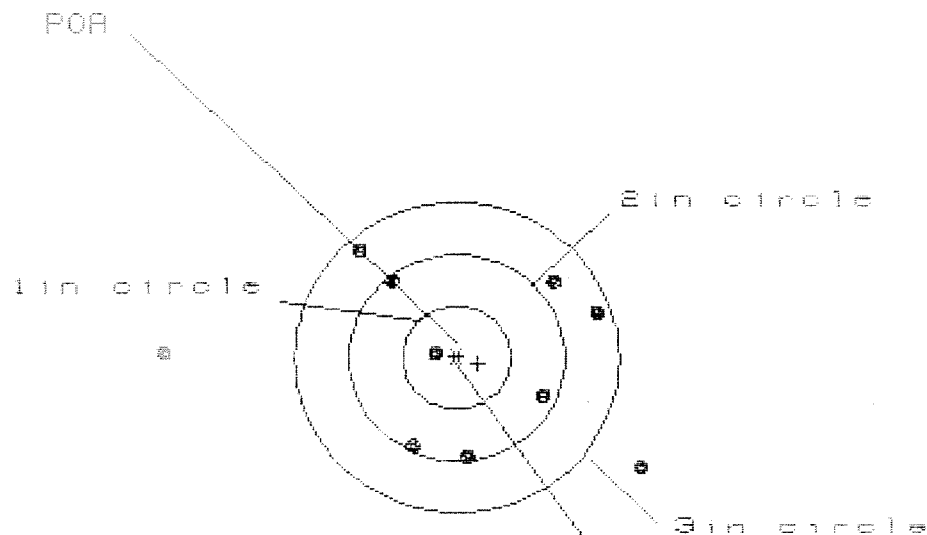
$\frac{E}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0624
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0908282
THE AMR FOR THIS RIFLE IS: 1.05

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C883818E

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 4.367

VS= 2.079

GS= 4.502

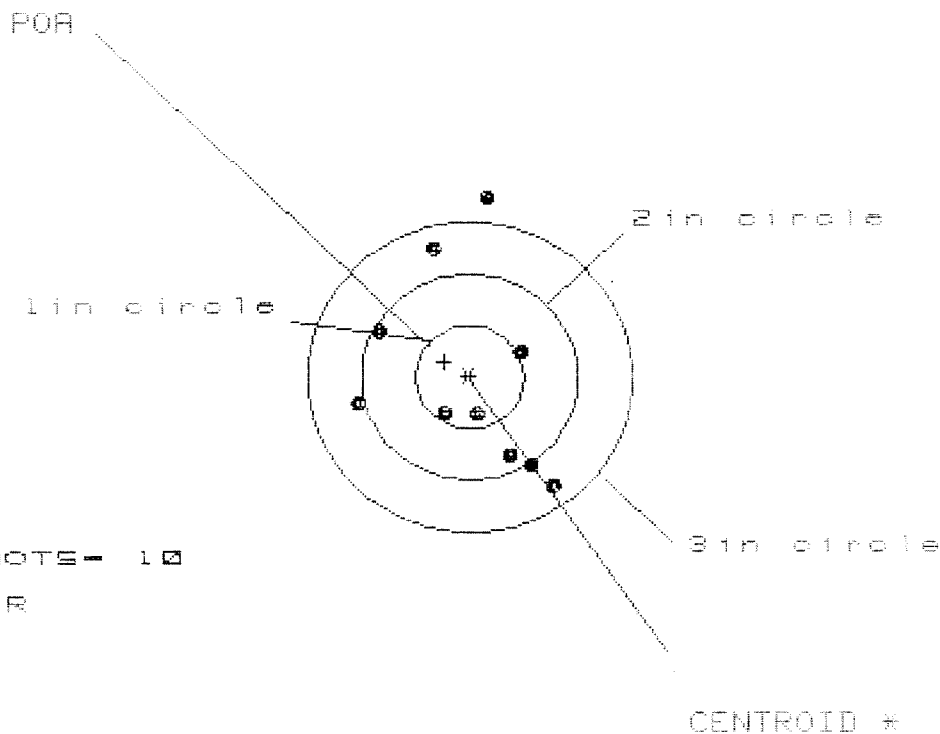
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.648	1.346	1.149
MINIMUM X	-2.719	-1.229	-1.061
MAXIMUM Y	1.072	1.082	.957
MINIMUM Y	-1.007	-1.997	-1.038
CENTROID X	-.197	.105	-.063
CENTROID Y	.056	.046	.171
POA TO CENTROID in.	.205	.115	.182
MIN RADIUS	.157	.458	.304
MEAN RADIUS	1.239	1.062	.972
MAX RADIUS	2.721	1.675	1.429
HORIZONTAL SPREAD	4.367	2.575	2.210
VERTICAL SPREAD	2.079	2.079	1.995
EXTREME SPREAD	4.502	3.310	2.295
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

11 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.755

VS= 2.793

GS= 2.860

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.757	.773	.709
MINIMUM X	-.998	-.982	-.886
MAXIMUM Y	1.735	1.428	1.320
MINIMUM Y	-1.058	-.865	-.790
CENTROID X	.233	.217	.121
CENTROID Y	-.148	-.341	-.233
POA TO CENTROID in.	.276	.404	.262
MIN RADIUS	.371	.185	.260
MEAN RADIUS	.951	.817	.786
MAX RADIUS	1.741	1.464	1.339
HORIZONTAL SPREAD	1.755	1.755	1.595
VERTICAL SPREAD	2.793	2.293	2.110
EXTREME SPREAD	2.860	2.540	2.307
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 7

HS = 2.804

VS = 2.220

GS = 3.134

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.131	1.113	.919
MINIMUM X	:	-1.673	-1.547	-1.618
MAXIMUM Y	:	.941	.799	.797
MINIMUM Y	:	-1.279	-.928	-.930
CENTROID X	:	-.269	-.395	-.201
CENTROID Y	:	-.158	-.016	-.014
POA TO CENTROID in.	:	.312	.395	.202
MIN RADIUS	:	.166	.042	.206
MEAN RADIUS	:	.974	.866	.779
MAX RADIUS	:	1.707	1.547	1.620
HORIZONTAL SPREAD	:	2.804	2.660	2.537
VERTICAL SPREAD	:	2.220	1.727	1.727
EXTREME SPREAD	:	3.134	2.747	2.600
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Jun 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 5

3 in - 8

HS= 2.155

VS= 2.886

GS= 2.889

CENTROID *

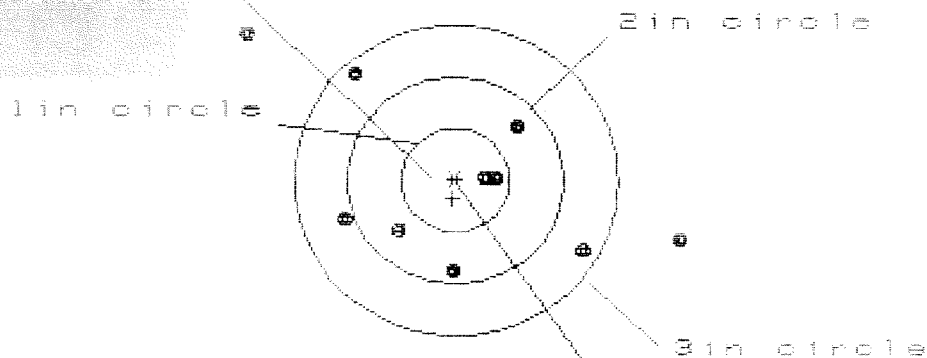
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.683	.519	.479
MINIMUM X	-1.472	-.596	-.636
MAXIMUM Y	1.255	1.172	.968
MINIMUM Y	-1.551	-1.634	-1.015
CENTROID X	-.123	.041	.081
CENTROID Y	-.235	-.152	.052
POA TO CENTROID in.	.265	.157	.096
MIN RADIUS	.485	.339	.393
MEAN RADIUS	.944	.824	.695
MAX RADIUS	1.649	1.665	1.198
HORIZONTAL SPREAD	2.155	1.115	1.115
VERTICAL SPREAD	2.886	2.886	1.983
EXTREME SPREAD	2.889	2.889	2.030
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

01 Jun 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 4.014

VS= 2.326

GS= 4.500

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.063	1.846	1.181
MINIMUM X	-1.951	-1.195	-.964
MAXIMUM Y	1.420	1.179	1.122
MINIMUM Y	-.906	-.749	-.806
CENTROID X	.026	.243	.013
CENTROID Y	.173	.016	.073
POA TO CENTROID in.	.175	.244	.074
MIN RADIUS	.307	.182	.336
MEAN RADIUS	1.142	.961	.852
MAX RADIUS	2.413	1.901	1.475
HORIZONTAL SPREAD	4.014	3.041	2.146
VERTICAL SPREAD	2.326	1.928	1.928
EXTREME SPREAD	4.500	3.447	2.708
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	