

C6649136

MODEL 700TM M24

Model **SMS**TM

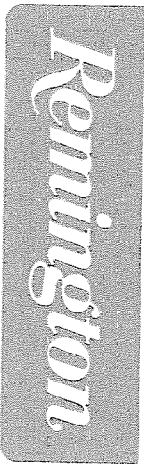
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

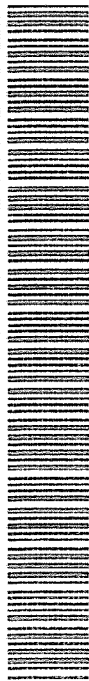
MODEL 700™ M24

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

SERIAL NO.
 C6649136

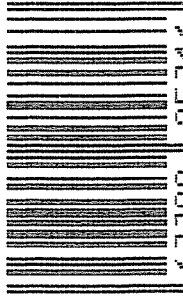
ORDER NO.
 5716

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



5716 C6649136

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649136

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KL
600	Proof		6/26/91	KL
607	Check Headspace		6/26/91	KL
610	Dis-assemble Gun		6/26/91	KL
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	LB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/91	KL
	C) Inspect Ejector Hole for Chamfer		8/13/91	KL
	D) Oil Firing Pin Ass'y		8/13/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/14/91	WB

op. #	BARBER, M24 0065222 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-14-91	DH
	G) Safety Off Force	3 1/2	2	2			8-14-91	DH
	H) Trigger Pull Test & Retainability						8/14/91	WB
	I) Firing Pin Indent	.020	.020	.020			8-14-91	DH
	J) Assemble Stock						8/14/91	KH
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/14/91	KH
	M) Iron Sight Alignment						8/14/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	KH
	O) Attach Scope to Rifle						8/14/91	KH
	P) Detach & Attach Scope 20 Times						8/14/91	KH
640	Gallery Target & Test						8-16-91	DH
	A) Time						8-16-91	DH
	B) Malfunctions						8-16-91	DH
	C) Pierced Primers						8-16-91	DH
	D) Optical Clarity of Scope						8-16-91	DH
645	Inspect for Live Ammo						8-16-91	DH
655	Final Inspection A) Headspace						8-17-91	DH
	B) Trigger Pull	2.48	2.58	2.58	2.59	2.56	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-19-91	VF

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

SERIAL NO. C6649136
DATE 8/14/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.50	2.48	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.42	2.57	2.58	
PULL #3	2.47	2.45	2.54	2.58	
PULL #4	2.44	2.47	2.40	2.59	
PULL #5	2.39	2.52	2.46	2.56	
TOTAL	12.30	12.36	12.45		
AVG.	2.46	2.47	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.30		
PULL #2	3.18	3.28		
PULL #3	3.28	3.29		
PULL #4	3.32	3.24		
PULL #5	3.14	3.23		
TOTAL	16.22	16.34		
AVG.	3.24	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.23		4.21
PULL #2	4.12	4.24		4.15
PULL #3	4.28	4.30		4.18
PULL #4	4.12	4.24		4.28
PULL #5	4.29	4.24		4.30
TOTAL	21.02	21.25		21.12
AVG.	4.20	4.25		4.22

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649136
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.285871
1 TO	2	.178197
1 TO	3	.24286
1 TO	4	.573566
1 TO	5	.522165

5th <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0634
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0649136
THE AMR FOR THIS RIFLE IS: .9552

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06849136

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.405

VS= 1.805

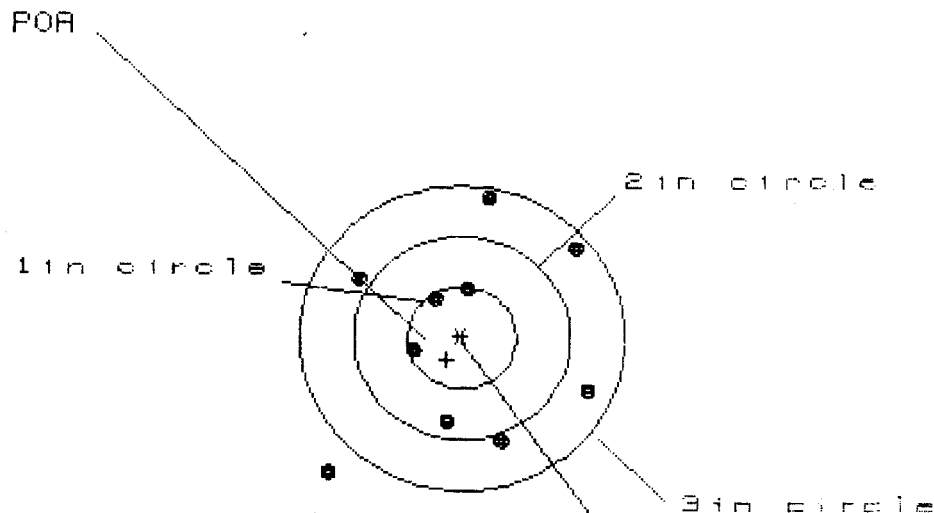
GS= 2.676

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.276	1.150	1.202
MINIMUM X	-1.129	-1.188	-1.044
MAXIMUM Y	.851	.911	.962
MINIMUM Y	-.954	-.860	-.809
CENTROID X	.271	.397	.253
CENTROID Y	.091	-.003	-.054
POA TO CENTROID in.	.286	.397	.259
MIN RADIUS	.046	.149	.102
MEAN RADIUS	.927	.877	.804
MAX RADIUS	1.414	1.269	1.209
HORIZONTAL SPREAD	2.405	2.338	2.246
VERTICAL SPREAD	1.805	1.771	1.771
EXTREME SPREAD	2.676	2.338	2.312
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649136

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 2.344

VS = 2.663

GS = 3.158

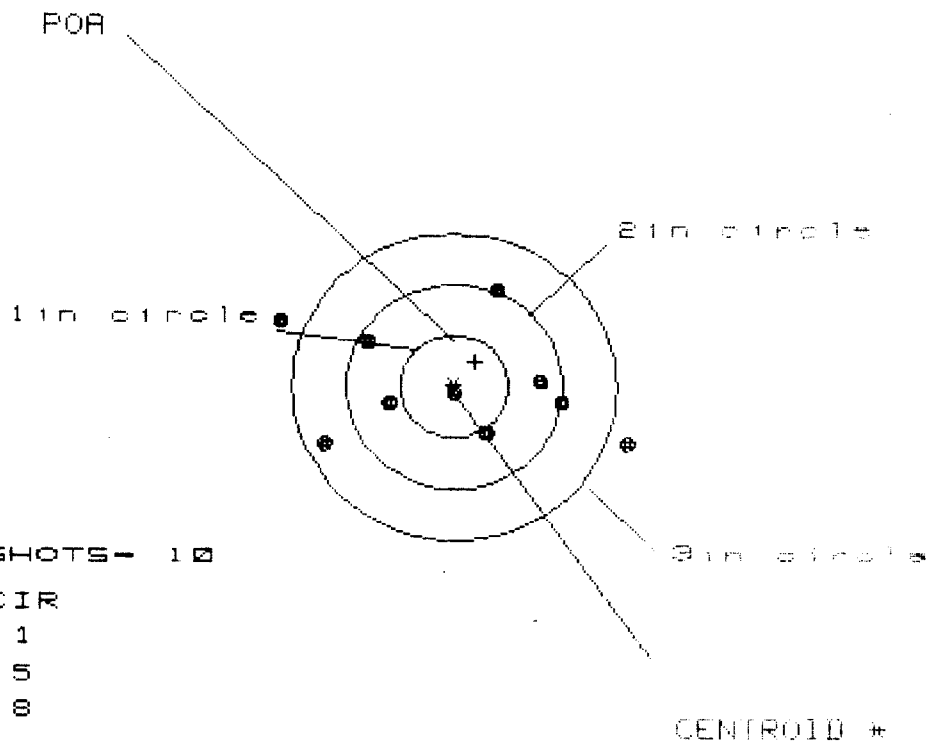
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	1.007	1.126
MINIMUM X	-1.203	-1.043	-.924
MAXIMUM Y	1.371	1.228	1.320
MINIMUM Y	-1.292	-1.125	-1.033
CENTROID X	.144	.278	.159
CENTROID Y	.216	.359	.267
POA TO CENTROID in.	.259	.454	.311
MIN RADIUS	.452	.389	.473
MEAN RADIUS	1.027	.939	.886
MAX RADIUS	1.765	1.234	1.341
HORIZONTAL SPREAD	2.344	2.050	2.050
VERTICAL SPREAD	2.663	2.353	2.353
EXTREME SPREAD	3.158	2.358	2.358
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849136

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.216

VS= 1.552

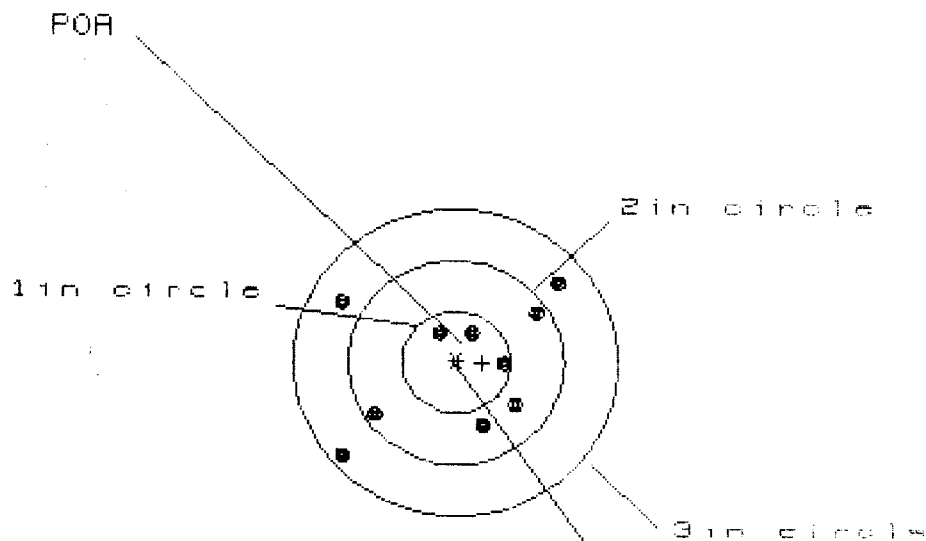
GS= 3.451

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.589	1.409	1.024
MINIMUM X	-1.627	-1.423	-1.247
MAXIMUM Y	.961	1.035	.970
MINIMUM Y	-.591	-.517	-.581
CENTROID X	-.196	-.016	-.192
CENTROID Y	-.242	-.316	-.251
FOR TO CENTROID in.	.312	.316	.316
MIN RADIUS	.112	.146	.102
MEAN RADIUS	.988	.883	.801
MAX RADIUS	1.756	1.514	1.376
HORIZONTAL SPREAD	3.216	2.832	2.271
VERTICAL SPREAD	1.552	1.552	1.551
EXTREME SPREAD	3.451	2.832	2.319
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649136

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 7

3 in - 10

HS - 2.049

VS - 1.639

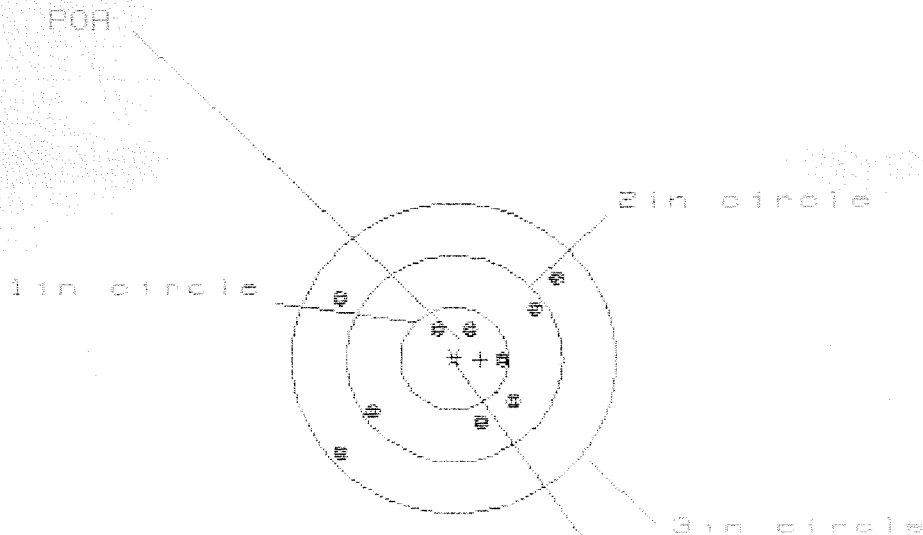
GS - 2.624

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.945	.823	.671
MINIMUM X	-1.104	-1.214	-1.001
MAXIMUM Y	.769	.672	.732
MINIMUM Y	-.870	-.693	-.630
CENTROID X	-.245	-.123	.029
CENTROID Y	.011	.108	.048
POA TO CENTROID in.	.246	.163	.056
MIN RADIUS	.306	.166	.126
MEAN RADIUS	.799	.698	.597
MAX RADIUS	1.405	1.306	1.152
HORIZONTAL SPREAD	2.049	2.037	1.671
VERTICAL SPREAD	1.639	1.365	1.152
EXTREME SPREAD	2.624	2.131	1.671
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.049

VS= 1.639

GS= 2.624

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.945	.823	.671
MINIMUM X	-1.104	-1.214	-1.001
MAXIMUM Y	.769	.672	.732
MINIMUM Y	-.870	-.693	-.633
CENTROID X	-.245	-.123	.029
CENTROID Y	.011	.108	.048
FOR TO CENTROID IN.	.245	.163	.056
MIN RADIUS	.306	.166	.126
MEAN RADIUS	.799	.698	.597
MAX RADIUS	1.405	1.306	1.162
HORIZONTAL SPREAD	2.049	2.037	1.671
VERTICAL SPREAD	1.639	1.365	1.365
EXTREME SPREAD	2.624	2.131	2.131
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		