

C6636167

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™ M24

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

SERIAL NO.
C6636167

ORDER NO.
5716

20


5716 C6636167

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

UPC


0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636167

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	u
615	Rollmark Caliber		4/10/91	JS
617	Drill and Tap Sight Holes		APR 19 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	JA

op. #	BARBER - M24 0038487 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/24/91	DL
	G) Safety Off Force	4	4	4			5/24/91	DL
	H) Trigger Pull Test & Retainability						5/24/91	DL
	I) Firing Pin Indent	10225	10225	10225			5/24/91	DL
	J) Assemble Stock						5/25/91	KS
	K) Assemble Swivel Studs						6-91	NH
	L) Attach Front and Rear Sight Assemblies						5/25/91	KS
	M) Iron Sight Alignment						5/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	KS
	O) Attach Scope to Rifle						5/25/91	KS
	P) Detach & Attach Scope 20 Times						5/25/91	KS
640	Gallery Target & Test						5/29/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/29/91	KT
655	Final Inspection							
	A) Headspace						6-91	NH
	B) Trigger Pull	2.34	2.49	2.49	2.50	2.76	6/1/91	DL
	C) Function						6-91	NH
660	Pack						6-20-91	NH

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

SERIAL NO. 6636167DATE 5/24/81TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.31	2.35	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.36	2.38	2.49	
PULL #3	2.30	2.34	2.38	2.49	
PULL #4	2.29	2.34	2.28	2.50	
PULL #5	2.30	2.33	2.35	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.36		
PULL #2	3.54	3.33		
PULL #3	3.32	3.32		
PULL #4	3.34	3.18		
PULL #5	3.33	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.25		4.43
PULL #2	4.36	4.38		4.43
PULL #3	4.36	4.16		4.36
PULL #4	4.38	4.39		4.46
PULL #5	4.32	4.40		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636167
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.247952
1 TO	2	.406533
1 TO	3	.394069
1 TO	4	.325748
1 TO	5	.211483

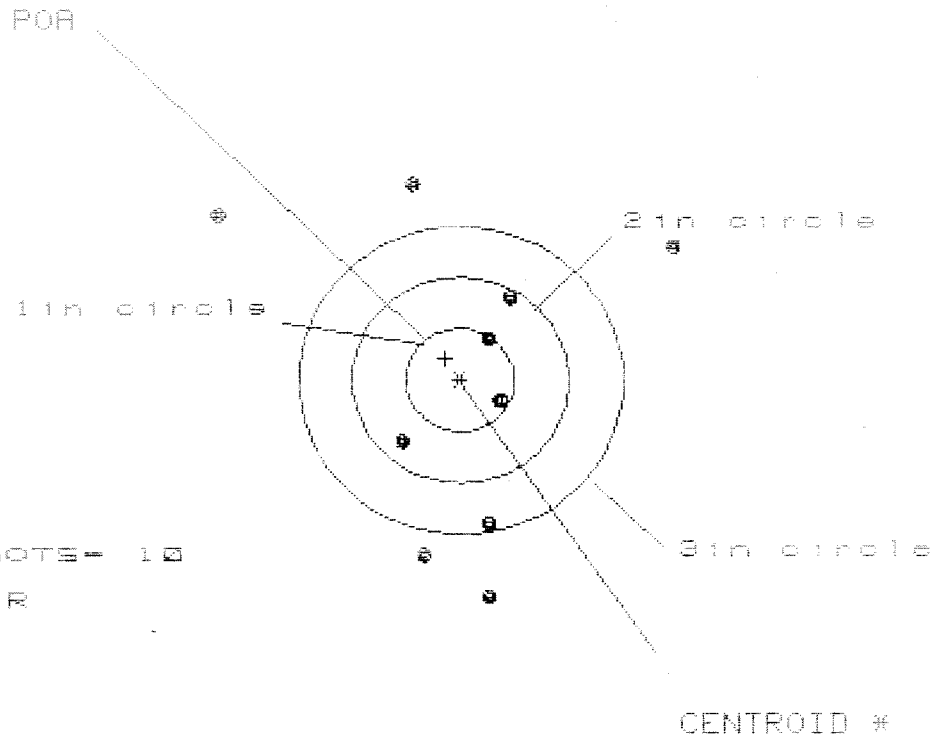
←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0666
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0646
THE RESULTING AVERAGE PC. RADIUS FOR THIS RIFLE IS: .0927832
THE AMR FOR THIS RIFLE IS: 1.113

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636167

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 5

HS = 4.1277

VS = 4.008

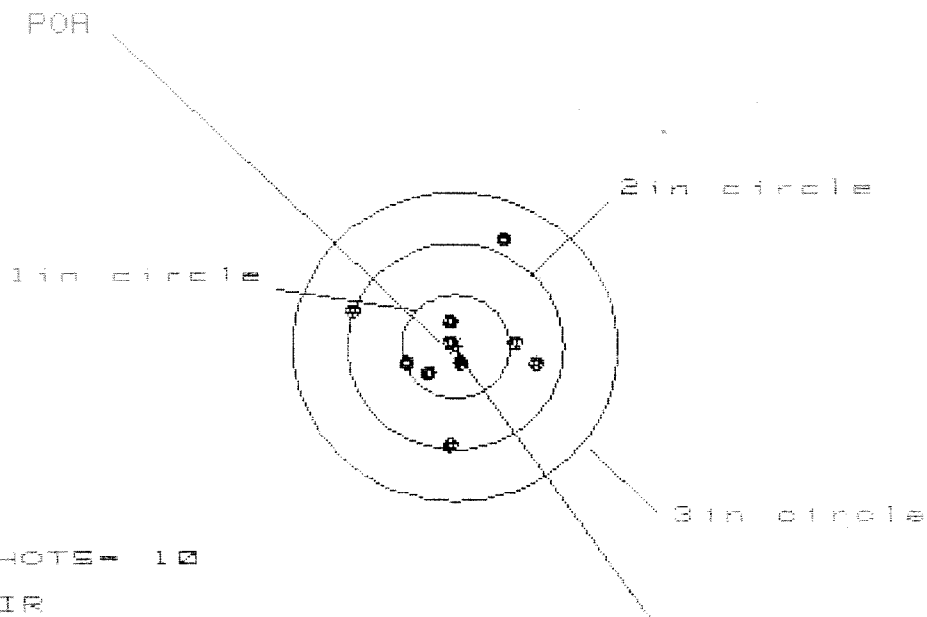
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PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.005	1.752	.481
MINIMUM X	-2.272	-.813	-.594
MAXIMUM Y	1.911	2.092	2.277
MINIMUM Y	-2.097	-1.916	-1.731
CENTROID X	.138	.391	.172
CENTROID Y	-.206	-.387	-.572
POA TO CENTROID in.	.248	.550	.597
MIN RADIUS	.444	.152	.381
MEAN RADIUS	1.497	1.310	1.182
MAX RADIUS	2.796	2.294	2.317
HORIZONTAL SPREAD	4.277	2.565	.995
VERTICAL SPREAD	4.008	4.008	4.008
EXTREME SPREAD	4.491	4.057	4.057
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

29 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.702

VS= 1.998

GS= 2.047

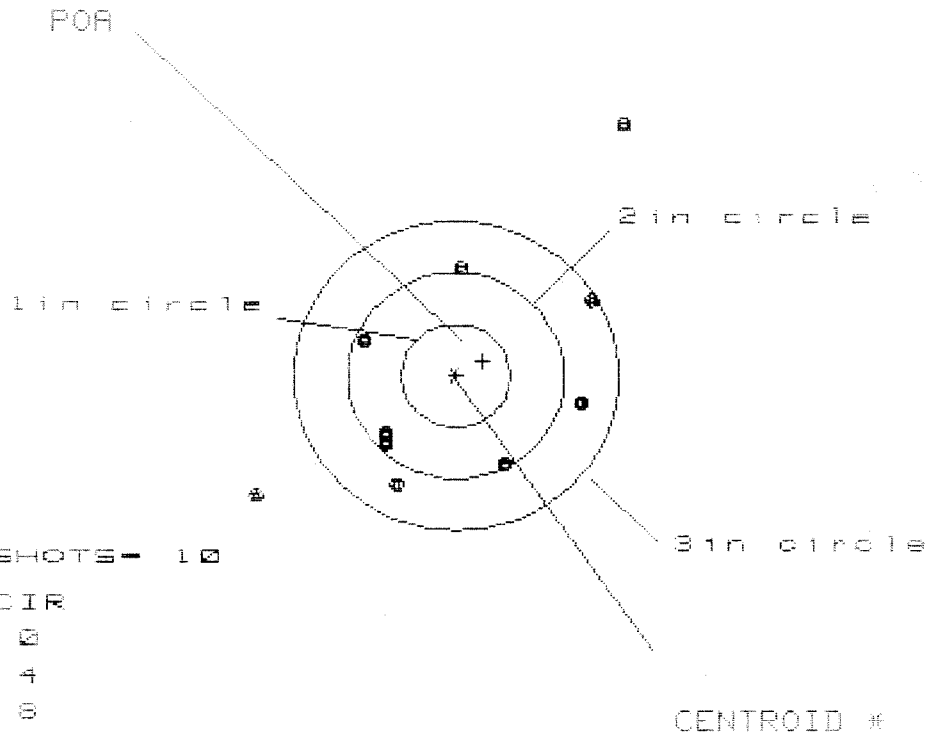
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.715	.760	.642
MINIMUM X	-.987	-.942	-.513
MAXIMUM Y	1.066	.461	.456
MINIMUM Y	-.932	-.813	-.756
CENTROID X	-.047	-.093	.025
CENTROID Y	.156	.037	-.020
POA TO CENTROID in.	.163	.100	.032
MIN RADIUS	.021	.076	.056
MEAN RADIUS	.573	.501	.437
MAX RADIUS	1.142	1.048	.763
HORIZONTAL SPREAD	1.702	1.702	1.155
VERTICAL SPREAD	1.998	1.274	1.212
EXTREME SPREAD	2.047	1.782	1.212
NUMBER IN ONE INCH CIRCLE	= 5		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

29 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.374

VS= 3.672

GS= 4.987

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.574	1.400	1.197
MINIMUM X	-1.800	-1.625	-0.886
MAXIMUM Y	2.491	1.310	1.197
MINIMUM Y	-1.181	-0.904	-0.899
CENTROID X	-0.251	-0.426	-0.223
CENTROID Y	-0.143	-0.420	-0.307
POA TO CENTROID in.	0.289	0.598	0.379
MIN RADIUS	0.849	0.552	0.784
MEAN RADIUS	1.354	1.110	1.033
MAX RADIUS	2.947	1.860	1.490
HORIZONTAL SPREAD	3.374	3.025	2.083
VERTICAL SPREAD	3.672	2.214	2.096
EXTREME SPREAD	4.987	3.575	2.489
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

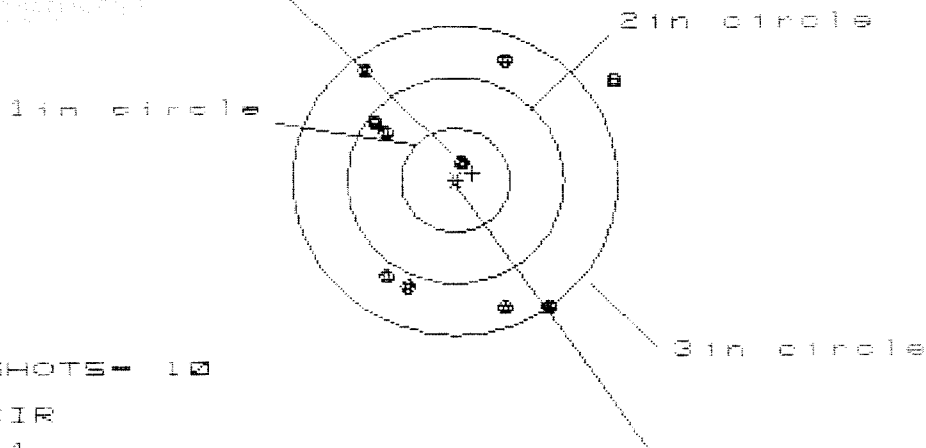
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CENTERFIRE PATTERNS

4

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

CENTROID #

HS= 2.229

VS= 2.428

GS= 2.870

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.421	1.051	.766
MINIMUM X	-.808	-.650	-.519
MAXIMUM Y	1.187	1.290	1.149
MINIMUM Y	-1.241	-1.138	-1.279
CENTROID X	-.158	-.316	-.447
CENTROID Y	-.870	-.173	-.032
POA TO CENTROID in.	.173	.360	.448
MIN RADIUS	.200	.352	.350
MEAN RADIUS	1.134	1.059	.965
MAX RADIUS	1.698	1.543	1.488
HORIZONTAL SPREAD	2.229	1.701	1.285
VERTICAL SPREAD	2.428	2.428	2.428
EXTREME SPREAD	2.870	2.870	2.648
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

29 May 1991

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CENTERFIRE PATTERNS

5

POA

2in circle

1in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.248

VS= 2.425

GS= 2.667

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.300	1.355	1.225
MINIMUM X	-.948	-.893	-.723
MAXIMUM Y	1.139	.997	1.027
MINIMUM Y	-1.286	-.848	-.818
CENTROID X	-.015	-.070	-.240
CENTROID Y	-.060	.082	.052
POA TO CENTROID in.	.062	.108	.245
MIN RADIUS	.670	.723	.594
MEAN RADIUS	1.009	.963	.872
MAX RADIUS	1.379	1.377	1.233
HORIZONTAL SPREAD	2.248	2.248	1.948
VERTICAL SPREAD	2.425	1.845	1.845
EXTREME SPREAD	2.667	2.285	1.989
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	10	