

C6649146

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

Remington



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

MODEL 700TM M24

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

SERIAL NO.
C6649146

ORDER NO.
5716



5716 C6649146



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649146

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	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		6-27-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KL
	C) Inspect Ejector Hole for Chamfer		8/22/91	KL
	D) Oil Firing Pin Ass'y		8/22/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5	5			8-23-91	DH
	G) Safety Off Force	3 1/2	3	3			8-23-91	DH
	H) Trigger Pull Test & Retainability						8/23/91	JS
	I) Firing Pin Indent	.022	.023	.022			8-23-91	DH
	J) Assemble Stock						8/27/91	JS
	K) Assemble Swivel Studs						9/13/91	JS
	L) Attach Front and Rear Sight Assemblies						8/27/91	JS
	M) Iron Sight Alignment						8/27/91	JS
	N) Detach Front & Rear Sights & place in numbered container						8/27/91	JS
	O) Attach Scope to Rifle						8/27/91	JS
	P) Detach & Attach Scope 20 Times						8/27/91	JS
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							
	A) Headspace						9/13/91	JS
	B) Trigger Pull	2.50	2.45	2.45	2.45	2.42	8-28-91	DH
	C) Function						9/13/91	JS
660	Pack						9-11-91	JS

MOD. _____ GA. CAL. _____ GUN # 26648146

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
TEST	1st		
		ejector sticks	KS
	2nd		
8/28/91	X	Repaired	KS
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

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

AVERAGE PULL FORCE BETWEEN INITIAL & CYCLE TESTS

$$2.50\# + .50\#$$
$$3.00\overline{\#} + .75\#$$

4.00# + 1.00#

SERIAL NO. C-66 49146

DATE 8/23/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.30	2.38	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.42	2.30	2.45	
PULL #3	2.30	2.51	2.43	2.45	
PULL #4	2.44	2.45	2.38	2.45	
PULL #5	2.45	2.54	2.45	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.57		
PULL #2	3.26	3.55		
PULL #3	3.19	3.47		
PULL #4	3.16	3.38		
PULL #5	3.54	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.37		4.18
PULL #2	4.15	4.20		4.31
PULL #3	4.36	4.29		4.34
PULL #4	4.35	4.49		4.34
PULL #5	4.35	4.34		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6649146
 28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.255327
1 TO	2	.626288
1 TO	3	.433748
1 TO	4	.596662
1 TO	5	.497122

$\frac{1}{4}$ ← --- POA

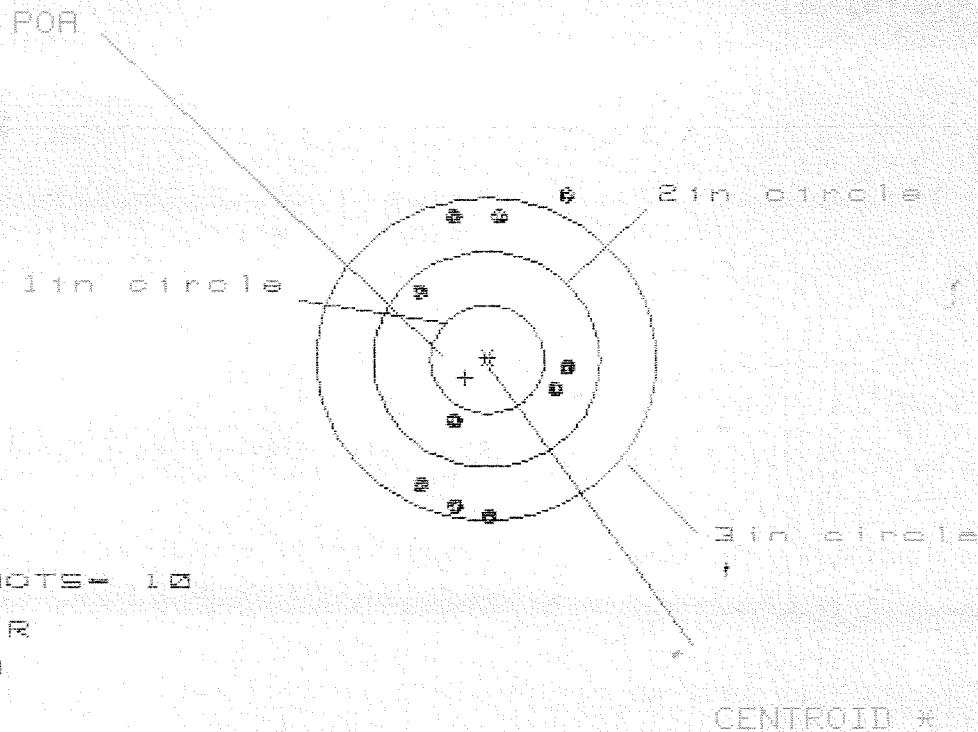
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.169
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .004
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169047

THE AMR FOR THIS RIFLE IS: .8838

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649146

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 1.259

VS = 3.009

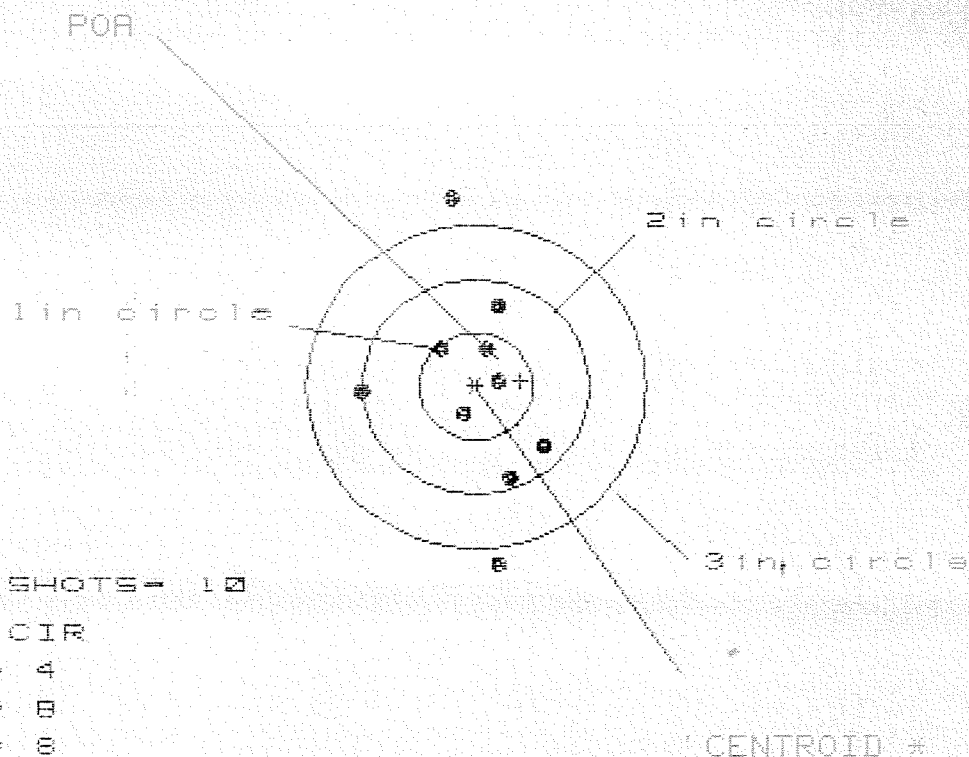
GS = 3.093

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.700	.755	.763
MINIMUM X	-.569	-.491	-.483
MAXIMUM Y	1.545	1.535	1.373
MINIMUM Y	-1.464	-1.292	-1.338
CENTROID X	.194	.116	.108
CENTROID Y	.166	-.006	.156
POA TO CENTROID in.	.255	.116	.189
MIN RADIUS	.621	.432	.579
MEAN RADIUS	1.136	1.051	1.027
MAX RADIUS	1.696	1.544	1.385
HORIZONTAL SPREAD	1.269	1.246	1.246
VERTICAL SPREAD	3.009	2.827	2.711
EXTREME SPREAD	3.093	2.829	2.738
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649146

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS = 1.589

VS = 3.395

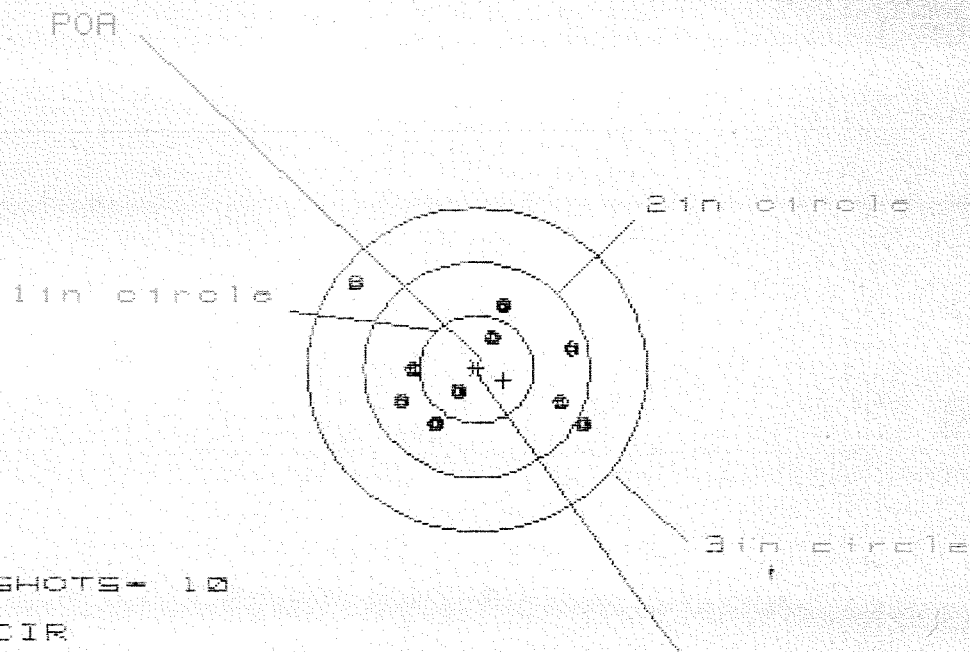
GS = 3.422

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.603
MINIMUM X	-.986
MAXIMUM Y	1.714
MINIMUM Y	-1.681
CENTROID X	-.392
CENTROID Y	-.055
POA TO CENTROID in.	.396
MIN RADIUS	.239
MEAN RADIUS	.823
MAX RADIUS	1.728
HORIZONTAL SPREAD	1.589
VERTICAL SPREAD	3.395
EXTREME SPREAD	3.422
NUMBER IN ONE INCH CIRCLE	4
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	8

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649146

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HE = 1.955

VS = 1.340

GS = 2.370

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.771	.791
MINIMUM X	-1.066	-.771	-.675
MAXIMUM Y	.806	.650	.594
MINIMUM Y	-.534	-.444	-.465
CENTROID X	-.235	-.117	-.213
CENTROID Y	.102	.012	.068
POA TO CENTROID in.	.256	.117	.223
MIN RADIUS	.240	.288	.231
MEAN RADIUS	.703	.632	.583
MAX RADIUS	1.337	.889	.817
HORIZONTAL SPREAD	1.955	1.542	1.466
VERTICAL SPREAD	1.340	1.094	1.059
EXTREME SPREAD	2.370	1.554	1.554
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

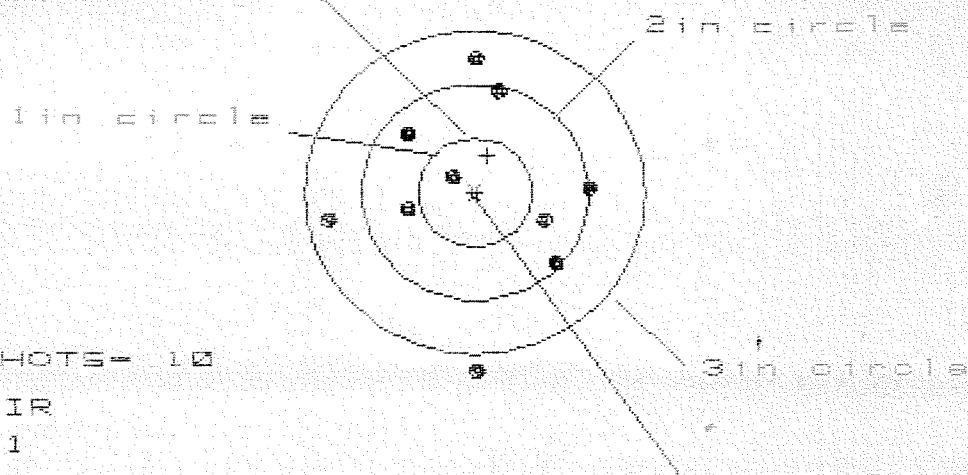
28 Aug 1991

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CENTERFIRE PATTERNS

4

POR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.306

VS = 2.935

GS = 2.935

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.044

1.044

.886

MINIMUM X

:

-1.262

-1.262

-.731

MAXIMUM Y

:

1.248

1.060

1.010

MINIMUM Y

:

-1.687

-.843

-.893

CENTROID X

:

-.109

-.109

.049

CENTROID Y

:

-.348

-.160

-.110

POR TO CENTROID in.

:

.365

.194

.121

MIN RADIUS

:

.221

.158

.323 *

MEAN RADIUS

:

.943

.837

.782

MAX RADIUS

:

1.687

1.324

1.054

HORIZONTAL SPREAD

:

2.306

2.306

1.617

VERTICAL SPREAD

:

2.935

1.903

1.903

EXTREME SPREAD

:

2.935

2.317

2.040

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

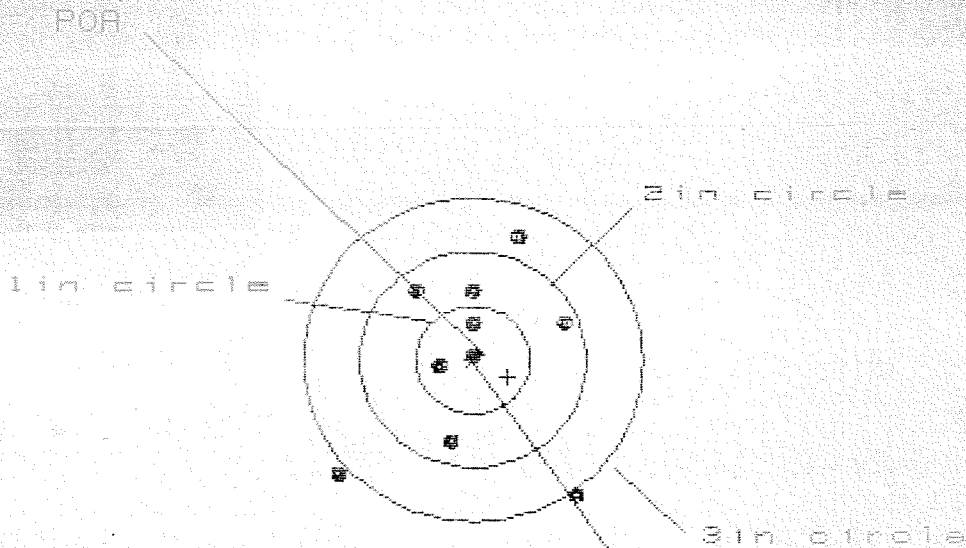
NUMBER IN THREE INCH CIRCLE =

9

20 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649146

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.106

VS= 2.433

GS= 2.712

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.942	.813	.808
MINIMUM X	-1.164	-.579	-.477
MAXIMUM Y	1.182	1.064	.893
MINIMUM Y	-1.251	-1.369	-1.048
CENTROID X	-.303	-.174	-.276
CENTROID Y	.155	.273	.444
POA TO CENTROID in.	.340	.323	.522
MIN RADIUS	.047	.142	.016
MEAN RADIUS	.814	.723	.566
MAX RADIUS	1.576	1.592	1.077
HORIZONTAL SPREAD	2.106	1.392	1.285
VERTICAL SPREAD	2.433	2.433	1.941
EXTREME SPREAD	2.712	2.502	2.026
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		