

C6348804

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.

01

SERIAL NO.
C6348804

ORDER NO.
5716



5716 C6348804

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348804

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7 21 89	RW
600	Proof		7 21 89	RW
607	Check Headspace		7 21 89	RW
610	Dis-assemble Gun		7 21 89	RW
612	Magnaflux Barrel Action		7/25/89	KR
	Magnaflux Bolt		7/25/89	KR
615	Rollmark Caliber		7/25/89	JS
7	Drill and Tap Sight Holes		7/27/89	WC
618	Polish Barrel RB		7/31/89	WC
620	Apply Coatings (Barrel Action)		7/27/89	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/7/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/7/89	RW
	C) Inspect Ejector Hole for Chamfer		8/7/89	RW
	D) Oil Firing Pin Ass'y		8/7/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/11/89	J.U.

op. #	OP NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	5 5 5	8/11/89	JD
	G) Safety Off Force	4 4 4	8/11/89	JD
	H) Trigger Pull Test & Retainability		8/11/89	JD
	I) Firing Pin Indent	.205 .205 .20	8/11/89	JD
	J) Assemble Stock		8/15/89	RW
	K) Assemble Swivel Studs		23 Aug 89	JD
	L) Attach Front and Rear Sight Assemblies		8/15/89	RW
	M) Iron Sight Alignment		8/15/89	RW
	N) Detach Front & Rear Sights & place in numbered container		8/15/89	RW
	O) Attach Scope to Rifle		8/16/89	JD
	P) Detach & Attach Scope 20 Times		8/16/89	JD
640	Gallery Target & Test	71 R 82L	8-21-89	AC
	A) Time		8-21-89	AC
	B) Malfunctions		8-21-89	AC
	C) Pierced Primers		8-21-89	AC
	D) Optical Clarity of Scope		8-21-89	AC
645	Inspect for Live Ammo		8-21-89	AC
655	Final Inspection			
	A) Headspace		23 Aug 89	JD
	B) Trigger Pull	266 207 230 238 234	23 Aug 89	JD
	C) Function		23 Aug 89	JD
660	Pack		19 Sept 89	JD

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348804DATE 7/18/90TESTER ES

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	220	206	219	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	222	209	221	
PULL #3	224	212	214	
PULL #4	244	213	223	
PULL #5	223	219	224	
TOTAL	1133	1059	1101	
AVG.	226.6	211.8	220.2	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	296	301	
PULL #2	303	303	
PULL #3	299	308	
PULL #4	302	299	
PULL #5	301	307	
TOTAL	1501	1518	
AVG.	300.2	303.6	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	395	401		
PULL #2	401	404		
PULL #3	398	404		
PULL #4	398	403		
PULL #5	401	410		
TOTAL	1993	2022		
AVG.	398.6	404.4		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348804
21 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	.26163
1 TO	2	.455281
1 TO	3	.43899
1 TO	4	.355373
1 TO	5	.814946

14 (----POA
3 2
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3396
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .464971
THE AMR FOR THIS RIFLE IS: .9364

7 Aug 1986

FILE:/PATTERNING/CENTERFIRE_PATT/C634B884

CENTERFIRE PATTERNS

1

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS = 2.128

VS = 3.332

GS = 3.377

PATTERN #

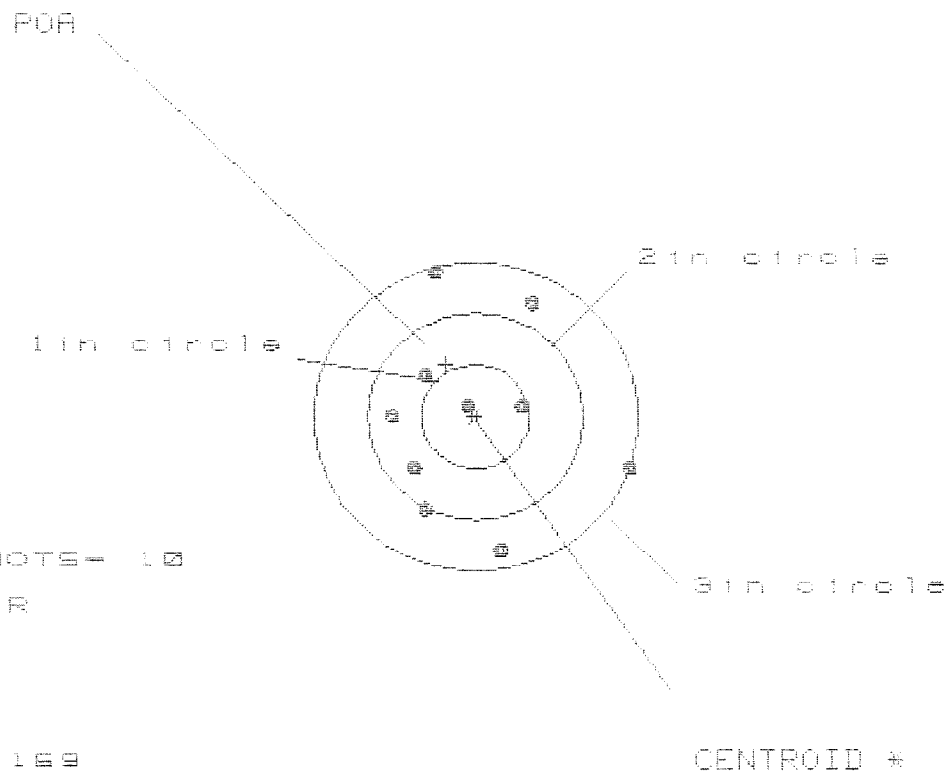
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.164	1.118	.992
MINIMUM X	:	-.964	-1.010	-.665
MAXIMUM Y	:	1.328	1.105	.917
MINIMUM Y	:	-2.004	-1.591	-1.453
CENTROID X	:	.257	.303	.429
CENTROID Y	:	-.049	.174	.036
POR TO CENTROID in.	:	.261	.350	.431
MIN RADIUS	:	.432	.253	.269
MEAN RADIUS	:	1.053	.907	.843
MAX RADIUS	:	2.047	1.618	1.463
HORIZONTAL SPREAD	:	2.128	2.128	1.657
VERTICAL SPREAD	:	3.332	2.696	2.370
EXTREME SPREAD	:	3.377	2.995	2.418
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Aug 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.169

VS= 2.763

GS= 2.837

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.432	.653	.628
MINIMUM X	:	-.737	-.578	-.603
MAXIMUM Y	:	1.427	1.376	1.237
MINIMUM Y	:	-1.336	-1.387	-1.215
CENTROID X	:	.273	.114	.139
CENTROID Y	:	-.504	-.453	-.625
POA TO CENTROID in.	:	.573	.467	.641
MIN RADIUS	:	.104	.144	.248
MEAN RADIUS	:	.925	.841	.776
MAX RADIUS	:	1.504	1.453	1.387
HORIZONTAL SPREAD	:	2.169	1.231	1.231
VERTICAL SPREAD	:	2.763	2.763	2.452
EXTREME SPREAD	:	2.837	2.837	2.462
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Aug 1989

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CENTERFIRE PATTERNS # 3

POB

1in circle

2in circle

3in circle

+ OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 2.230

VS = 1.936

GS = 2.597

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.425	1.127	.642
MINIMUM X	:	-.805	-.647	-.506
MAXIMUM Y	:	.759	.676	.519
MINIMUM Y	:	-1.177	-1.260	-.871
CENTROID X	:	-.069	-.227	-.368
CENTROID Y	:	-.343	-.260	-.183
POB TO CENTROID in.	:	.350	.345	.382
MIN RADIUS	:	.165	.245	.087
MEAN RADIUS	:	.827	.706	.533
MAX RADIUS	:	1.608	1.690	.952
HORIZONTAL SPREAD	:	2.230	1.774	1.148
VERTICAL SPREAD	:	1.936	1.936	1.390
EXTREME SPREAD	:	2.597	2.551	1.592
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.525

VS = 1.593

GS = 2.528

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.403	1.190	1.080
MINIMUM X	-1.122	-.966	-1.075
MAXIMUM Y	.717	.714	.629
MINIMUM Y	-.876	-.879	-.964
CENTROID X	.606	.450	.560
CENTROID Y	.018	.021	.106
POR TO CENTROID in.	.606	.451	.570
MIN RADIUS	.263	.168	.294
MEAN RADIUS	.826	.746	.683
MAX RADIUS	1.403	1.210	1.123
HORIZONTAL SPREAD	2.525	2.156	2.150
VERTICAL SPREAD	1.593	1.593	1.593
EXTREME SPREAD	2.528	2.157	2.157
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348884

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.136

VS= 2.742

GS= 2.756

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.218	1.183	1.186
MINIMUM X	-.918	-.953	-1.030
MAXIMUM Y	1.255	1.090	.848
MINIMUM Y	-1.487	-1.194	-1.058
CENTROID X	.521	.556	.633
CENTROID Y	-.820	-.655	-.791
POA TO CENTROID in.	.971	.859	1.013
MIN RADIUS	.402	.446	.329
MEAN RADIUS	1.051	.977	.935
MAX RADIUS	1.519	1.309	1.235
HORIZONTAL SPREAD	2.136	2.136	2.136
VERTICAL SPREAD	2.742	2.284	1.986
EXTREME SPREAD	2.756	2.547	2.404
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

