

C6649145

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

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

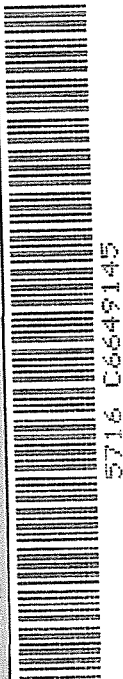
MODEL 700TM M24

SERIAL NO.
C6649145

ORDER NO.
5716

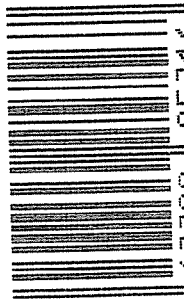
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marquo Deposee.



5716 C6649145

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649/45

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	8 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LS
617	Drill and Tap Sight Holes	JUL	1 1991	EB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/26/91	YU

op. #	BARBER M24 0065321	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 1/2	5			8/26/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/26/91	WB
	H) Trigger Pull Test & Retainability						8/26/91	JV
	I) Firing Pin Indent	.021	.022	.021			8/26/91	WB
	J) Assemble Stock							
	K) Assemble Swivel Studs						8-28-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/28/91	RW
	M) Iron Sight Alignment						8/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	RW
	O) Attach Scope to Rifle						8/28/91	RW
	P) Detach & Attach Scope 20 Times						8/28/91	RW
640	Gallery Target & Test						8-28-91	AC
	A) Time						8-28-91	AC
	B) Malfunctions						8-28-91	AC
	C) Pierced Primers						8-28-91	AC
	D) Optical Clarity of Scope						8-28-91	AC
645	Inspect for Live Ammo						8-28-91	AC
655	Final Inspection						8-28-91	D/H
	A) Headspace							
	B) Trigger Pull	2.59	2.54	2.70	2.71	2.80	8-27-91	D/H
	C) Function						8-28-91	D/H
660	Pack						9-17-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#SERIAL NO. C6649145DATE 8/26/91TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.54	2.49	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.51	2.44	2.54	
PULL #3	2.30	2.54	2.54	2.70	
PULL #4	2.53	2.50	2.56	2.71	
PULL #5	2.54	2.41	2.58	2.80	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.45		
PULL #2	3.30	3.39		
PULL #3	3.27	3.39		
PULL #4	3.30	3.41		
PULL #5	3.33	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.24		4.26
PULL #2	4.23	4.25		4.27
PULL #3	4.34	4.26		4.23
PULL #4	4.31	4.26		4.28
PULL #5	4.22	4.29		4.32
TOTAL	4.24			
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649145
26 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.276139
1 TO	2	.349986
1 TO	3	.304237
1 TO	4	.175
1 TO	5	.322343

POI <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0186
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0972
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0989636
THE RMV FOR THIS RIFLE IS: 1.095

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649145

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.537

VS= 4.133

GS= 4.631

PATTERN # :

1

SHOTS (BEST OF) :

10

9

8

MAXIMUM X :

2.436

1.714

1.673

MINIMUM X :

-1.101

-1.830

-1.871

MAXIMUM Y :

1.810

1.666

1.358

MINIMUM Y :

-2.323

-2.467

-1.189

CENTROID X :

.133

-.138

-.097

CENTROID Y :

-.242

-.098

.210

POA TO CENTROID in.:

.276

.169

.232

MIN RADIUS :

.286

.588

.461

MEAN RADIUS :

1.425

1.238

1.058

MAX RADIUS :

2.757

2.488

1.829

HORIZONTAL SPREAD :

3.537

2.544

2.544

VERTICAL SPREAD :

4.133

4.133

2.547

EXTREME SPREAD :

4.631

4.153

2.975

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

6

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649145

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.896

VS= 2.071

GS= 2.956

CENTROID +

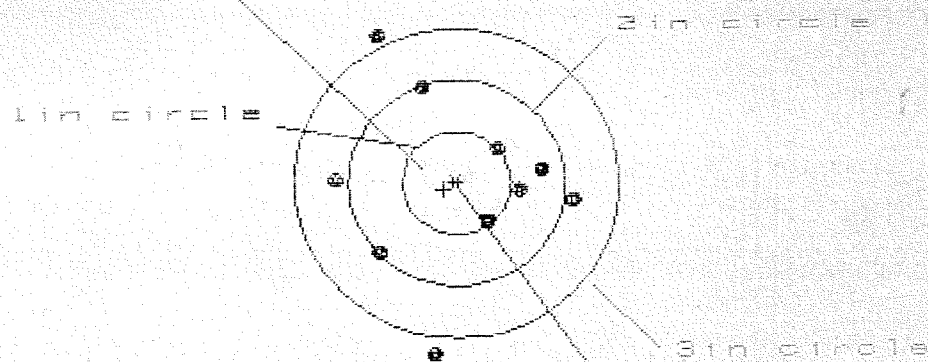
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.946	.730	.805
MINIMUM X	-1.950	-1.096	-1.021
MAXIMUM Y	.778	.749	.583
MINIMUM Y	-1.294	-1.322	-1.573
CENTROID X	-.086	.130	.055
CENTROID Y	.031	.060	.226
POA TO CENTROID in.	.092	.144	.232
MIN RADIUS	.320	.259	.087
MEAN RADIUS	.963	.801	.682
MAX RADIUS	1.967	1.454	1.130
HORIZONTAL SPREAD	2.896	1.826	1.826
VERTICAL SPREAD	2.071	2.071	1.156
EXTREME SPREAD	2.956	2.342	1.954
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8B49145

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.227

VS= 3.023

CS= 3.062

CENTROID #

PATTERN # : 3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.110	1.081	.983
MINIMUM X	-1.117	-1.146	-1.244
MAXIMUM Y	1.405	1.225	.877
MINIMUM Y	-1.618	-.864	-.711
CENTROID X	.121	.150	.248
CENTROID Y	.062	.242	.089
POA TO CENTROID in.	.136	.285	.264
MIN RADIUS	.440	.398	.392
MEAN RADIUS	.983	.898	.791
MAX RADIUS	1.640	1.454	1.244
HORIZONTAL SPREAD	2.227	2.227	2.227
VERTICAL SPREAD	3.023	2.089	1.588
EXTREME SPREAD	3.062	2.434	2.234
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

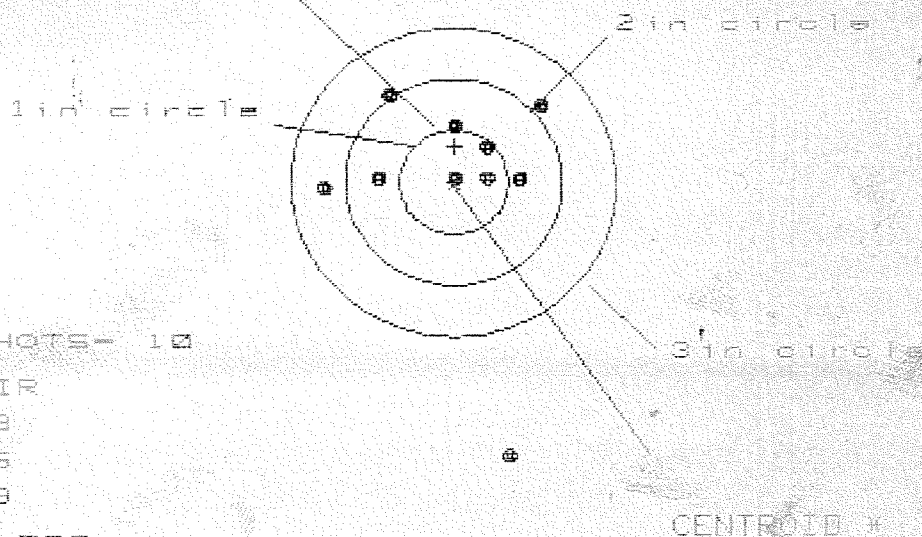
26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649145

CENTERFIRE PATTERNS

4

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.027

VS= 3.512

GS= 3.672

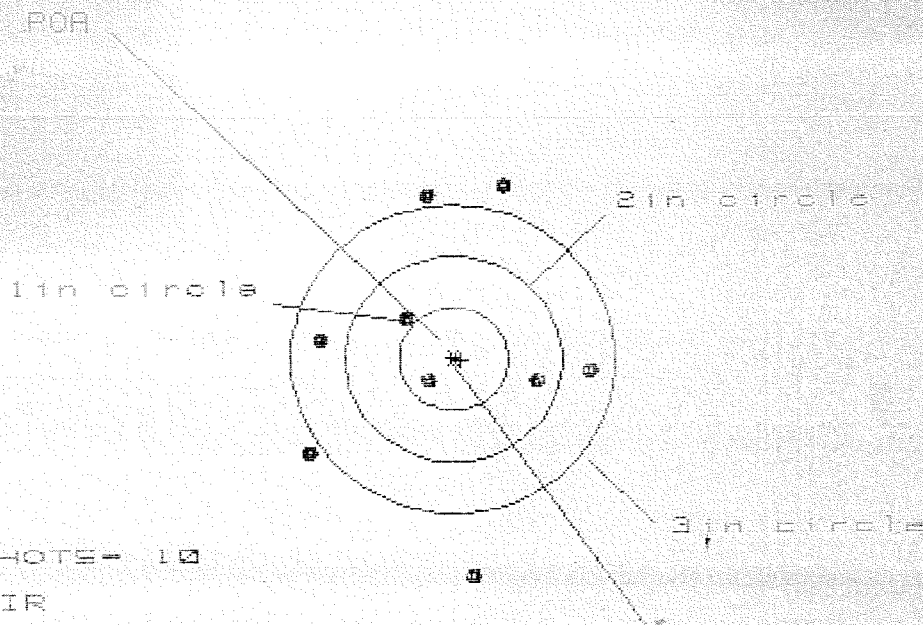
CENTROID *

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.792	.849	.701
MINIMUM X	-1.235	-1.178	-.925
MAXIMUM Y	.943	.546	.504
MINIMUM Y	-2.669	-.336	-.335
CENTROID X	-.007	-.064	.084
CENTROID Y	-.347	-.050	-.003
FOR TO CENTROID in.	.347	.081	.084
MIN RADIUS	.031	.269	.222
MEAN RADIUS	.878	.635	.530
MAX RADIUS	2.718	1.225	.865
HORIZONTAL SPREAD	2.027	2.027	1.526
VERTICAL SPREAD	3.512	.882	.839
EXTREME SPREAD	3.672	2.169	1.660
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.550

VS= 3.776

GS= 3.790

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.258
MINIMUM X	-1.292
MAXIMUM Y	1.648
MINIMUM Y	-2.128
CENTROID X	-.068
CENTROID Y	.010
POA TO CENTROID IN.	.068
MIN RADIUS	.300
MEAN RADIUS	1.194
MAX RADIUS	2.134
HORIZONTAL SPREAD	2.550
VERTICAL SPREAD	3.776
EXTREME SPREAD	3.790
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	5