

06649230

MODEL 700TM M24

Model **SMS**

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

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

MODEL 700[™] M24

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

SERIAL NO.
C6649200

ORDER NO.
5716

20

5716 C6649200

UPC
0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649230

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	9 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	JS
617	Drill and Tap Sight Holes	JUL	1 1991	FB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/7/91	JS
	Apply Coating (Bolt)		8/7/91	JS
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	JS

op. #	BARBER M24 0066722	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			9/4/91	JK
	G) Safety Off Force	3	3	3			9/4/91	JK
	H) Trigger Pull Test & Retainability						9/4/91	JK
	I) Firing Pin Indent	.020	.0205	.0205			9/4/91	JK
	J) Assemble Stock						9/4/91	RW
	K) Assemble Swivel Studs						9-9-91	AF
	L) Attach Front and Rear Sight Assemblies						9/4/91	RW
	M) Iron Sight Alignment						9/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	RW
	O) Attach Scope to Rifle						9/4/91	RW
	P) Detach & Attach Scope 20 Times						9/4/91	RW
640	Gallery Target & Test						9-4-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-4-91	AF
655	Final Inspection							
	A) Headspace						9-9-91	AC
	B) Trigger Pull	2.59	2.43	2.28	2.35	2.33	9-6-91	JK
	C) Function						9-9-91	AC
660	Pack						9-10-91	AF

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

SERIAL NO. C-6649230DATE 9-4-91TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.31	2.28	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.36	2.38	2.43	
PULL #3	2.38	2.35	2.36	2.28	
PULL #4	2.66	2.39	2.25	2.35	
PULL #5	2.59	2.36	2.28	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.50		
PULL #2	3.49	3.55		
PULL #3	3.40	3.48		
PULL #4	3.45	3.45		
PULL #5	3.59	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.46		4.28
PULL #2	4.51	4.24		4.43
PULL #3	4.59	4.36		4.31
PULL #4	4.39	4.36		4.41
PULL #5	4.59	4.20		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649230
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.154302
1 TO 2	.223464
1 TO 3	.0814985
1 TO 4	.365816
1 TO 5	.255

1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0414
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.026
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0488872
THE RPR FOR THIS RIFLE IS: .8278

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649280

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

IS= 2.260

VS= 3.181

GS= 3.382

PATTERN #	1	2	3
14015 BEST OF	10	9	8
14015 X	1.256	1.316	1.246
14015 Y	-1.004	-.944	-1.014
14015 Z	1.572	1.393	.949
14015 W	-1.609	-.888	-.714
14015 V	.120	.060	.130
14015 U	-.097	.082	-.092
14015 T	.154	.102	.159
14015 S	.126	.140	.117
14015 R	1.069	.990	.913
14015 Q	1.696	1.499	1.313
14015 P	2.260	2.260	2.260
14015 O	3.181	2.281	1.663
14015 N	3.382	2.724	2.307
14015 M	1	1	1
14015 L	3	3	3
14015 K	8	8	8

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 9

HS= 1.248

VS= 2.352

GS= 2.354

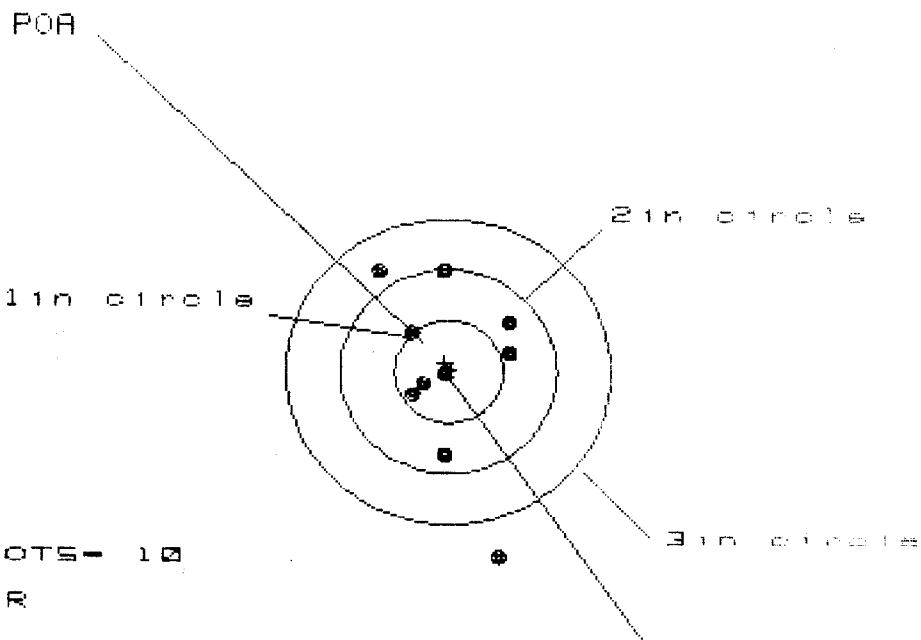
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.543	.533	.444
MINIMUM X	-.705	-.715	-.339
MAXIMUM Y	.773	.597	.633
MINIMUM Y	-1.579	-.620	-.584
CENTROID X	-.036	-.026	.063
CENTROID Y	.063	.239	.203
POA TO CENTROID IN.	.073	.240	.213
1 IN RADIUS	.183	.257	.260
2 IN RADIUS	.632	.520	.487
3 IN RADIUS	1.582	.817	.734
HORIZONTAL SPREAD	1.248	1.248	.783
VERTICAL SPREAD	2.352	1.217	1.217
EXTREME SPREAD	2.354	1.541	1.328
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.221

VS= 2.793

CS= 3.009

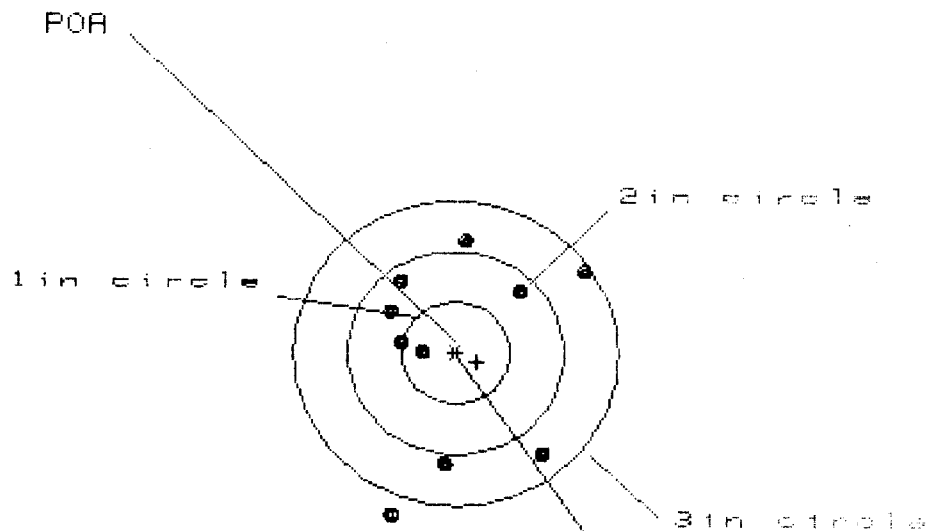
CENTROID #

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM	:	.584	.637	.564
MINIMUM	:	-.637	-.584	-.379
MAXIMUM	:	.974	.772	.856
MINIMUM	:	-1.819	-1.043	-.947
CENTROID X	:	.039	-.014	.059
CENTROID Y	:	-.088	.114	.018
POA TO CENTROID in.	:	.096	.115	.061
1in RADIUS	:	.035	.219	.132
2in RADIUS	:	.738	.609	.551
3in RADIUS	:	1.882	1.043	.949
HORIZONTAL SPREAD	:	1.221	1.221	.943
VERTICAL SPREAD	:	2.793	1.815	1.803
EXTREME SPREAD	:	3.009	1.909	1.804
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Sep 1931

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

IS= 1.8008

VS= 2.707

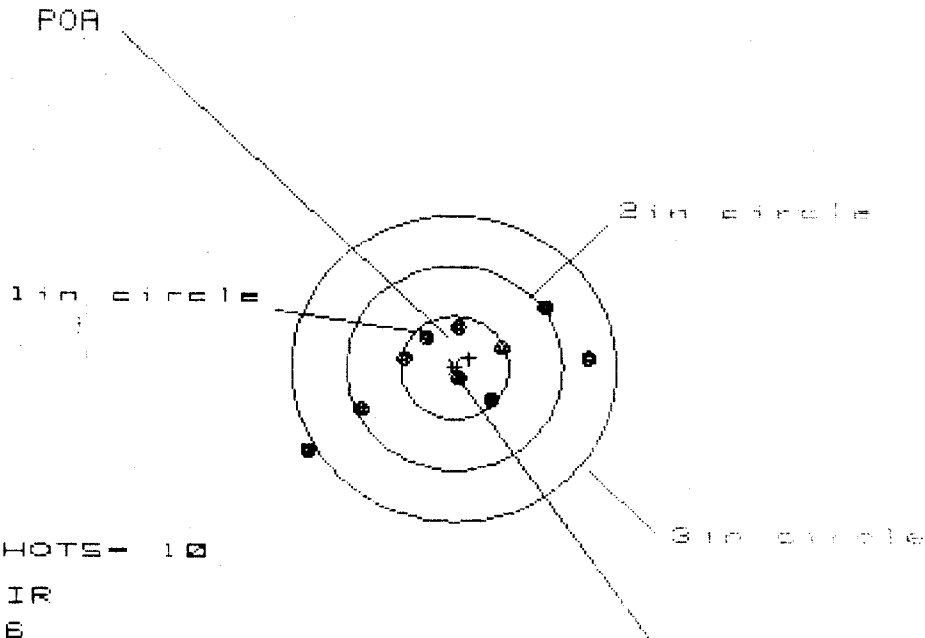
GS= 3.001

PATTERN #	1	2	3
SHOTS LEFT OF	10	9	8
RIGHT OF	1.164	1.093	.863
WINDWARD	-.644	-.655	-.518
DOWNWIND	1.092	.912	.987
WINDWARD	-1.615	-1.296	-1.221
CENTERFIRE	-.195	-.124	-.261
CELESTIAL	.089	.269	.194
CELESTIAL (SUN)	.215	.296	.325
CELESTIAL	.327	.417	.265
CELESTIAL	.986	.883	.807
CELESTIAL	1.739	1.382	1.399
CELESTIAL	1.808	1.748	1.382
CELESTIAL	2.707	2.208	2.208
CELESTIAL	3.001	2.263	2.214
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 6

2 in = 7

3 in = 9

IS= 2.677

VS= 1.375

CS= 2.815

CENTROID

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MEAN	1.275	1.119	.853
STANDARD	-1.402	-1.001	-.861
MEAN	.559	.468	.463
STANDARD	-.816	-.506	-.511
MEAN	-.135	.021	-.119
STANDARD	-.097	-.006	-.001
MEAN	.166	.021	.119
STANDARD	.062	.200	.153
MEAN	.714	.608	.525
STANDARD	1.622	1.121	1.001
MEAN	2.677	2.120	1.714
STANDARD	1.375	.974	.974
MEAN	2.815	2.171	1.971
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		