

C6636178

MODEL 700TM M24

Model **SMS** TM

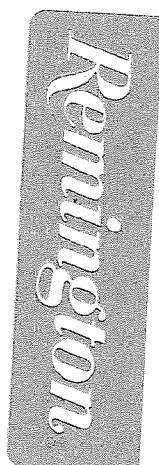
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

MODEL 700™ M24

SERIAL NO. C6636178

ORDER NO. 5716

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

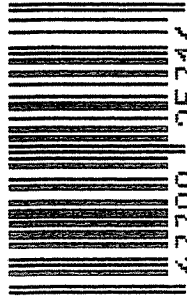
20

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



5716 C6636178

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636178

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	KCR
	Magnaflux Bolt	5 8	9 1	KCR
615	Rollmark Caliber	5 8	9 1	GB
617	Drill and Tap Sight Holes	5 15	9 1	LB
618	Polish Barrel	5 15	9 1	WB
620	Apply Coatings (Barrel Action)		5-29-91	TH
	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		6-4-91	GB

op. #	BARBER M24 0038608	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-4-91	QU
	G) Safety Off Force	3	3	3			6-4-91	QU
	H) Trigger Pull Test & Retainability						6-4-91	QU
	I) Firing Pin Indent	.0225	.022	.022			6-4-91	QU
	J) Assemble Stock						6-5-91	RW
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6-5-91	RW
	M) Iron Sight Alignment						6-5-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-5-91	RW
	O) Attach Scope to Rifle						6-5-91	RW
	P) Detach & Attach Scope 20 Times						6-5-91	RW
640	Gallery Target & Test						6-6-91	AC
	A) Time						6-6-91	AC
	B) Malfunctions						6-6-91	AC
	C) Pierced Primers						6-6-91	AC
	D) Optical Clarity of Scope						6-6-91	AC
645	Inspect for Live Ammo						6-6-91	AC
655	Final Inspection						6-8-91	D/H
	A) Headspace							
	B) Trigger Pull	2.39	2.39	2.50	2.51	2.57	6-8-91	QU
	C) Function						6-8-91	D/H
660	Pack						6-20-91	RF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636178
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.254751
1 TO	2	.387675
1 TO	3	.264121
1 TO	4	.0434166
1 TO	5	.0210238

2.4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .150877
THE AMR FOR THIS RIFLE IS: .9688

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08536178

CENTERFIRE PATTERNS

1

POB

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 2.199

VS = 1.992

GS = 2.201

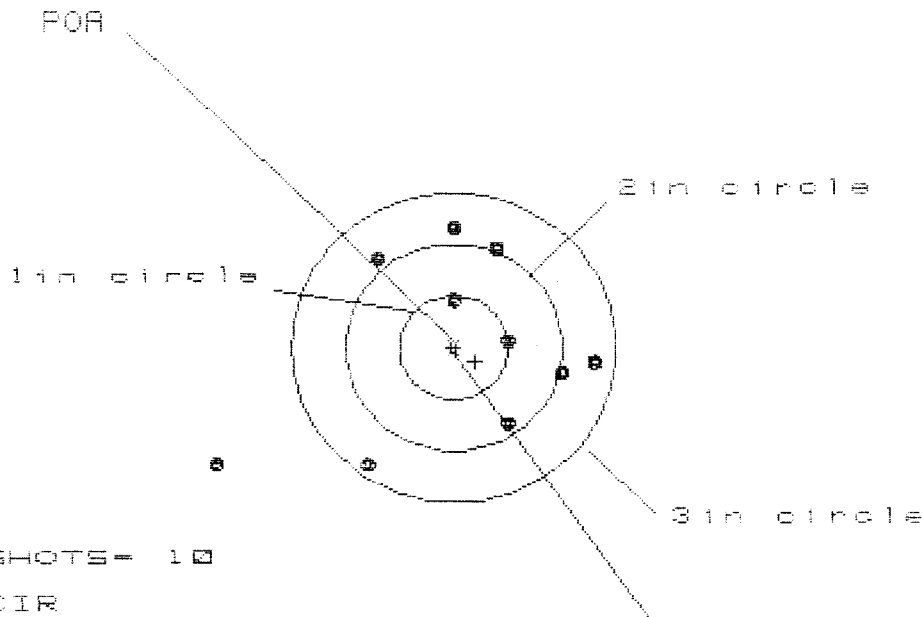
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.081	1.013	.865
MINIMUM X	-1.118	-1.186	-.890
MAXIMUM Y	1.187	.820	.879
MINIMUM Y	-.805	-.673	-.614
CENTROID X	.187	.255	.403
CENTROID Y	.173	.041	-.018
POB TO CENTROID in.	.254	.258	.404
MIN RADIUS	.485	.450	.353
MEAN RADIUS	.939	.871	.804
MAX RADIUS	1.337	1.275	1.122
HORIZONTAL SPREAD	2.199	2.199	1.755
VERTICAL SPREAD	1.992	1.493	1.493
EXTREME SPREAD	2.201	2.201	1.947
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636178

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.550

VS= 2.292

GS= 3.682

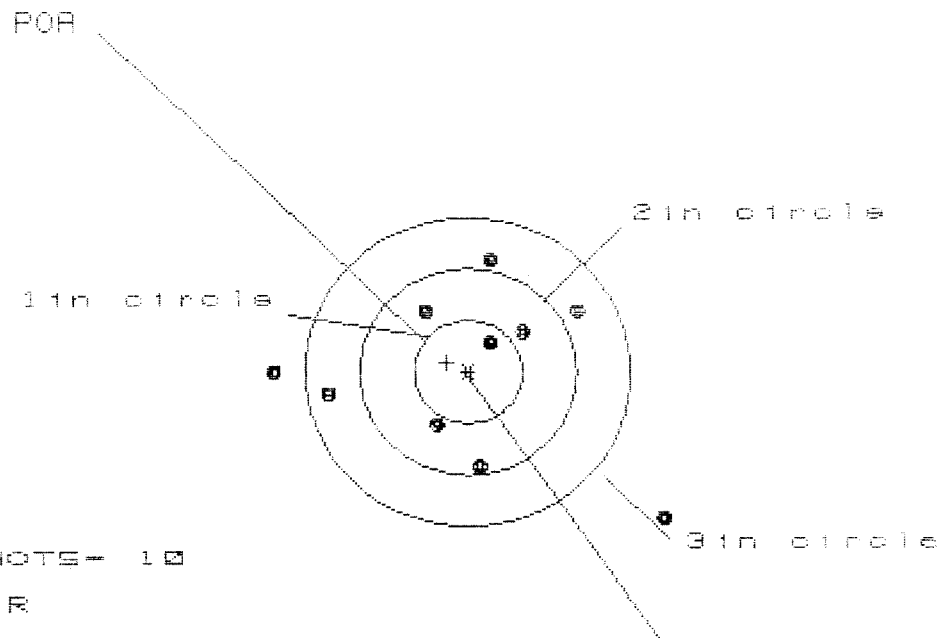
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.093	.958
MINIMUM X	:	-2.211	-1.083	-1.061
MAXIMUM Y	:	1.134	1.006	.848
MINIMUM Y	:	-1.158	-1.258	-1.029
CENTROID X	:	-.199	.047	.182
CENTROID Y	:	.137	.265	.423
POA TO CENTROID in.	:	.242	.269	.460
MIN RADIUS	:	.452	.262	.260
MEAN RADIUS	:	1.136	.914	.794
MAX RADIUS	:	2.496	1.660	1.223
HORIZONTAL SPREAD	:	3.550	2.176	2.019
VERTICAL SPREAD	:	2.292	2.264	1.877
EXTREME SPREAD	:	3.682	2.417	2.288
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.643

VS= 2.475

GS= 3.895

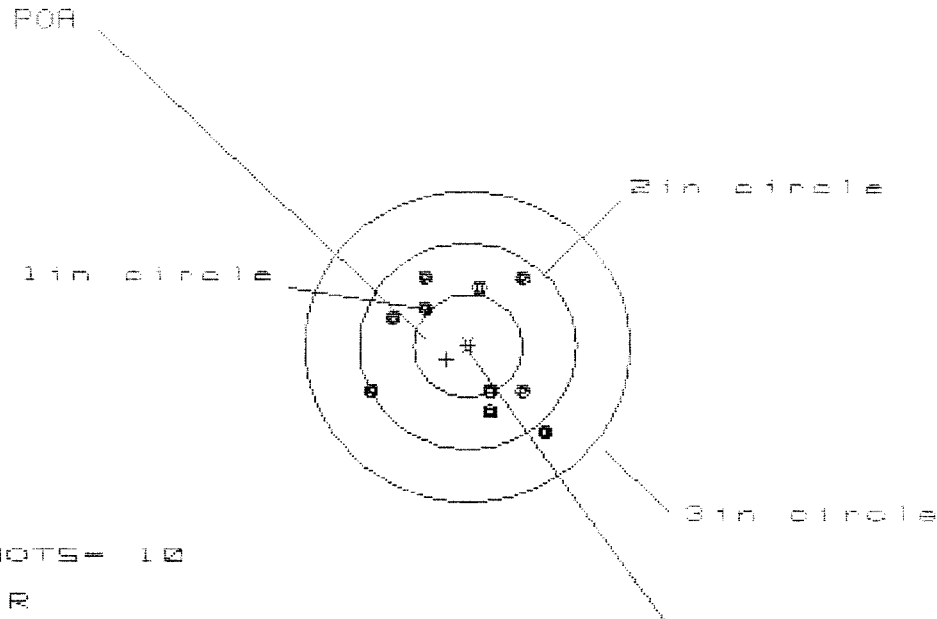
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.831
MINIMUM X	-1.812
MAXIMUM Y	1.093
MINIMUM Y	-1.382
CENTROID X	.195
CENTROID Y	-.091
POA TO CENTROID in.	.215
MIN RADIUS	.346
MEAN RADIUS	1.084
MAX RADIUS	2.294
HORIZONTAL SPREAD	3.643
VERTICAL SPREAD	2.475
EXTREME SPREAD	3.895
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

6 Jun 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.616

VS= 1.490

GS= 1.867

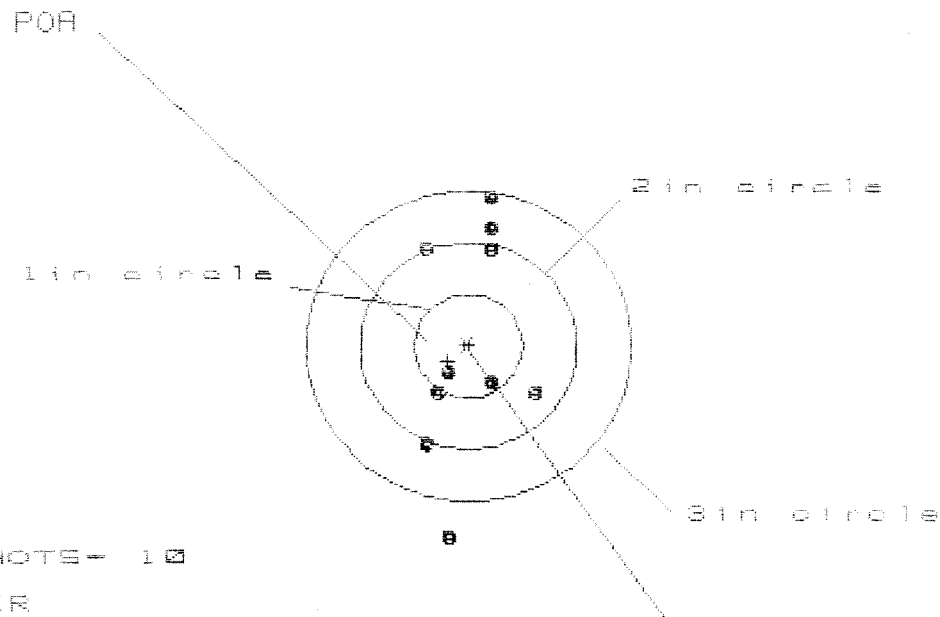
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.756	.639	.542
MINIMUM X	-.860	-.776	-.682
MAXIMUM Y	.683	.593	.533
MINIMUM Y	-.808	-.687	-.747
CENTROID X	.193	.109	.206
CENTROID Y	.130	.219	.279
POA TO CENTROID in.	.233	.245	.347
MIN RADIUS	.452	.439	.429
MEAN RADIUS	.727	.674	.637
MAX RADIUS	1.106	.912	.784
HORIZONTAL SPREAD	1.616	1.415	1.224
VERTICAL SPREAD	1.490	1.280	1.280
EXTREME SPREAD	1.867	1.775	1.413
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

6 Jun 1991

FILE: PATTERNING/CENTERFIRE_PATT/08636178

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 1.094

VS = 3.248

CS = 3.275

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.657	.637	.663
MINIMUM X	-.437	-.457	-.431
MAXIMUM Y	1.429	1.227	1.111
MINIMUM Y	-1.819	-1.156	-.997
CENTROID X	.188	.268	.182
CENTROID Y	.152	.354	.201
POA TO CENTROID in.	.242	.411	.271
MIN RADIUS	.333	.527	.374
MEAN RADIUS	.958	.873	.796
MAX RADIUS	1.829	1.245	1.127
HORIZONTAL SPREAD	1.094	1.094	1.094
VERTICAL SPREAD	3.248	2.377	2.108
EXTREME SPREAD	3.275	2.463	2.191
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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

SERIAL NO. C6636178
DATE 6-4-91
TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.65	2.48	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.65	2.50	2.39	
PULL #3	2.47	2.69	2.53	2.50	
PULL #4	2.50	2.22	2.55	2.51	
PULL #5	2.56	2.51	2.50	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.40		
PULL #2	3.65	3.46		
PULL #3	3.37	3.42		
PULL #4	3.48	3.52		
PULL #5	3.69	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.27		4.34
PULL #2	4.32	4.36		4.13
PULL #3	4.34	4.30		4.21
PULL #4	4.35	4.36		4.38
PULL #5	4.33	4.18		4.43
TOTAL				
AVG.				