

C5649100

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

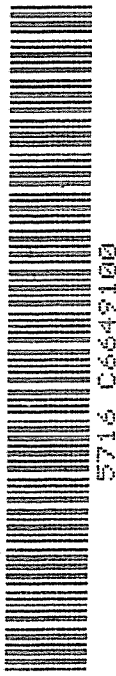
MODEL 700TM M24

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

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

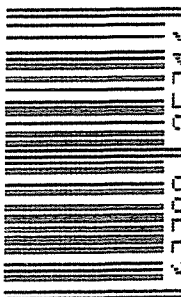
SERIAL NO.
 C6649100

ORDER NO.
 5716



5716 C6649100

LPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649100**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	KB
618	Polish Barrel		JUL 20 1991	CB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)		8-7-91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	KA
	C) Inspect Ejector Hole for Chamfer		8/27/91	KA
	D) Oil Firing Pin Ass'y		8/27/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	KA

op. #	UP. NAME BARBER, M24 0064825	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/28/91	JK
	G) Safety Off Force	3	3	3			8/28/91	JK
	H) Trigger Pull Test & Retainability						8/28/91	JK
	I) Firing Pin Indent	.0215	.0215	.0215			8/28/91	JK
	J) Assemble Stock						8/28/91	JK
	K) Assemble Swivel Studs						9-13-91	AC
	L) Attach Front and Rear Sight Assemblies						8/28/91	JK
	M) Iron Sight Alignment						8/28/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	JK
	O) Attach Scope to Rifle						8/28/91	JK
	P) Detach & Attach Scope 20 Times						8/28/91	JK
640	Gallery Target & Test						8-27-91	AC
	A) Time						8-29-91	AC
	B) Malfunctions						8-29-91	AC
	C) Pierced Primers						8-29-91	AC
	D) Optical Clarity of Scope						8-29-91	AC
645	Inspect for Live Ammo						8-29-91	AC
655	Final Inspection							
	A) Headspace						9-13-91	AC
	B) Trigger Pull	2.63	2.60	2.65	2.69	2.62	9/13/91	JK
	C) Function						9-13-91	AC
660	Pack						9-19-91	VF

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rd Test OK 9-13-91 AC	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 36649100

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
TEST	1st	Shower brass & ejector ejector stick	KS
	2nd	8/29 Repair	KS
	3rd		
	4th		
		FUNCTION	

RD 6654

Rev 1

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649100DATE 8/28/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.31	2.40	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.36	2.38	2.60	
PULL #3	2.44	2.35	2.36	2.65	
PULL #4	2.41	2.39	2.42	2.69	
PULL #5	2.44	2.43	2.44	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.51		
PULL #2	3.40	3.49		
PULL #3	3.46	3.47		
PULL #4	3.40	3.49		
PULL #5	3.49	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.48		4.53
PULL #2	4.54	4.59		4.54
PULL #3	4.51	4.49		4.21
PULL #4	4.54	4.43		4.36
PULL #5	4.23	4.52		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649100
29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.214581
1 TO	2	.377895
1 TO	3	.503751
1 TO	4	.104293
1 TO	5	.103005

24³ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1685
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0200
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1700
THE AMR FOR THIS RIFLE IS: .8694

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648100

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.655

VS= 2.212

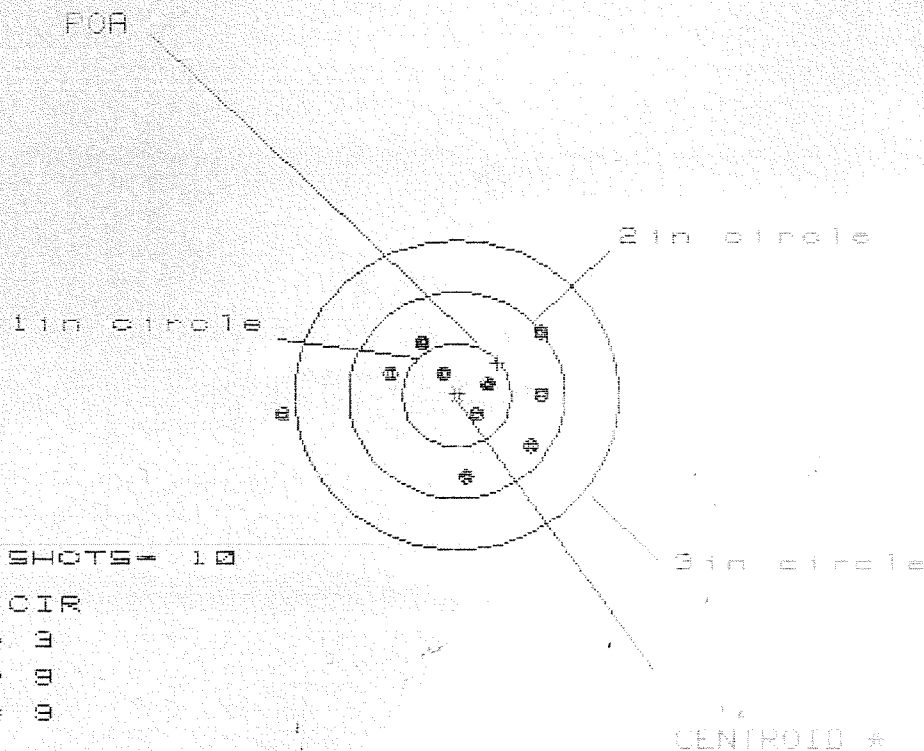
GS= 2.655

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	1.046	.992
MINIMUM X	-1.448	-.473	-.527
MAXIMUM Y	.916	.925	.764
MINIMUM Y	-1.296	-1.267	-.846
CENTROID X	-.213	-.052	.062
CENTROID Y	.026	.017	.178
POA TO CENTROID in.	.215	.055	.178
MIN RADIUS	.200	.310	.268
MEAN RADIUS	.853	.802	.725
MAX RADIUS	1.450	1.359	.997
HORIZONTAL SPREAD	2.655	1.519	1.519
VERTICAL SPREAD	2.212	2.212	1.610
EXTREME SPREAD	2.655	2.424	1.949
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849100

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 9

3 in = 9

HS = 2.404

VS = 1.373

GS = 2.516

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.768	.586	.655
MINIMUM X	:	-1.636	-.790	-.717
MAXIMUM Y	:	.578	.560	.522
MINIMUM Y	:	-.795	-.813	-.743
CENTROID X	:	-.382	-.200	-.273
CENTROID Y	:	-.312	-.294	-.364
POA TO CENTROID in.	:	.493	.355	.455
MIN RADIUS	:	.232	.106	.185
MEAN RADIUS	:	.694	.561	.529
MAX RADIUS	:	1.645	.824	.777
HORIZONTAL SPREAD	:	2.404	1.376	1.372
VERTICAL SPREAD	:	1.373	1.373	1.265
EXTREME SPREAD	:	2.516	1.549	1.434
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6548100

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.437

VS = 2.554

GS = 2.685

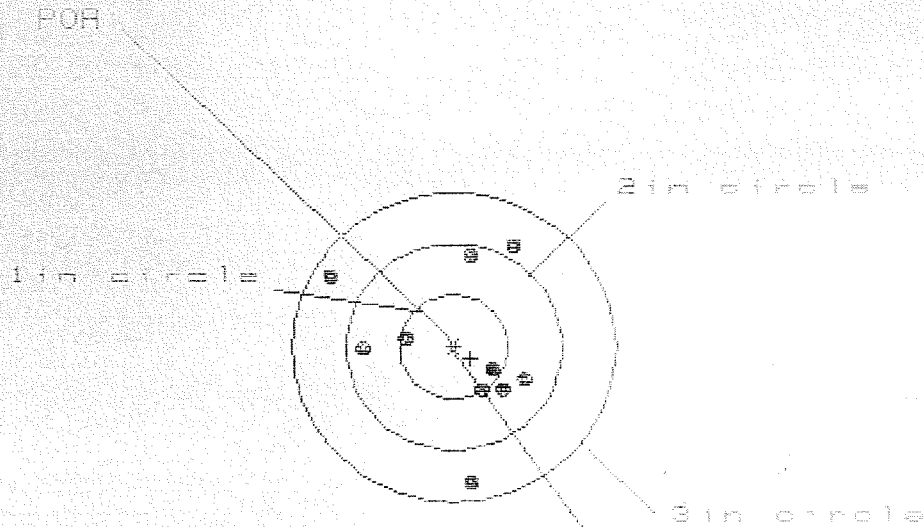
CENTROID *

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.394
MINIMUM X	:	-1.040
MAXIMUM Y	:	1.387
MINIMUM Y	:	-1.167
CENTROID X	:	.201
CENTROID Y	:	.313
POA TO CENTROID in.	:	.372
MIN RADIUS	:	.133
MEAN RADIUS	:	1.029
MAX RADIUS	:	1.596
HORIZONTAL SPREAD	:	2.437
VERTICAL SPREAD	:	2.554
EXTREME SPREAD	:	2.685
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	9

25 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.751

VS = 2.268

GS = 2.388

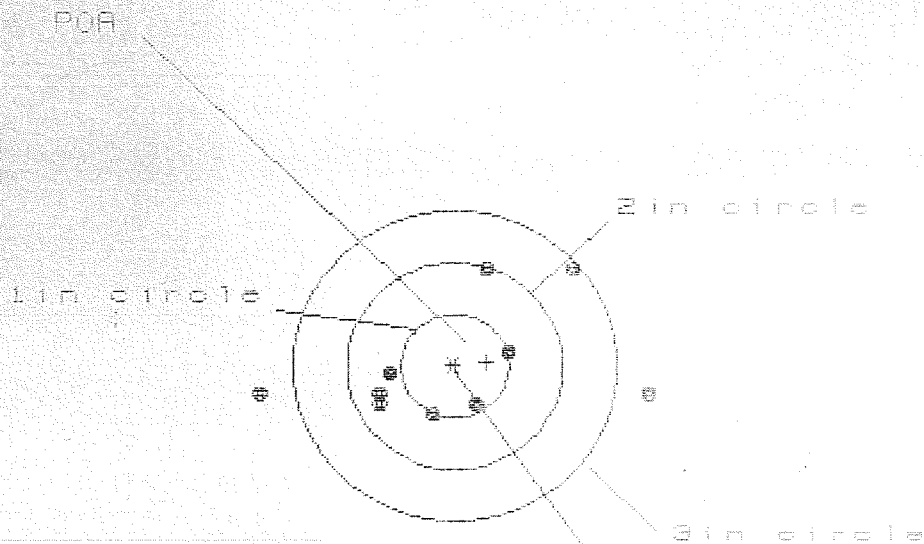
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.614	.488	.489
MINIMUM X	-1.137	-1.013	-1.012
MAXIMUM Y	.986	1.067	.917
MINIMUM Y	-1.282	-1.201	-1.512
CENTROID X	-.154	-.028	-.029
CENTROID Y	.112	.031	.181
POR TO CENTROID in.	.191	.042	.183
MIN RADIUS	.420	.270	.366
MEAN RADIUS	.809	.717	.672
MAX RADIUS	1.351	1.201	1.018
HORIZONTAL SPREAD	1.751	1.501	1.501
VERTICAL SPREAD	2.268	2.268	1.429
EXTREME SPREAD	2.388	2.384	1.756
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

28 AUG 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 3.594

VS= 1.457

GS= 3.594

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.798	1.268	1.069
MINIMUM X	-1.796	-1.596	-.666
MAXIMUM Y	.964	.939	.988
MINIMUM Y	-.493	-.518	-.549
CENTROID X	-.296	-.496	-.296
CENTROID Y	-.035	-.010	.021
POA TO CENTROID in.	.298	.496	.297
MIN RADIUS	.446	.386	.496
MEAN RADIUS	.962	.845	.757
MAX RADIUS	1.812	1.615	1.402
HORIZONTAL SPREAD	3.594	2.864	1.735
VERTICAL SPREAD	1.457	1.457	1.457
EXTREME SPREAD	3.594	3.100	2.202
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		