

C6649168

MODEL 700TM M24

Model **S&S** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington  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. C6649168
ORDER NO. 5716

06



5716 C6649168

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C 6649168

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KH
600	Proof		7/24/91	KH
607	Check Headspace		7/24/91	KH
610	Dis-assemble Gun		7/24/91	KH
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	JS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/9/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/9/91	KH
	C) Inspect Ejector Hole for Chamfer		9/9/91	KH
	D) Oil Firing Pin Ass'y		9/9/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/91	JS

op. #	NAME BARBER M24 0065625	READINGS				DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	9/10/91	SH
	G) Safety Off Force	3	3	3	3	9/10/91	SH
	H) Trigger Pull Test & Retainability					9/10/91	SH
	I) Firing Pin Indent	.021	.021	.021	.021	9/10/91	SH
	J) Assemble Stock					9/11/91	SH
	K) Assemble Swivel Studs					9-13-91	A
	L) Attach Front and Rear Sight Assemblies					9/11/91	SH
	M) Iron Sight Alignment					9/11/91	SH
	N) Detach Front & Rear Sights & place in numbered container					9/11/91	SH
	O) Attach Scope to Rifle					9/11/91	SH
	P) Detach & Attach Scope 20 Times					9/11/91	SH
640	Gallery Target & Test					9-12-91	D/H
	A) Time					9-12-91	D/H
	B) Malfunctions					9-12-91	D/H
	C) Pierced Primers					9-12-91	D/H
	D) Optical Clarity of Scope					9-12-91	D/H
645	Inspect for Live Ammo					9-12-91	D/H
655	Final Inspection						
	A) Headspace					9-13-91	A
	B) Trigger Pull	235	238	233	234	235	9-12-91
	C) Function					9-13-91	A
660	Pack					9-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649/68

DATE 9-10-91

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.46	2.50	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.44	2.48	2.38	
PULL #3	2.41	2.40	2.45	2.33	
PULL #4	2.20	2.45	2.40	2.34	
PULL #5	2.47	2.42	2.40	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.48		
PULL #2	3.22	3.34		
PULL #3	3.25	3.26		
PULL #4	3.22	3.42		
PULL #5	3.23	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.30		4.43
PULL #2	4.44	4.37		4.41
PULL #3	4.41	4.29		4.44
PULL #4	4.45	4.47		4.48
PULL #5	4.31	4.29		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06649168
 12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.204924
1 TO	2	.580253
1 TO	3	.407483
1 TO	4	.336376
1 TO	5	.492325

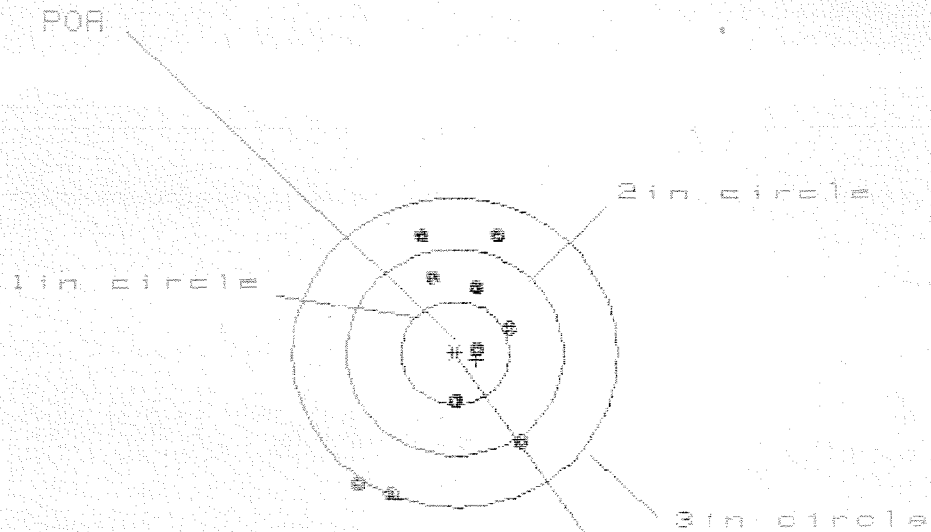
8 4₂ <----PDR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1304
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.163
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .208742
 THE AMP FOR THIS RIFLE IS: .9716

12 Sep 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6649168

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.499

VS= 2.572

GS= 2.767

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.523	.471	.388
MINIMUM X	-.926	-.663	-.495
MAXIMUM Y	1.170	1.025	.832
MINIMUM Y	-1.402	-1.547	-1.154
CENTROID X	-.195	-.093	-.010
CENTROID Y	.063	.208	.401
POA TO CENTROID in.	.205	.227	.401
MIN RADIUS	.214	.119	.262
MEAN RADIUS	.920	.801	.658
MAX RADIUS	1.594	1.683	1.217
HORIZONTAL SPREAD	1.499	1.134	.883
VERTICAL SPREAD	2.572	2.572	1.986
EXTREME SPREAD	2.767	2.703	2.173
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	8	8	8

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649168

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 2.148

VS= 3.047

GS= 3.144

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.134	1.159	1.036
MINIMUM X	-1.014	-0.989	-1.112
MAXIMUM Y	.999	.772	.530
MINIMUM Y	-2.048	-1.929	-1.623
CENTROID X	.293	.268	.391
CENTROID Y	-.251	-.024	.217
POA TO CENTROID in.	.386	.269	.447
MIN RADIUS	.570	.405	.135
MEAN RADIUS	1.120	.956	.728
MAX RADIUS	2.060	2.166	1.137
HORIZONTAL SPREAD	2.148	2.148	2.148
VERTICAL SPREAD	3.047	2.701	1.153
EXTREME SPREAD	3.144	3.144	2.154
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649168

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 1.401

VS= 2.897

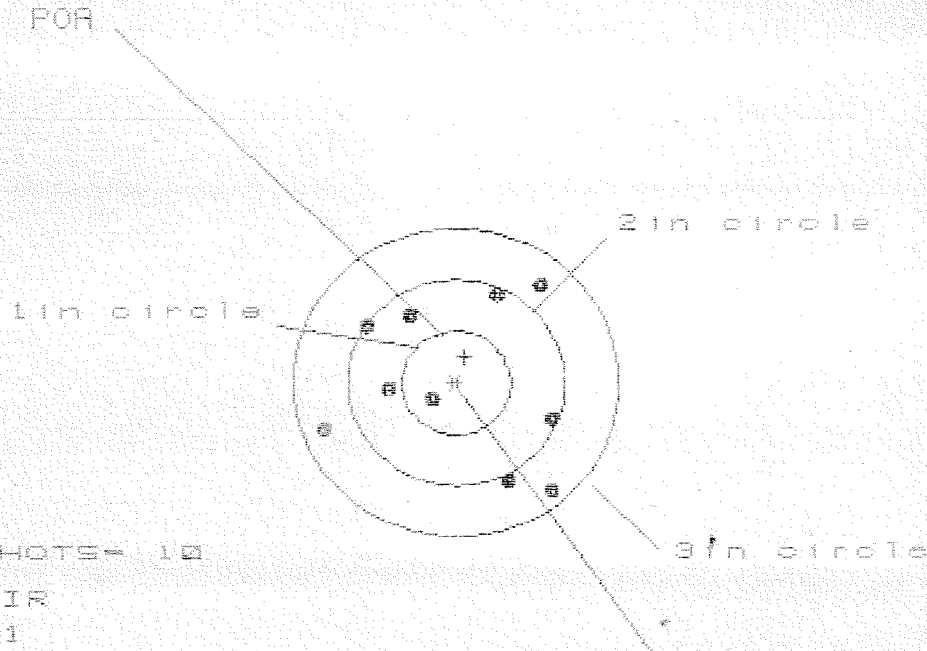
GS= 2.902

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.641
MINIMUM X	-.760
MAXIMUM Y	1.277
MINIMUM Y	-1.620
CENTROID X	-.006
CENTROID Y	-.298
POA TO CENTROID in.	.298
MIN RADIUS	.390
MEAN RADIUS	1.033
MAX RADIUS	1.625
HORIZONTAL SPREAD	1.401
VERTICAL SPREAD	2.897
EXTREME SPREAD	2.902
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	9

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649168

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.129

VS= 1.974

GS= 2.478

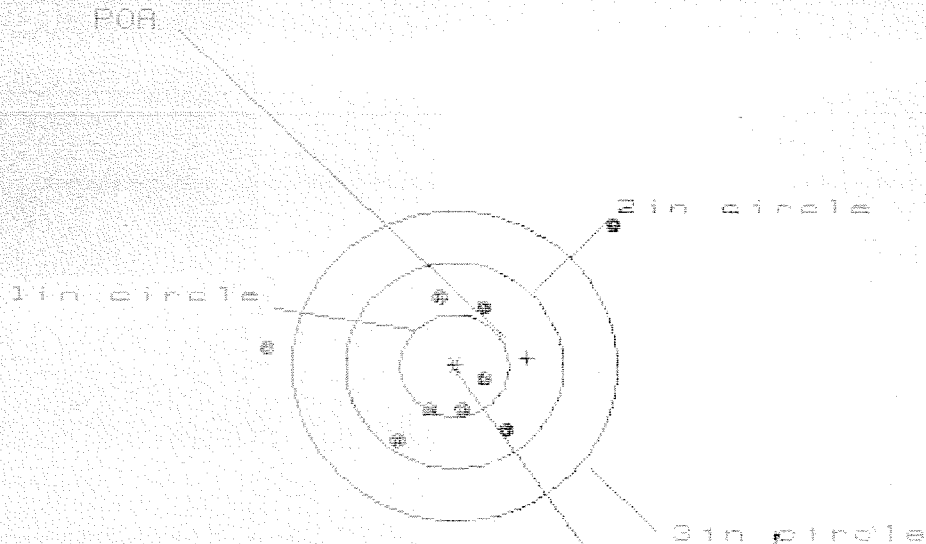
CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.986
MINIMUM X	-1.223
MAXIMUM Y	.947
MINIMUM Y	-1.027
CENTROID X	-.077
CENTROID Y	-.252
POA TO CENTROID in.	.263
MIN RADIUS	.295
MEAN RADIUS	.951
MAX RADIUS	1.326
HORIZONTAL SPREAD	2.129
VERTICAL SPREAD	1.974
EXTREME SPREAD	2.478
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10

12 Sep 1991

FILE:\PATTERNING\CENTERFIRE_PATT\08649168

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS = 3.272

VS = 2.046

GS = 3.498

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.516	.666	.468
MINIMUM X	-1.756	-1.587	-.563
MAXIMUM Y	1.366	.791	.826
MINIMUM Y	-.680	-.529	-.434
CENTROID X	-.667	-.836	-.638
CENTROID Y	-.077	-.228	-.263
POA TO CENTROID in.	.672	.867	.690
MIN RADIUS	.280	.247	.196
MEAN RADIUS	.834	.676	.585
MAX RADIUS	2.041	1.612	.842
HORIZONTAL SPREAD	3.272	2.253	1.631
VERTICAL SPREAD	2.046	1.320	1.320
EXTREME SPREAD	3.498	2.382	1.479
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	