

06649219

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5715

* Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

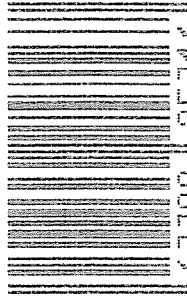
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6649219

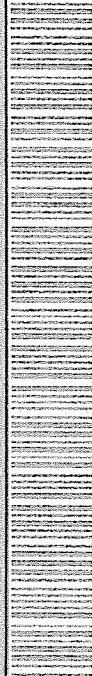
ORDER NO.
5716

20

LPC



0 47700 25716 7



5716 C6649219

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649219

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	dw
600	Proof	6 27	9 1	dw
607	Check Headspace	6 27	9 1	dw
610	Dis-assemble Gun	6 27	9 1	BW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GL
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-29-91	JH

op. #	BARBER - M24 0066592					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	6	6	4		7-29-91	YH
	G) Safety Off Force	5	5	5		7-29-91	YH
	H) Trigger Pull Test & Retainability					7-29-91	YH
	I) Firing Pin Indent	.021	.022	.021		7-29-91	YH
	J) Assemble Stock					8/5/91	RW
	K) Assemble Swivel Studs					8-6-91	AC
	L) Attach Front and Rear Sight Assemblies					8/5/91	RW
	M) Iron Sight Alignment					8/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container					8/5/91	RW
	O) Attach Scope to Rifle					8/5/91	RW
	P) Detach & Attach Scope 20 Times					8/5/91	RW
640	Gallery Target & Test					8/5/91	KT
	A) Time						KT
	B) Malfunctions						KT
	C) Pierced Primers						KT
	D) Optical Clarity of Scope						KT
645	Inspect for Live Ammo					8/5/91	KT
655	Final Inspection						
	A) Headspace					8-6-91	AC
	B) Trigger Pull	2.15	2.18	2.18	2.28	2.27	8-6-91
	C) Function					8-6-91	AC
660	Pack					7/7/91	DH

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

SERIAL NO. C6649219
DATE 7-29-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.31	2.23	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.24	2.34	2.18	
PULL #3	2.25	2.24	2.44	2.18	
PULL #4	2.22	2.50	2.53	2.28	
PULL #5	2.28	2.27	2.50	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.48		
PULL #2	3.50	3.54		
PULL #3	3.53	3.58		
PULL #4	3.51	3.50		
PULL #5	3.44	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.53		4.58
PULL #2	4.50	4.50		4.45
PULL #3	4.50	4.50		4.53
PULL #4	4.47	4.55		4.58
PULL #5	4.43	4.54		4.60
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649219
5 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.172679
1 TO	2	.195502
1 TO	3	.318944
1 TO	4	.191846
1 TO	5	.369096

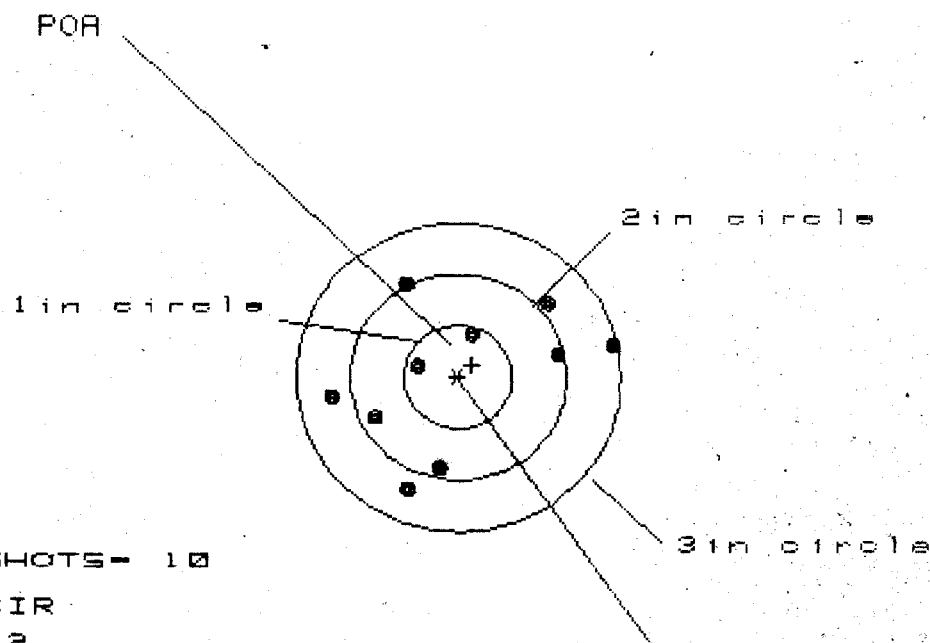
5.12 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0994
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116312
THE AMR FOR THIS RIFLE IS: 1.041

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649219

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.664

VS = 1.962

GS = 2.710

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.455	1.131	1.000
MINIMUM X	-1.209	-1.048	-.723
MAXIMUM Y	.874	.904	.880
MINIMUM Y	-1.088	-1.058	-1.082
CENTROID X	-.127	-.288	-.157
CENTROID Y	-.117	-.147	-.123
POA TO CENTROID in.	.172	.324	.200
MIN RADIUS	.373	.238	.345
MEAN RADIUS	.956	.875	.854
MAX RADIUS	1.480	1.298	1.181
HORIZONTAL SPREAD	2.664	2.179	1.723
VERTICAL SPREAD	1.962	1.962	1.962
EXTREME SPREAD	2.710	2.299	2.299
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649219

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS = 2.424

VS = 3.528

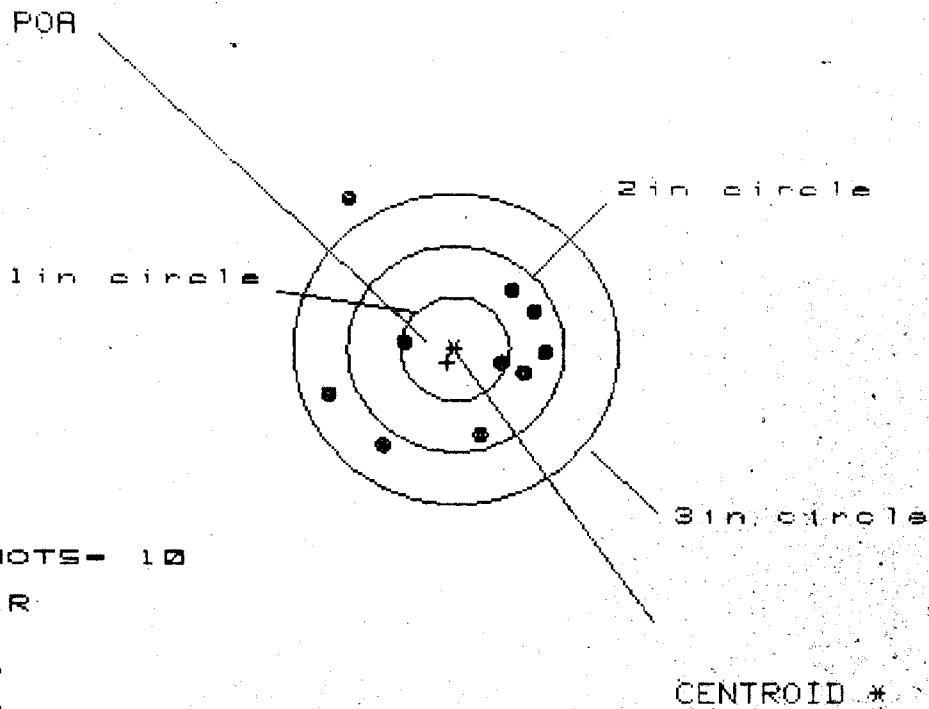
GS = 3.531

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	1.155	1.057
MINIMUM X	:	-1.176	-1.269	-1.367
MAXIMUM Y	:	1.194	.934	.867
MINIMUM Y	:	-2.334	-1.161	-1.044
CENTROID X	:	.068	.161	.259
CENTROID Y	:	-.103	.157	.040
POA TO CENTROID in.	:	.123	.225	.262
MIN RADIUS	:	.767	.784	.700
MEAN RADIUS	:	1.210	1.035	.997
MAX RADIUS	:	2.481	1.270	1.377
HORIZONTAL SPREAD	:	2.424	2.424	2.424
VERTICAL SPREAD	:	3.528	2.095	1.911
EXTREME SPREAD	:	3.531	2.426	2.426
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.041

VS= 2.383

GS= 2.609

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.719	.553
MINIMUM X	:	-1.210	-1.322	-.982
MAXIMUM Y	:	1.486	.728	.701
MINIMUM Y	:	-.897	-.732	-.759
CENTROID X	:	.076	.188	.354
CENTROID Y	:	.129	-.036	-.009
POA TO CENTROID in.	:	.150	.192	.354
MIN RADIUS	:	.467	.342	.175
MEAN RADIUS	:	.915	.781	.660
MAX RADIUS	:	1.799	1.340	1.241
HORIZONTAL SPREAD	:	2.041	2.041	1.535
VERTICAL SPREAD	:	2.383	1.460	1.460
EXTREME SPREAD	:	2.609	2.104	1.934
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Aug 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS = 2.344

VS = 2.440

GS = 2.586

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.190	1.279	1.264
MINIMUM X	:	-1.154	-1.065	-1.080
MAXIMUM Y	:	1.406	1.558	.768
MINIMUM Y	:	-1.034	-.882	-.687
CENTROID X	:	.002	-.087	-.072
CENTROID Y	:	.025	-.127	-.322
POA TO CENTROID in.	:	.025	.154	.330
MIN RADIUS	:	.275	.189	.156
MEAN RADIUS	:	.970	.869	.746
MAX RADIUS	:	1.586	1.563	1.479
HORIZONTAL SPREAD	:	2.344	2.344	2.344
VERTICAL SPREAD	:	2.440	2.440	1.455
EXTREME SPREAD	:	2.586	2.451	2.451
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Aug 1991

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CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.064

VS= 3.355

GS= 4.053

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	.727	.571
MINIMUM X	:	-2.103	-1.253	-1.013
MAXIMUM Y	:	1.199	.959	1.074
MINIMUM Y	:	-2.157	-1.400	-1.285
CENTROID X	:	-.321	-.087	.069
CENTROID Y	:	-.431	-.191	-.305
POR TO CENTROID in.	:	.537	.210	.313
MIN RADIUS	:	.312	.229	.329
MEAN RADIUS	:	1.156	.863	.754
MAX RADIUS	:	3.012	1.552	1.476
HORIZONTAL SPREAD	:	3.064	1.980	1.584
VERTICAL SPREAD	:	3.355	2.359	2.359
EXTREME SPREAD	:	4.053	2.888	2.707
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		